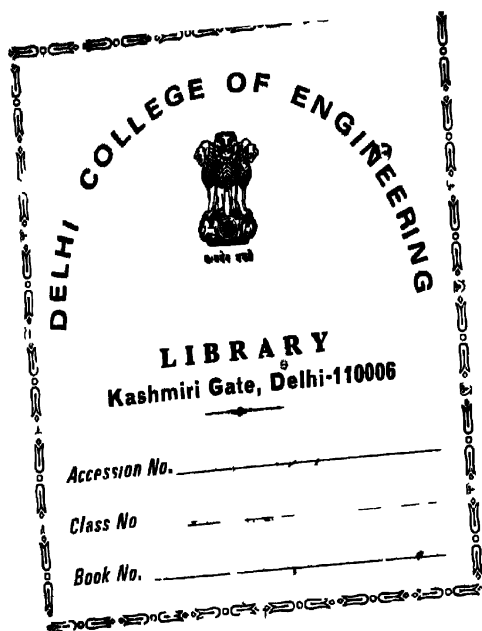




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# **MATERIALS HANDBOOK**



# MATERIALS HANDBOOK

An Encyclopedia for Purchasing Agents  
Engineers, Executives, and Foremen

*by* GEORGE S. BRADY

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## **MATERIALS HANDBOOK**

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## PREFACE TO THE SEVENTH EDITION

The First Edition of "Materials Handbook" was published in 1929. It grew out of the author's need for a quick reference to basic data on all kinds of industrial materials when he was an American Trade Commissioner. It began with an intensive study of the materials of each industry and a card index of comparative data.

Accumulated data were based on the ready-reference information needed in preliminary discussions of purchasing requirements. Later, when the author was managing editor of two industrial trade papers, and then a consulting engineer, the collection and classification of data were extended to cover the primary requirements of industrial executives, designers, architects, and builders of mechanical equipment and plant. Still later, when he was chief materials consultant to the Office of Civilian Supply and to the Board of Economic Warfare, the scope was extended to include in the book the chief materials entering into international trade because of the widened interest in all world materials throughout American industry brought about by the war.

It is not the author's intention to provide an exhaustive treatise on any material, as it is assumed that purchasers and designers will consult producers of the materials for detailed specifications. General information, with the most commonly used comparative figures, is given on materials in their group classifications in order to give a general picture; patented and trade-named materials are then described to give a more specific understanding of commercial applications. The relative position and the length of description of proprietary materials are for purposes of illustration and bear no relation to the relative merits of the products of any one producer. Some processed industrial materials have been included for more intelligent judgment of the basic raw materials and because these materials are the raw materials in some industries.

Statements regarding characteristics of the materials and nomenclature are not the personal opinions of the author, but are backed

by the most competent authorities in each case or are the most common usage of successful manufacturers. Names are selected by the greatest and most reasonable use. Local, slang, and colloquial names are omitted unless they represent particular grades or uses.

Part II also represents a development from a need. It began as an Appendix containing such tables as are frequently required for reference. In this edition, it developed into an arrangement of basic economic data because the experience of the author in dealing with procurement officials in Federal and military service has paralleled that of the National Association of Purchasing Agents, namely, that the materials' procurement function is a profession drawing on all the technical sciences, and that the procurement official no longer is content merely with the administrative "how" of buying, but wants basic technical facts on the "why" in simple usable terms.

Because of the numerous sources of information, it is impossible to give credit in the published volume to the producers and experts who have furnished data, but acknowledgment is here made to the ready and willing cooperation that has been received from producers, technical authorities, industrial-paper editors, and government bureaus in this country and in England. Encouragement and advice given to the work by members of the National Association of Purchasing Agents have also been of real help to the author. Credit is given to James F. Moulton, Jr., of the Naval Ordnance Laboratory, for much work in checking statements on physical and chemical properties, and for his cooperation on technical arrangement.

GEORGE S. BRADY

WASHINGTON, D.C.

*January, 1951*

## A FOREWORD FOR THE USER

For the purchasing executive or the product engineer who must think in terms of a wide variety of materials, nothing is more useful than to fix in the mind a few figures that will serve as milestones to give a quick comparative judgment of material characteristics. A new figure is of little value unless it brings to the mind a comparison with a known value.

Only a few such values need be remembered. For purposes of comparison it is well to keep in mind such data as these: The average tensile strength of common low-carbon soft steel is 40,000 psi; the average point of hardness at which metals are no longer machinable with ordinary tools is 300 Brinell; the average weight of ordinary steel is 7.8 times that of water, and aluminum is about one-third the weight of steel. With only a little effort the nonchemist can familiarize himself with the chemical groupings and characteristics of important basic chemical radicals, such as the benzene ring, ethyl, methyl, amine, for better judgment of chemical materials.

A relatively short amount of reading with a perceptive mind will soon fix in the consciousness important points of relativity on strengths, hardness, weights, degrees of screen fineness, of organic compositions, and other matters that will make the path easier for a ready judgment of any new material that may come to the attention.

In the present edition the shortest accepted abbreviations have been used in order to save space, such as psi to indicate pounds per square inch, and rpm for revolutions per minute. Where no particular physical units are mentioned, the generally accepted and widely used units apply. Thus, when the density of a gas is given as 1.312, it signifies 1.312 grams per liter. If the figure were used to indicate the density of a liquid, the density would be understood to be 1.312 grams per cubic centimeter. When not specifically stated, all physical constants given are those determined at room temperature and standard atmospheric pressure.





## PART I

### *Materials, Their Properties and Uses*

**Abrasives.** Substances used for surfacing and finishing metals, stone, wood, glass, and other materials by abrasive action. The natural abrasives include the diamond, emery, corundum, sand, crushed garnet and quartz, tripoli, and pumice. The artificial abrasives are marketed under many trade names, but are mostly either silicon carbide or aluminum oxide. The massive natural abrasives, such as sandstone, are cut into grinding wheels from the natural block, but most abrasive material is used in the grain or built into artificial shapes.

For industrial grinding, artificial abrasives are preferred to natural abrasives because of their greater uniformity. Grading is important because uniform grinding requires grains of the same size. The abrasive grains are used as a grinding powder, are made into wheels, blocks, or stones, or are bonded to paper or cloth. Abrasive cloth is made of cotton jeans or drills to close tolerances of yarns and weaves, and the abrasive grains are stuck on with glue or resinoids. The crushed material is graded in sizes from 8 to 240 mesh and marketed in kegs or cans. Coarse grain is 12 to 24 grit; very fine is 150 to 240. Floated flours consist of grains of extreme fineness and uniformity marketed as Grinding flour for grinding optical glass and fine cutlery, usually in grain sizes from 280 to 600 mesh. Levigated abrasive powders used for final burnishing of metals or for metallographic polishing are abrasives reduced to an extremely fine, smooth powder. The so-called Green rouge is levigated chromic oxide, and Mild polish is levigated tin oxide; both are used for burnishing soft metals. Ultra-fine Polishing powder is made by pressure grinding and washing to make it chemically neutral. Gamal, of the Fisher Scientific Co., is a fine aluminum oxide powder with the particles so small that they are visible only with the electron microscope, the smaller cubes being

1.5 microns (0.0015 mm), with tinier particles 0.0005 mm, or 0.0000197 in.

The hardest abrasive is the diamond, which has a hardness of 10 on the Moh scale. The artificial abrasives silicon carbide and boron carbide have a hardness between 9 and 10. Garnet is one of the softest of the so-called hard abrasives, with a hardness of 6 to 7.5. Rouge is one of the hardest of the soft abrasives, with a hardness of 5.5 to 6.5. The Mild abrasives, used in silver polishes and window-cleaning compounds, such as chalk and talc, have a hardness of 1 to 2 Moh. The milder abrasives for dental pastes and powders may be precipitated calcium carbonate, tricalcium phosphate, or combinations of sodium metaphosphate and tricalcium phosphate. Abrasives for metal polishes may also be pumice, diatomite, silica flour, tripoli, whiting, kaolin, tin oxide, or fuller's earth. This type of fine abrasive must be of very uniform grain in order to prevent scratching. Ground glass is regularly marketed as an abrasive for use in scouring compounds and in match-head compositions. Lapping abrasives, for finish grinding of hard materials, are diamond dust or boron carbide powder.

In the metalworking industry, aluminum oxide wheels are used for grinding materials of high tensile strength. Silicon carbide is harder but is not as strong as aluminum oxide. It is used for grinding metals that have dense grain structure and for stone. The first artificial Grinding wheels were introduced in 1825 from India where they had been made for centuries by binding natural corundum grains with gum resin or shellac. There are five processes for making Abrasive wheels, each giving different characteristics: Vitrified wheels are made by running the mixture into molds and, when dry, subjecting to intense heat. They are used for heavy work up to 6,500 surface ft per min. The silicate process consists in tamping the material into molds with a silicate binder, and then baking in an oven. The silicate bond releases the grains more easily than the vitrified. Synthetic resins, such as the phenol resins, are used for bonding where greater strength is required than is obtained with the silicate, but less openness than with the vitrified. Resinoid bonds are used up to 16,000 surface ft per min. Shellac binder is used on wheels for light work and for finishing. Rubber is used for high speed or fine finish. Butadiene synthetic rubber bonds give longer life than those of nat-

ural rubber. Some Diamond wheels are made with aluminum powder mixed with a thermosetting resin, and the diamond abrasive mix is hot-pressed around this core wheel.

The choice of a binder for grinding wheels is important, as it must be strong enough to hold the grains together to accomplish the desired results, and then to release them before they become too dull. Coarse-grained wheels are used for fast removal of stock or for ductile materials, and fine-grained wheels for hard and brittle material or for fine finish. With any given bond the amount of bond determines a hard or soft wheel as distinct from hard or soft grains. The structure, or spacing of the grains in the bond, must be uniform to obtain uniform grinding. Some wheels are made with a porous honeycombed structure to give free cutting and cooler operation on some types of metal grinding. The Open-structure wheel of the Norton Co., and the Por-Os-Way of A. P. De Sanno & Co., Inc., are wheels of this type.

**Abrasive garnet.** Garnet is a general name for a group of minerals varying in color, hardness, toughness, and method of fracture, used for coating abrasive paper and cloth and for cutting glass and stone. Almandite is the type most used for abrasive purposes, although andradite and rhodolite are also employed. The best garnet abrasives come from red almandite, obtained in large crystals in New York state. The garnet of North Carolina is a by-product of kyanite mining, the ore containing 10% garnet, 15 kyanite, and 30 mica. Garnet is crushed, ground, and separated and graded in settling tanks and sieves. Hornblende is a common impurity and is difficult to separate, but good quality abrasive garnet should be free of this mineral. Garnet-coated paper and cloth are preferred to quartz for the wood-working industries, because garnet is harder and gives sharper cutting edges, but aluminum oxide is often substituted for garnet. The less expensive quartz is sometimes colored to imitate garnet. The grades of garnet grains used on Garnet paper and cloth range from No. 5, the coarsest, which is about 15 mesh, to 7/0, the finest, which is about 220 mesh. The paper used as a backing is a good quality kraft of 50 to 70 lb weight, or a rope manila stock. The usual size is 9 by 11 in. The cloth is usually in two weights, the lightweight being used as a flexible rubbing-down material. Some garnet is made into wheels

by the silicate process, but vitrified wheels are not made because of the low melting point of garnet.

**Abrasive sand.** Any sand used for abrasive and grinding purposes, but the term does not include the sharp grains obtained by crushing quartz and used for sandpaper. The chief types of abrasive sand include sandblast sand, glass-grinding sand, and stone-cutting sand. Sand for stone sawing and for marble and glass grinding is usually ungraded, with no preparation other than screening, but it must have tough, uniform grains. Chats are sand tailings from the Missouri lead ores, used for sawing stone. Banding sand is used for the band grinding of tool handles, and for the grinding of plate glass, but is often replaced by artificial abrasives. Banding-sand grains are fine, 95% being retained on a 150-mesh screen. Burnishing sand, for metal polishing or grinding valve seats, is a fine-grained silica sand with rounded grains. It should pass a 65-mesh screen, and be retained on a 100-mesh screen.

**Acaroid resin.** A gum resin from the base of the tufted trunk leaves of various species of *Xanthorrhoea* trees of Australia and Tasmania. It is also called Gum accroides and Yacca gum. Yellow acaroid from the *X. tateana* is relatively scarce, but a gum of the yellow class comes from the tree *X. preissii* of Western Australia, and is in small hollow pieces of yellow to reddish color. It is known as Black boy resin, the name coming from the appearance of the tree. Red acaroid, known also as Red gum and Grass tree gum, comes in small dusty pieces of reddish-brown color. This variety is from the *X. australis* and about 15 other species of the tree of southeastern Australia. The resins contain 80 to 85% resinotannol with coumaric acid and some cinnamic acid. They are thus closely related chemically to the balsams. Acaroid resin has the property unique among natural resins of capacity for thermosetting to a hard, insoluble, chemical-resistant film. By treatment with nitric acid it yields picric acid; by treatment with sulphuric acid the resin yields fast brown to black dyes. The resins are soluble in alcohols and in aniline, only slightly soluble in chlorinated compounds, and insoluble in coal-tar hydrocarbons. Acaroid has some of the physical characteristics of shellac, but is difficult to bleach. It is used for spirit varnishes and metal lacquers, coatings, paper sizing, in inks and sealing waxes, binders,

for blending with shellac, production of picric acid, and in catarrhal medicine.

**Acetaldehyde.** A water-white inflammable liquid with an aromatic penetrating odor, used as a reducing agent, in the manufacture of synthetic resins, in making pentaerythritol, in rubber antioxidants, as a preservative, for making dyestuffs, for the explosive pentolite, and for silvering mirrors. It is also called Ethanal. It is made by the oxidation of ethyl alcohol and has the composition  $\text{CH}_3 \cdot \text{CHO}$ . The specific gravity is 0.801 and boiling point  $20.8^\circ\text{C}$ . It is soluble in water, alcohol, and in naphtha. Paraldehyde,  $(\text{CH}_3 \cdot \text{CHO})_3$ , may be used instead of acetaldehyde in resin manufacture, has a higher boiling point,  $124^\circ\text{C}$ , and a higher flash point, but is not as reactive and will not reduce silver solutions to form a mirror. Paraldehyde is used for fulling leather.

**Acetamide.** Also called Acetic acid amine and Ethanamide. A grayish-white crystalline solid with a melting point of  $77$  to  $81^\circ\text{C}$ , specific gravity 1.139, composition  $\text{CH}_3 \cdot \text{CO} \cdot \text{NH}_2$ , and slight mousy odor. It is soluble in water and in alcohol. It is used as a liquid flux for soldering on painted or oily surfaces, as an antacid in lacquers and explosives, as a softening agent in glues and leather coatings, and as a nonhazing plasticizer in cellulose nitrate and acetate films. Its ability to dissolve starch and dextrine makes it useful in adhesives for waxy papers. With added corrosion inhibitors it is used as an anti-freeze, a 50% solution in water having a freezing point of  $-27.5^\circ\text{C}$ . Acetaldehyde ammonia,  $\text{CH}_3 \cdot \text{CHOH} \cdot \text{NH}_3$ , is a white crystalline solid with a melting point of  $80^\circ\text{C}$ . Aldamine of the Niacet Chemicals Corp. is this product. It is used as a rubber vulcanization accelerator, pickling inhibitor for steel, and in the manufacture of plastics.

**Acetic acid.** Also known as Ethanoic acid. A colorless, corrosive liquid of pungent odor and composition  $\text{CH}_3 \cdot \text{COOH}$ , having a wide variety of industrial uses as a reagent, solvent, and esterifier. It is employed as a weak acid for etching and for soldering, in stain removers and bleaches, as a preservative, in photographic chemicals, for the manufacture of cellulose acetate, as a solvent for essential oils, resins, and gums, as a precipitant for latex, in tanning leather, and in making artificial flavors. Acetic acid is found in the juices of many

fruits, and in combination in the stems or woody parts of plants. It is the active principle in Vinegar, giving it the characteristic sour taste, acid flavor, and pungent odor. It is made commercially by the oxidation of ethyl alcohol, and also produced in the destructive distillation of wood. The specific gravity is 1.049, boiling point  $118^{\circ}\text{C}$ , and it becomes a colorless solid below  $16.6^{\circ}\text{C}$ . The pure 99.9% solid is known as Glacial acetic acid. Standard and Laundry special grades contain 99.5% acid, with water the chief impurity. Various standard strengths of water solution are 28, 56, 70, 80, 85, 90%.

Acetic anhydride,  $\text{CH}_3\text{COOCOCH}_3$ , a colorless liquid with boiling point  $139.5^{\circ}\text{C}$ , is a more powerful acetylating agent, and is used in making cellulose acetate. It forms acetic acid when water is added. Hydroxyacetic acid,  $\text{HOCH}_2\text{COOH}$ , or Glycolic acid, is produced synthetically and is intermediate in strength between acetic and formic acids. It is soluble in water, is nontoxic, and is used in foodstuffs, dyeing, tanning, electropolishing stainless steel, and in resins. Its esters are solvents for resins. Acetin is an ester of acetic acid made from glycerin and acetic acid, used as a solvent for basic dyes and tannins. It is a neutral straw-colored liquid of specific gravity 1.20 and boiling point  $133$  to  $153^{\circ}\text{C}$ . It is also used in low-freezing dynamites and smokeless powder. The triacetic ester, Triacetin, is a water-white liquid of specific gravity 1.16 and flash point  $271^{\circ}\text{F}$ , soluble in aromatic hydrocarbons. It is used as a plasticizer.

Peracetic acid,  $\text{CH}_3\cdot\text{O}\cdot\text{COOH}$ , is a colorless liquid of strong odor with the same solubility as acetic acid. It has 8.6% available oxygen, and is used as a bleaching agent, a polymerization catalyst, and as a bactericide. Trifluoroacetic acid,  $\text{CF}_3\text{COOH}$ , is one of the strongest organic acids. It is a colorless, corrosive liquid, boiling at  $71.1^{\circ}\text{C}$  and freezing at  $-15.3^{\circ}\text{C}$ . It is used in the manufacture of plastics, dyes, pharmaceuticals, and flame-resistant compounds.

**Acetone.** An important industrial solvent, used in the manufacture of lacquers, plastics, smokeless powder, for dewaxing lubricating oils, for dissolving acetylene for storage, for dyeing cotton with aniline black, and as a raw material in the manufacture of other chemicals. It is a colorless, inflammable liquid with a mint-like odor and is soluble in water and in ether. The composition is  $\text{CH}_3\cdot\text{CO}\cdot\text{CH}_3$ , specific gravity 0.790, boiling point  $56^{\circ}\text{C}$ , and solidification point

—94°C. Acetone is prepared by a special fermentation of grain, forming butyl alcohol and acetone. The oily residue from the distillation is called Acetone oil and is used as a denaturant of alcohol. Diacetone, or Diacetone alcohol, is a colorless liquid of the composition  $\text{CH}_3 \cdot \text{CO} \cdot \text{CH}_2 \cdot \text{COH} (\text{CH}_3)_2$  with a pleasant odor. It is used as a high boiling solvent for nitrocellulose and cellulose acetate, for gums and resins, in lacquers and thinners, and in ink removers. Because of its low freezing point and miscibility with castor oil it is used in hydraulic brake fluids. The specific gravity is 0.938, boiling point 166°C, and freezing point —54°C. Synthetic Methyl acetone is a mixture of about 50% acetone, 30 methyl acetate, and 20 methanol, used in lacquers, cellulose plastics, paint removers, and for coagulating latex.

**Acetylene.** A colorless gas of the composition  $\text{CH}:\text{CH}$ , used for welding torches, for lighting, and for producing other chemicals. Because of the shortage of short-chain hydrocarbons from petroleum during the war the Germans used acetylene as a raw material for the production of butadiene, ethyl alcohol, ethylene, glycerin, adipic acid, and other chemicals. It contains 92.3% carbon, and is therefore nearly gaseous carbon. When pure, it has a sweet odor, but has a disagreeable odor when it contains hydrogen sulphide as an impurity. Acetylene burns brightly in the air, and was widely used for theater stage lighting before the advent of the electric light. When mixed with oxygen as Oxyacetylene for welding, it gives a temperature of 3500°C. In a mixture of about 3% acetylene to 97 of air, it is used as an explosive gas. The maximum explosive effect is with a mixture of 7.7% gas with 92.3 air. Acetylene has a specific gravity of 0.92. It is nontoxic, and is soluble in water, alcohol, or acetone. It liquefies under a pressure of 700 psi at 70°F. It is easily generated by the action of water on calcium carbide, but is also produced from petroleum. It is marketed compressed in cylinders, dissolved in acetone to make it nonexplosive. One volume of acetone will dissolve 25 volumes of acetylene at atmospheric pressure, or 250 volumes at 10 atm. Prestolite is a trade name of the Prestolite Co., Inc., for acetylene dissolved in acetone. Acetylene snow, or solid acetylene, is produced by cooling acetylene below the melting point and compressing. It is insensible to shock and flame, and is thus easier to transport.



**Acrylic resins.** Colorless, highly transparent, thermoplastic, synthetic resins made by the polymerization of acrylic derivatives, chiefly from the esters of Acrylic acid,  $\text{CH}_2\text{:CH}\cdot\text{COOH}$ , and Methacrylic acid,  $\text{CH}_2\text{:C}(\text{CH}_3)\cdot\text{COOH}$ , Ethyl acrylate and Methyl acrylate. The resins vary from soft, sticky semisolids to hard, tough solids, depending upon the constitution of the monomers and upon the polymerization. They are used for adhesives, protective coatings, finishes, laminated glass, transparent structural sheet, and molded products. Acrylic resins are stable and resistant to chemicals. They do not cloud or fade in light when used as a laminating material in glass. For molding they may be compounded with fillers, plasticizers, and pigments. Methyl methacrylate is a hard rigid resin of the acrylic series. In sheet form the density is 1.185, tensile strength 5,800 to 9,000 psi, compressive strength 15,000 psi, flexural strength 15,000 psi, refractive index 1.49, Brinell hardness 18 to 20, softening point  $203^\circ\text{F}$ , and dielectric strength 480 volts per mil. It is superior to ordinary glass in the transmission of ultraviolet light, transmitting the rays down to 250 millimicrons wave length. The direct transmission of white light is 93%, and the flat sheet has optical homogeneity. The material is resistant to acids and to petroleum solvents. Sheet can be molded and bent by heating to 220 to  $300^\circ\text{F}$ , and is easily sawed, drilled, or machined. The powder can be injection- or compression-molded. Because of its transparency, it is adapted for molded products such as costume jewelry, handbag frames, and novelties.

Lucite is methyl methacrylate of E. I. du Pont de Nemours & Co., Inc., marketed as molding powder and in rods, tubes, and cast and molded sheets. Lucitone is this material molded in dentures in pink and translucent. Lucite HM-140 is this material compounded for high-temperature injection molding. Crystalite, of Rohm & Haas Co., is an acrylic molding powder. Plexiglas, of this company, is transparent methyl methacrylate in sheets and rods. Plexiglas V is for injection molding to give products of water-white clarity, while Plexiglas VM is a molding powder for products to resist heat distortion to  $174^\circ\text{F}$ . Vernonite, of this company, is an acrylic denture resin. Acryloid and Acrysol are acrylic resins of this company, the Acryloids being copolymer solid resins, and the Acrysols being solutions for coatings and finishes for leather, textiles, and paper. Plexene M, of this company, is a styrene-acrylic copolymer thermoplastic resin for

injection molding. The specific gravity of the molded material is 1.08, dielectric strength 350 volts per mil, and tensile strength 15,000 psi. Acryloid A-10 resin of the Rohm & Haas Co., used for coatings and finishes, is a solution of the resin in cellosolve acetate, and Acryloid B-7 is a solution in ethylene dichloride. Uncolored coatings made with these resins will transmit 92% of the light rays. They are resistant to oils and many chemicals, are waterproof, and have good dielectric strength. Lucite, Plexiglas, and the English Perspex are used for aircraft windows. Polyco 296, of the American Polymer Corp., is a water-soluble acrylic copolymer used for thickening natural or synthetic rubber latex for coating paper and textiles. It gives resistance to yellowing and to bacteria.

**Acrylonitrile.** Also called Vinyl cyanide. A liquid of the composition  $\text{CH}_2\text{:CHCN}$ , boiling at  $78^\circ\text{C}$ , used in insecticides and for producing plastics and other chemicals. It is made by the addition of hydrocyanic acid to acetylene, or from petroleum. Acrylonitrile fiber, originally developed in Germany as a staple textile fiber and as a monofilament for screens and weaving, has good dimensional stability, high dielectric strength, and is resistant to water and to solvents. The polymerized acrylonitrile has a molecular structure that can be oriented by drawing to give fibers of high strength. Orlon, originally known as Fiber A, of E. I. du Pont de Nemours & Co., Inc., is a polymerized acrylonitrile fiber. It is nearly as strong as nylon, and has a softer feel. It can be crimped to facilitate spinning with wool. It is used for clothing textiles and for filter fabrics. Dynel, of the Carbide & Carbon Chemicals Corp., is an acrylonitrile-vinyl chloride copolymer staple fiber. It produces textiles with a warmth and feel like those of wool. It has good strength, is resilient, dyes easily, and is mothproof. Bakelite C-11 is an acrylonitrile copolymer for injection molding and extruding that produces rigid thermoplastic parts of higher tensile strength than those of the methacrylates, and has good dimensional stability and scratch resistance.

**Activated charcoal.** A nearly chemically pure amorphous carbon made by carbonizing and treating dense material such as coconut shells, peach pits, or hardwood. When made from coal, or in the chemical industry, it is more usually called Activated carbon. It may be made by dry distillation, or by leaching the charcoal with steam or

by treatment with zinc chloride or potassium thiocyanate. It is used as an adsorbent material for gas masks, and for purifying acids, recovering solvents, and decolorizing liquids. Coconut charcoal, valued for gas masks, is an activated charcoal usually made by heating coconut shells in a closed retort, crushing, and steam treating. An activated charcoal made from coconut shell will adsorb 68% of its weight of carbon tetrachloride, while one made from anthracite will adsorb only 50%. Activated charcoal made in Germany for gas masks was produced from ground peat by mixing with zinc chloride and heating to 700°C to drive off moisture,  $\text{ZnCl}_2$ , and  $\text{HCl}$ , and then leached. A requirement of activated charcoals, besides high adsorbing power, is that they possess strength to retain a porous structure to pass the air or liquid. Powdered activated charcoal is ground so that 95% will pass through a 300-mesh screen. For water purification it should be fine enough to wet easily, but not so light that it will float on the top. For decolorizing or deodorizing oils and chemicals it is mixed in the liquid and settles out in a few hours. A single drop of water will hold 10,000 particles of powdered charcoal. In sugar and oil refining it removes color but does not bleach like chemicals. Hydrodarco, of the Darco Corp., is a powdered activated carbon. Norit, of the American Norit Co., Inc., is a group of highly adsorptive activated carbons. Other trade names for activated charcoals are Dorsite, Bachite, and Kelpchar, the latter being made from seaweed. Tec-Char, of the Tennessee Eastman Corp., is by-product charcoal obtained in wood distillation, and in graded grains for various uses. Nuchar is an activated carbon of the West Virginia Pulp & Paper Co. The activated carbon of the Masonite Corp. is made by subjecting wood chips to high steam pressure and disintegrating by sudden release of the pressure. The doughy mass is briquetted and carbonized.

**Adhesives.** Materials, usually liquid solutions, employed for sticking, or adhering, one surface to another. The commercial adhesives include pastes, glues, pyroxylin cements, rubber cements, latex cement, and special cements of chlorinated rubber, synthetic rubbers, or synthetic resins. Adhesives are characterized by the degree of tack, or stickiness, by their strength of bond after setting or drying, by the rapidity of bonding, and by their durability. Adhesives for rapid machine application must have good initial tack. Tack is often

increased by adding rosin or ester gum, while the speed of drying may be altered by changing the solvent. The strength of bond is inherent in the character of the adhesive itself, particularly in its ability to adhere intimately to the surface to be bonded. Adhesives prepared from organic products are in general subject to disintegration on exposure. The life of an adhesive depends usually upon the stability of the ingredient that gives the holding power, although otherwise good cements of synthetic materials may disintegrate by the oxidation of fillers or materials used to increase tack.

Pastes are usually water solutions of starches or dextrines, sometimes mixed with gums, resins, or glue, and containing antioxidants. They are the cheapest of the adhesives, but deteriorate on exposure. They are widely employed for the adhesion of paper and paper-board. Much of the so-called Vegetable glue is Tapioca paste. It is used for the cheaper plywoods, for postage stamp adhesives, envelopes, and for labeling. Latex pastes of the rub-off type are used for such purposes as photographic mounting as they do not shrink the paper as do the starch pastes. Glues are usually water solutions of animal gelatin, and are stronger and more durable than pastes. The only difference between animal glues and edible gelatin is in the degree of purity. Hide and bone glues are marketed as dry flake, but fish glue is liquid. Mucilages are light vegetable glues, generally from water-soluble gums. Pyroxylin cements may be merely solutions of nitrocellulose in chemical solvents, or they may be compounded with resins, or plasticized with gums or synthetics. They dry by the evaporation of the solvent, and have little initial tack, but because of their ability to adhere to almost any type of surface they are called Household cements. Cellulose acetate may also be used. These cements are used in the shoe industry for bonding the soles of women's shoes. The bonding strength is about 10 psi, or equivalent to the adhesive strength of the outer fibers of the leather to be bonded. Some of the commercial pyroxylin and acetate cements are simply solvent solutions of recovered motion-picture film and retain the original plasticizers. Other plastics are also used in adhesives. For hot-press lamination of wood the plastic cement is sometimes marketed in the form of thin sheet. Tego resin film, of the Rohm & Haas Co., is a phenol resin sheet of this class. Uformite 507, of this company, is a precatyzed urea-formaldehyde resin powder for dispersion

in water as a hot-pressing adhesive for plywood. Urac 110 resin, of the American Cyanamid Co., is a urea-formaldehyde resin in powder form for adding to starch adhesives to make them waterproof for use in laminating. The German adhesive known as Pressal is a mixture of 30% melamine-formaldehyde resin and 70 starch. The Desmophens were German adhesives made by reacting a polyhydric alcohol with adipic acid. Maltophen is a Desmophen mixed with carbon black. Norelite glue, developed by the U.S. Department of Agriculture, is a water-soluble phenol resin with soybean meal and corn gluten.

Rubber cements for paper bonding are simple solutions of rubber in a chemical solvent. Like the latex pastes, the excess can be rubbed off the paper. Stronger rubber cements are usually compounded with resins, gums, or synthetics. An infinite variety of these cements is possible, and they are all waterproof with good initial bond, but they are subject to deterioration on exposure as the rubber is uncured. This type of cement is also made from synthetic rubbers which are self-curing. Ubapol, of the Union Bay State Chemical Co., is a synthetic rubber solvent cement. Curing cements are rubber compounds to be cured by heat and pressure or by chemical curing agents. When cured, they are stronger, give better adhesion to metal surfaces, and have longer life. Latex cements are solvent solutions of rubber latex. They provide excellent tack and give strong bonds to paper, leather, and fabric, but they are subject to rapid disintegration unless cured.

Cements compounded from synthetics are less subject to deterioration than the vegetable and animal products, and may have high bonding strength. They are the only adhesives that give reliable cold bonds to metals, especially after curing or chemical setting. Cold bonds as high as 300 psi can be obtained with compounded synthetic cements, while heat-cured bonds as high as 1,000 can be obtained. Neoprene cements may be simple solutions in a solvent with strengthening fillers and a curing agent, or they may be compounded with resins. Like the rubber cements they may be marketed in two parts to be mixed just before use. The Fairprene cement of E. I. du Pont de Nemours & Co., Inc., is a Neoprene cement in which an activator is mixed before use. It then cures at room temperature. The synthetic rubber cements are also marketed as Sealing tapes with the cement coated on both sides of a thin fabric for application as gaskets, and for sealing seams at riveted metal joints or bulkheads.

**Adipic acid.** Also called Butane dicarboxylic acid. A white crystalline solid of the composition  $\text{COOH}(\text{CH}_2)_4\text{COOH}$ , used as a plasticizer in synthetic resins and coatings, and in the production of nylon. It is made by the treatment of fatty acids with nitric acid, or can be made by oxidizing cyclohexanol. The melting point is  $152^\circ\text{C}$ . It is soluble in alcohol, and slightly soluble in water.

**Admiralty metal.** An alloy containing about 70% copper, 1 tin, and the remainder zinc, sometimes termed Admiralty bronze. This composition is listed by the American Brass Co. as Admiralty alloy. The tin increases the hardness and strength but decreases the ductility. Admiralty metal of the Revere Copper & Brass, Inc., has 71% copper, 28 zinc, and 1 tin. The hard-drawn tube has a tensile strength of 100,000 psi and elongation 3%. Federal specifications permit up to 0.06% iron and 0.075 lead as impurities. The weight is 0.305 lb per cu in. It machines readily, especially when it contains lead. The alloy has been standard for condenser tubes, and in sheet form where corrosion resistance is required.

**Agar-agar.** The dried bleached gelatinous extract from various species of Seaweed, *Algae*, mostly from the Pacific and Indian Oceans. Some agar is produced in North Carolina, Great Britain, and Australia. The double Malay word means seaweed. When dissolved in hot water, agar forms a transparent jelly, and is used for fixing bacteria for counts, as a stabilizer in toilet lotions and medicines, in dental forms, and in foods. Kantan is a variety of agar from the Tengusa seaweed, *Gelidium corneum*, of Japan. Australian agar is from the abundant seaweed *Gracilaria confervoides*. Commercial agar is colorless, yellowish, or pink to black. It is marketed in strips, blocks, or shredded, and is obtained by boiling the dry seaweed and straining out the insoluble matter.

Most of the American production of agar, as distinct from the algaes of the Atlantic, is from the giant Kelp, *Macrocystia pyrifera* and *Gelidium cartilagineum* of the coast of California and Mexico, but it is not valued as highly for bacteriologic use as the Asiatic. The kelp grows straight up in water 60 to 100 ft deep and then spreads out on the water another 60 to 80 ft. It is cut about 3 ft below the surface, and three crops are harvested annually. The plant is 90% water. The dried kelp is washed with boiling water, cooked with

soda ash, filtered, sterilized, and treated with muriatic acid to extract the algin in fiber form.

Irish moss, also called *Chondrus* (pronounced chone-droosh), Pearl moss, and Carageen, is a variety of brown seaweed, *Chondrus crispus*, found off the Hebrides, the west coast of Ireland, and New England. The weed used mostly for alginic acid is the brown kelp, *Laminaria saccharium*, *L. ditatata*, and other species, found off the Hebrides. The seaweed *Gigartina stellata*, of the North Atlantic, is also used to produce agar and algin. It is bleached and treated to produce gelatin used in soaps and foodstuffs, as a clarifying agent, and as a sizing for textiles. Krim-Ko gel, of the Krim-Ko Co., is the dry concentrate from Irish moss in light buff-colored scaly powder easily soluble in water, used as a colloidal gelling agent. It is neutral, with a pH of 6.4 to 7.2. Carragar is the purified edible material used for pharmaceuticals and foodstuffs. Unlike agar, it contains the natural salts of potassium, sodium, calcium, and magnesium which increase the food value. The Irish name Dulse is applied to the dried or cooked seaweed, *Rhodymenia palmata*, used by the people of the Canadian Maritime Provinces for food. It is purple in color and rich in iodine and mineral salts. Other species, known as Laver and Murlins, are also used in Iceland, Ireland, and Scotland for food. When used for producing iodine in Scotland, the seaweed goes under the general name of Tangle. The kelp found along the Chilean and Peruvian coasts, when dried for making algin products, is called by the Quichua name Cochayuyo. Kombu, used by the Japanese for food, is a brown seaweed from the coast of Hokkaido.

Algin, or Alginic acid, is a protein gelatin obtained from seaweed as a by-product in the manufacture of iodine and potash, or directly from the weed. Algin is a colorless mass resembling gelatin, and has the empirical formula  $C_{21}H_{27}O_{20}$ . When dry, it becomes hard and horny, insoluble in alcohol, and only slightly soluble in cold water. Dry seaweed contains 20 to 30% algin. In the form of Sodium alginate it is used as a stabilizer in ice cream and other foods, in textile printing, as an emulsifier and stabilizer in medicines to replace gum arabic and as a laxative, and in water paints, boiler compounds, polishes, and in meat packing.

Sodium alginate, made by dissolving algin in a sodium carbonate solution and neutralizing with hydrochloric acid, forms tough, flex-

ible, colorless sheets, soluble in water. When applied as a coating for fabrics, it is again treated with acids to make it insoluble and water-proof. Kelgin is the trade name of the Kelco Co. for sodium alginate used as a stabilizer in the food industry, and Keltex is the material in granular powder for use in the textile industry. Dariloid, of this company, is sodium alginate used to replace gelatin in ice cream. Alginic fibers are silklike threads made by forcing a sodium alginate solution through spinnerets into a calcium chloride bath and then making insoluble by treatment with a beryllium acetate solution. They are used for nonflammable fabrics, but the fiber is soluble in sodium soaps and must be dry-cleaned. A soluble alginic fiber is used for making fancy striped fabrics where uneven spacing of threads is desired without change in the loom. The alginate yarn is washed out of the fabric after weaving, leaving the desired spacing. At least 25 mineral salts are known to be present in seaweed as well as several vitamins. In the utilization of the seaweed as gelatin or alginate these are left in the Kelp meal which is marketed as poultry and stock feed. In Asia the whole plant is cooked and eaten.

**Agate.** A natural mixture of crystalline and colloidal silica, but consisting mainly of the mineral chalcedony. It usually occurs in irregular banded layers of various colors derived from mineral salts, and when polished has a waxy luster. The specific gravity is about 2.6, and the mineral is sometimes harder than quartz. It consists of about 98% silica. Agate is used for knife-edges and bearings of instruments, for pestles and mortars, for textile rollers, ornamental articles, and the finer specimens are employed as gem stones. The finest of the massive agates come from Uruguay and Brazil. Moss agate encloses filaments, mostly green, suggestive of moss. The moss agates of Montana, and the yellow-green moss agate of California known as Amberine, are used as gem stones. Agate was probably deposited from a silica gel solution, and also occurs in the form of stalactites and in petrified wood. The Agatized wood of Wyoming and Arizona has a green fluorescence. It is cut into ornaments. Clear, translucent, yellow agates are called Sard, while the clear reddish ones are Carnelian. Both are used as gem stones. Sardoine is a brownish carnelian found in Western United States. The Iris agate, with rainbow colors, from Montana and Oregon, is highly prized. Moss opal



of Nevada and California is moss agate intergrown with opal. Blue moonstone of California is not a true moonstone but is a blue agate of opalescent luster. Commercial agates may be artificially stained with mineral salts, dyed, or treated with acids to bring out color differences. White agate is a cream-colored chalcedony with a more waxy appearance than agate.

**Ajowan oil.** Also called *Ptychotis* oil. A yellow essential oil distilled from Ajwan seed of the herbaceous plant *Carum copticum*, or *Ptychotis ajowan*, of India. The seed yields 3 to 4% oil containing up to 50% Thymol and some Cymene, most of the thymol separating out on distillation. Thymol is known as Ajwan ka phul, meaning Flowers of ajwan, and the latter part of the name is Anglicized to thymol. Ajowan oil has a specific gravity of 0.900 to 0.930. It is used in pharmaceuticals. Thymol,  $(\text{CH}_3)_2\text{CHC}_6\text{H}_3(\text{CH}_3)\text{OH}$ , is a white crystalline solid with a strong thyme odor, soluble in alcohol, and melting at  $50^\circ\text{C}$ . It is used in antiseptics, and as a deodorant for leather. Thymol is also obtained from horsemint oil and from eucalyptus oil, or can be made synthetically from meta cresol. It was originally distilled from the Thyme plant, *Thymus vulgaris*, of the Mediterranean countries, the dried leaves of which are used as a condiment. Cymene,  $(\text{CH}_3)_2\text{CHC}_6\text{H}_4\text{CH}_3$ , is used as a scent in soaps, and has high solvent properties. It is also obtained from spruce turpentine. It is a liquid of specific gravity 0.861 boiling at  $177^\circ\text{C}$ .

**Albumin.** The water-soluble and alcohol-soluble protein obtained from blood, eggs, or milk, and used in adhesives, textile and paper finishes, leather coatings, varnishes, as a clarifying agent for tannins, and in oil emulsions. Crude Blood albumin is a brown amorphous lumpy material obtained by clotting slaughterhouse blood and dissolving out the albumin. The remaining dark-red material is made into Ground blood and marketed as a fertilizer. Blood albumin is sold as clear, pale, amber, and colored powders. Blood albumin from human blood is a stable, dry, white powder. It is used as a 25% water solution for treatment of shock. Egg white is known as Albumen. Egg albumin is prepared from the dried egg white, and is marketed in yellowish amorphous lumps or powdered. Milk albumin is made by coagulating casein. Soybean albumin is used to replace egg albumin in confectionery. Synthetic egg white, or albumen, was made in

Germany from fish by extracting the soluble proteins with acetic acid, removing the fat with trichlorethylene, and hydrolyzing with sodium hydroxide. After neutralization, it is obtained as a white powder. Fish albumin is a good emulsifier, and can be whipped into a stiff foam for bakery products.

**Alcohol.** The common name for ethyl alcohol, but the term properly applies to a large group of organic compounds that have important uses in industry, especially as solvents and in the preparation of other materials. A characteristic of all alcohols is the monovalent  $\text{—OH}$  group. In the primary alcohols there is always a  $\text{—CH}_2\text{OH}$  group in the molecule. The secondary alcohols have a  $\text{—CHOH}$  group, and the tertiary alcohols have a distinctive  $\text{—COH}$  group. Alcohols with one OH group are called Monohydroxy alcohols; those with more than one OH group are known as Polyhydroxy alcohols or Polyhydric alcohols. Another method of classification is by the terms saturated and unsaturated. The common alcohols used in industry are ethyl, methyl, amyl, butyl, isopropyl, and octyl. The alcohols vary in consistency. Methyl alcohol is like water, amyl alcohol is oily, and melissyl alcohol is a solid. Many of the alcohols are easiest made by fermentation; others are produced as Synthetic alcohol from natural gas or from petroleum hydrocarbons. Much of the production of ethyl alcohol is from blackstrap molasses. Solidified alcohol, used as a fuel in small stoves, is a jellylike solution of nitrocellulose in ethyl alcohol marketed in tins. It burns with a hot flame.

**Aldehyde.** A group name for substances made by the dehydrogenation or oxidation of alcohols, such as formaldehyde from methyl alcohol. By further oxidation the aldehydes form corresponding acids, as formic acid. The aldehydes have the radical group  $\text{—CHO}$  in the molecule, and because of their ease of oxidation are important reducing agents. They are also used in the manufacture of synthetic resins and many other chemicals. Aldehydes occur in animal tissues and in the odorous parts of plants, giving odor and flavor to many of these.

**Alder.** The wood of several species of tree of the genus *Alnus* of the same family as the birch and beech. The Red alder is from the *A. rubra*, or *A. oregona*, growing in the Northwestern United

**States.** The wood has a reddish-brown color, a fine even grain, is tough and resilient, can be worked easily, and takes a good polish. It is much used for furniture, cabinetwork, and interior finish as it rivals mahogany and walnut in appearance. Black alder is from the tree *A. glutinosa*, widely distributed in the Northern Hemisphere. It is of a reddish-white color, and has a smooth, fine grain, with a weight of about 35 lb per cu ft. It is used for plywood, cabinetwork, and toys. Formosan alder is from the *A. maritima* of Asia. The wood is light yellow streaked with reddish lines and has a fine texture.

**Aldol.** A viscous, pale-yellow liquid of the composition  $\text{CH}_3 \cdot \text{CH}(\text{OH}) \cdot \text{CH}_2 \cdot \text{CHO}$ , also called Acetaldol, made by condensation of acetaldehyde with an alkali. It is used to replace formaldehyde in the manufacture of synthetic resins, in cadmium plating baths, in dye baths, in refining ores, in the manufacture of butadiene rubber, and in engraving. It has a specific gravity of 1.090 to 1.105, and is soluble in hot water and in alcohol. Paral dol, which is a double molecule of aldol, is a white crystalline product with a melting point of  $82^\circ\text{C}$ .

**Alkali.** A caustic hydroxide characterized by its ability to neutralize acids and form soluble soaps with fatty acids. Fundamentally, they are inorganic alcohols, with the monovalent hydroxyl group  $\text{—OH}$  in the molecule, but in the alkalies this group is in combination with a metal or an ammonia group and they have none of the characteristics of alcohols. All alkalies are basic, and have a pH value from 7 to 14. They neutralize acids to form a salt and water. The common alkalies are sodium hydroxide and potassium hydroxide, which are the ones used in making soaps, soluble oils, and cutting compounds, in cleaning solutions, and for etching aluminum. All of the alkalies have a brackish taste and a soapy feel; most of them corrode animal and vegetable tissues.

**Alkali metals.** A name given to lithium, sodium, potassium, rubidium, strontium, cesium, calcium, and barium because of the basic reaction of their oxides, hydroxides, and carbonates. Carbonates of these metals are called Fixed alkalies. The metals show a gradation in properties and increase in chemical activity with increase in atomic weights. All are silvery white and are soft enough to be cut with a knife. They tarnish rapidly in the air and decompose water at ordi-

nary temperatures. All have remarkable affinity for oxygen. Rubidium and cesium ignite spontaneously in dry oxygen. Calcium, strontium, and barium are also called Earth metals. Thin films of the alkali metals are transparent to ultraviolet light but opaque to visible light.

**Alkanet.** Also called Orcanette and Anchusa, and in medicine Alkanna. The root of the plant *Alkanna tinctoria*, related to the heliotrope, growing in the Mediterranean countries, Hungary, and western Asia. The coloring principle, Alkannin, is soluble in alcohol, benzene, ether, and in oils, and is produced in dry extract as a dark-red, amorphous, slightly acid powder. It is used for coloring fats and oils in pharmacy and in cosmetics, for giving an even-red color to wines, for coloring wax, and as a chemical indicator. Alkannin paper, also called Boettger's paper, is a white paper impregnated with an alcohol solution of alkanet. The paper is red, but it is turned to shades from green to blue by alkalies.

**Alkyd resins.** A group of thermoplastic synthetic resins known chemically as hydroxycarboxylic resins, of which the one produced from phthalic anhydride and glycerol is representative. They are made by the esterification of a polybasic acid with a polyhydric alcohol, and have the characteristics of homogeneity and solubility that make them especially suitable for varnishes and enamels, resistant coatings, calking compounds, adhesives, and plasticizers for other resins. The resins have high adhesion to metals, are transparent, easily colored, tough, flexible, heat- and chemical-resistant, have good dielectric strength, and are the most readily blended of the synthetic resins. They vary greatly with the raw materials used and with varying percentage compositions, from soft rubbery gums to hard brittle solids. Phthalic anhydride imparts hardness and stability. Maleic acid makes a higher melting-point resin. Azelaic acid gives a softer and less brittle resin. The long-chain dibasic acids, such as adipic acid, give resins of great toughness and flexibility. In place of glycerol the glycols yield soft resins, and sometimes the glycerol is modified with a proportion of glycol. The resins are modified with drying oils or fatty acids, and find wide use as finishes for automobiles, marine finishes, and baking enamels for refrigerators and household equipment. They bake to a high gloss, and are resistant to oils, light, and

weathering. The oil-modified resins are used as waterproof coatings for textiles. When mixed with urea-formaldehyde or melamine resin the alkyd resins give harder and more resistant baked coatings. Blended with ethyl cellulose they are used as tough flexible coatings for electrical cable. Emulsions of the alkyd resins are used in some resistant water paints.

Amberlac and Duraplex are alkyd resins of the Rohm & Haas Co. in a wide range of formulations. The Paraplex resins are oil-modified soft resins used for coatings for textiles and paper, and for blending with cellulose plastics to give better adhesion in lacquers. Paraplex P-43HV, however, is a polyester-styrene copolymer supplied as a clear liquid for laminating, molding, or casting at low pressure. Aquaplex, of this company, is a group of oil-modified resins for use in water paints. Teglac resins, of the American Cyanamid Co., used for indoor finishes and clear-coat varnishes, are hard alkyd resins made with natural resin acids as blending agents. Cycopol, of this company, is an alkyd-styrene copolymer resin for fast-drying enamels, giving high gloss and durability. Beckosol 1341, of Reichhold Chemicals, Inc., is a phenol-modified alkyd resin for fast-drying machinery enamels. Petrex resin, of the Hercules Powder Co., is a series of alkyd resins used in lacquers, varnishes, adhesives, and inks. Glyptal, of the General Electric Co., is a phthalic anhydride glycerol resin for lacquers and insulation. Aroplaz 1248-M, of U.S. Industrial Chemicals, Inc., is a high-gloss phthalic alkyd resin, soluble in mineral spirits, for industrial finishes. Plaskon Alkyd, of the Libbey-Owens-Ford Glass Co., is a mineral-filled alkyd molding powder that cures at 300°F. It is used for electrical parts having good arc resistance and heat resistance to 350°F. Dulax, of E. I. du Pont de Nemours & Co., Inc., Beckol, of Beck, Koller & Co., Esterol, of the Paramet Chemical Corp., are alkyd resins. Neolyn resins, of the Hercules Powder Co., are alkyd resins produced from rosin. They are used as modifiers for nitrocellulose and for vinyl resins in lacquers and adhesives to add toughness to the film.

**Alligator leather.** A light, tough leather with platelike scales on the surface. It is made from the skins of large saurians, or lizards, of the order *Crocodylia*, abounding in muddy tropical streams. The species *Alligator mississippiensis* inhabits the swamps of Southeastern

United States. The mature animal is usually about 7 ft long, and reaches this length in little over 5 years. Alligator leather is especially valued for luggage, pocketbook, and shoe leathers. It is much imitated with embossed split sheepskins, but sheepskin is soft and easily scuffed. Lizard leather, from the Java ring lizard, is another reptile leather valued for women's shoes.

**Alloy.** A solid solution of two or more metals. Chemically, an alloy is a solution that is entirely homogeneous, but the commercial use of the term also includes mixtures of metals that do not dissolve in each other. Lead, for example, does not dissolve in copper but forms separate particles in the metal matrix; in steel it does not dissolve but forms strings in the metal. Both are useful combinations and are called alloys. The commercial utility of an alloy arises from the fact that the pure metals are often too soft, weak, or rare to be used alone. Thus, copper, a soft metal, when alloyed with the brittle metal zinc, forms a strong, hard alloy, brass, that has wide usage. Alloys show definite relations that one metal bears to another, and definite characteristics can be obtained from the combinations, although these may be changed by the interaction of one alloying element on another. Thus, silicon and nickel give definite added properties to copper when added separately, but give an additional separate property when used together because of the formation of a nickel-silicide compound. Some alloys contain chemical crystals of the metals. Thus, bronze contains a percentage of copper-tin crystals, while in brass the copper and zinc may be only mechanically dissolved. The melting point is always lowered by the addition of one metal to another.

The number of possible alloys is infinite. They are made by the fusion of the metals, as distinct from products made by the diffusion of particles in close contact under high pressure, which process is called powder metallurgy. The most common general groups of alloys are brass, bronze, babbitt, alloy steels, nickel silver, aluminum alloy. Alloys of various compositions are sold under many trade names, but some trade names may be used to designate the quality of a particular maker rather than composition. Nibcoloy, for example, is a general trade name of the Northern Indiana Brass Co. for alloys of Monel, Inconel, or stainless steel.

A **Technic alloy** is a low-cost alloy used in laboratories or dental schools to avoid the use of expensive alloys of gold or platinum in practice working. It may be copper or aluminum with tin, nickel, silver, and iron, to give the approximate working characteristics of the expensive metal. A **Master alloy**, or **Foundry alloy**, is an alloy used for adding elements to metals in the foundry. Some of these may not be metallic alloys in the true sense. **Carburite**, for example, is a high-graphitic iron master alloy containing 55% carbon and only 26 iron, bonded with fluxing material into blocks for adding to steel to increase the carbon content. **Nisiloy**, of the International Nickel Co., is an alloy of 60% nickel, 30 silicon, and 10 iron for ladle additions to cast iron to improve uniformity and machinability of the castings.

**Alloy steel.** A general name for steels that owe their distinctive properties to elements other than carbon. Alloy steels usually take the name of the element or elements having the greatest influence on the characteristics of the alloy, regardless of the percentage of the element contained in the steel. These alloy steels include vanadium steel, nickel steel, nickel-chromium steel, manganese steel, and silicon steel. The American Iron & Steel Institute defines alloy steel as a steel in which a minimum limit is specified or guaranteed for alloying elements. These minimum percentages are chromium, 0.25%; copper, 0.60; manganese, 1.65; nickel, 0.25; silicon, 0.60; or any amounts of titanium, tungsten, or molybdenum. Steels having casual amounts of these elements less than those specified are not rated as alloy steels, although vanadium steel may be any carbon steel that has been cleansed with vanadium. Alloy steels are also marketed under a great variety of trade names, covering a particular steel made into rough castings, such as **Tufaloy**, a high-strength cast steel of the Port Pitt Steel Casting Div., H. K. Porter Co., Inc., or covering a group of steels marketed in rods and sheets such as **Agathon steel** of the Central Alloy Steel Corp., and **Carilloy** of the Carnegie-Illinois Steel Corp. Some alloy steels owe their particular properties to refinements of manufacture and selection of small amounts of alloying elements. The **Super-Kore steels** of the Carnegie-Illinois Steel Corp. are low-carbon carburizing steels for gears and shafts, giving tough and strong cores when hardened. The alloy steels are used for automo-

tive and machinery parts where high strength or special characteristics are required. Most tool steels and structural steels with special properties are now alloy steels. High-speed steels are alloy steels, but are classed as a separate group.

At the beginning of the century the proportion of alloy steels produced was small; at the end of the First World War it was 1 out of every 25 tons; and at the end of the Second World War alloy steel constituted 1 out of every 7 tons of steel produced. Universal steel is a name applied to alloy steels containing a low percentage of carbon to give them a wide range of utility. They are usually nickel-chromium steels, as these steels can be used with carbon as low as 0.15% without losing their heat-treating properties. High-alloy steels are steels containing very large percentages of elements, usually to obtain some special property such as corrosion resistance. They are often not steel in the true sense, but are iron alloys.

**Allyl plastics.** A group of water-white casting plastics produced by the polymerization of the ester of allyl alcohol or from allyl chloride, both produced from propylene. Allyl alcohol,  $\text{CH}_2\text{:CH}\cdot\text{CH}_2\text{-OH}$ , is a colorless liquid also known as Propenol. The specific gravity is 0.849, boiling point  $96^\circ\text{C}$ , and freezing point  $-129^\circ\text{C}$ . Allyl chloride,  $\text{CH}_2\text{:CH}\cdot\text{CH}_2\text{Cl}$ , is a liquid of specific gravity 0.937, boiling point  $45^\circ\text{C}$ , and flash point  $-25^\circ\text{F}$ . Allyl ester is a clear sirupy liquid of specific gravity 1.26 which polymerizes with a peroxide catalyst to form allyl plastics. The liquid monomer can be poured into molds and hardened by polymerization. The polymerized castings are hard and crystal clear. Allyl plastics have a specific gravity of 1.34 to 1.40, dielectric strength of 1,275 volts per mil, refractive index 1.57, Rockwell M hardness 116, and compressive strength 19,600 psi. As the plastic has high clarity and less light dispersion than most optical glass it is used for lenses, prisms, and reflectors. It can be colored easily with dyes, and is also used for mechanical and electrical parts. Kriston, of the B. F. Goodrich Chemical Co., Allite, of the Columbia Chemical Div., and Vibron 103, of the Naugatuck Chemical Div., are allyl plastics. V-Lite, of the Victor Chemical Works, is a Diallyl phenyl phosphate monomer that polymerizes with a catalyst to form a transparent, hard, strong, flame-resistant thermosetting resin. It can also be copolymerized with the thermoplastic



vinyl acetate or methyl methacrylate to produce thermosetting resins. Selectron CR-39, of the Pittsburgh Plate Glass Co., is an Allyl diglycol carbonate casting resin. The cast plastic has good abrasion resistance, is resistant to the action of chemicals, and is noncrazing. This resin is also used to modify other plastics.

Methallyl alcohol,  $\text{CH}_2=\text{C}(\text{CH}_3)\text{CH}_2\text{OH}$ , also forms esters which can be used for the production of plastics. It is a liquid boiling at  $114.5^\circ\text{C}$ . The allyl radical will combine with starch or sugar to form shellaclike resins. Allyl sucrose, made by combining sugar and allyl chloride, is a resin that produces varnishes which will withstand temperatures to  $400^\circ\text{F}$ , and are chemical-resistant. Allyl starch is a resinous material made by treating sweet-potato or grain starches with allyl chloride or allyl bromide. It is soluble in varnish solvents and is a substitute for shellac as a varnishing agent, forming an adherent, resistant film on paper, fabric, wood, or metal. It will withstand temperatures to  $400^\circ\text{F}$ .

**Almond oil.** An essential oil distilled from the ground macerated kernels of the bitter almond, *Prunus amygdalus*, of the Mediterranean countries, and from the kernels of the Apricot, *P. armeniaca*, both oils being identical and containing the glucoside Amygdalin. The American production is mostly from the by-product pits of the apricot-canning industry of California. The almond is a small tree closely resembling the peach. The fruit is inedible, but the seed inside the pit is marketed as roasted and salted nuts and is made into a paste for confections. Oil of bitter almonds is used in perfumery and as a flavor. For flavoring use, the poisonous hydrocyanic acid is extracted. Synthetic almond oil is Benzaldehyde,  $\text{C}_6\text{H}_5\text{CHO}$ , a colorless volatile oil with an almond flavor, produced from benzol or from toluol.

**Alpaca.** An English nickel silver used as a base metal for tableware. It contains about 65% copper, 20 zinc, 13 nickel, and 2 silver, and has a white color similar to silver. It is usually plated with silver, takes a fine polish, and is resistant to corrosion. Alpaca is widely imitated, often without the silver. Alpaca is also the name of a fabric made from Alpaca fiber, the fine woollike hair of animals of the llama family of Bolivia, Peru, Chile, and Argentina. Alpaca fiber is long and fine, with a downy feel, but it does not have the strength or elasticity of fine wool. Llama hair (pronounced lyah-ma) from the llama

of Bolivia is marketed as Coarse alpaca. The Vicuña, another animal of the llama family, is almost extinct, and the commercial vicuña cloth is made of alpaca or fine wool, or mixtures. There is a limited production of true vicuña from domestic herds in Bolivia and Peru, raised at an altitude of about 14,000 ft. It is the softest of all animal weaving fibers. Alpaca and vicuña cloths are used for shawls, jackets, and fine goods. Imitation alpaca fabric for clothing linings is a lustrous, smooth, and wiry fabric plain-woven with a cotton warp and a worsted mohair filling. When made with a rayon filling, it is called Rayon alpaca.

**Alum.** A colorless to white crystalline substance of the composition  $\text{KAl}(\text{SO}_4)_2 \cdot 12\text{H}_2\text{O}$ , or  $[\text{KAl}(\text{H}_2\text{O})_6]\text{SO}_4 \cdot 6\text{H}_2\text{O}$  occurring naturally as the mineral Kalunite, and also in combination as the mineral Alunite. It is also called Potash alum to distinguish it from other forms. It has a sweetish taste and is very astringent. It is used as an astringent in the leather and textile industries, in sizing paper, as a mordant in dyeing, in medicines as an astringent and styptic, and in baking powder. It is an important water-purifying agent. From a water solution it crystallizes out, forming positively charged particles which attract the negatively charged organic impurities, thus purifying the water as they settle out. Alum has a specific gravity of 1.757, melts in its water of crystallization at  $92^\circ\text{C}$ , and when heated to redness is converted to Burnt alum, a porous, friable material which dissolves slowly in water. Alum is marketed as USP, lump, pea, nut, ground, and powdered. The rice crystal alum of the General Chemical Co. is from 10 to 30 mesh, and the granular is from 30 to 60 mesh.

Alumstone is a gray or pinkish massive form of alunite found in volcanic rocks. A pure variety from Italy is called Roman alum, or Roche alum. The alunite of Australia is used to produce Potassium sulphate,  $\text{K}_2\text{SO}_4$ , for fertilizer, and the residue, containing 50% alumina, is used for aluminum production. Soda alum, in which the potassium is replaced by sodium, occurs naturally in the South American Andes as the mineral Mendozite. It is more soluble than alum, but is more difficult to purify. Filter alum, also called Patent alum and Aluminous cake, used for waterworks filtration, is Aluminum sulphate,  $\text{Al}_2(\text{SO}_4)_3$ , plus a varying amount of water of crystallization.

In the anhydrous form it is used as a dehydrating agent for gases. It is a white crystalline solid readily soluble in water. When filter alum contains a slight excess of alumina it is called basic.

Commercial aluminum sulphate is also called Concentrated alum, and replaces potash alum for many uses because of its cheapness. It comes in colorless crystals having a strong astringent taste, and is used as a mordant in dyeing, in water purification, sizing papers, tanning, in printing inks, and in dry colors. For use in pickling and tanning leathers, it contains not more than 0.01% iron oxide. Ammonia alum, used in tanning sheepskins and fur skins, and in fireproofing and dyeing textiles, is Ammonium-aluminum sulphate,  $\text{NH}_4\text{Al}(\text{SO}_4)_2 \cdot 12\text{H}_2\text{O}$ , a colorless or white crystalline powder soluble in water and, like other alums, insoluble in alcohol. It is valued for water purification because it forms chloramine, and is also used in vegetable glues and porcelain cements. For uses where an alkaline instead of an acid solution is required, Sodium phosphoaluminate is employed. It is a white, water-soluble powder, and is a double salt containing about 70% sodium aluminate and 20 sodium orthophosphate, with the balance water.

**Alumina.** The oxide of aluminum,  $\text{Al}_2\text{O}_3$ . In natural or artificial crystalline form it is used as an abrasive under the name of aluminum oxide. It is widely distributed in nature in combination with silica and other minerals, and is an important constituent of the clays for making porcelain, bricks, pottery, and refractories. The Alumina clay from the large deposits in western Idaho contain an average of 20%  $\text{Al}_2\text{O}_3$ , 5.6 iron oxide, and a high percentage of titanium oxide. Such clays are used for ceramics, but the oxide, alumina, is obtained commercially only from high-grade ores, chiefly bauxite.

Pure alumina is a white amorphous powder, or it may be in nearly colorless crystals, with melting point at  $3686^\circ\text{F}$ . The chief uses are for the production of aluminum metal and as an abrasive. It is also used for making ceramic insulators, pigments, catalyst carriers, grinding balls, and in chemicals. Activated alumina is partly dehydrated aluminum trihydrate, which has a strong affinity for moisture or gases and is used for dehydrating organic solvents. Hydrated alumina is Aluminum trihydrate,  $\text{Al}_2\text{O}_3 \cdot 3\text{H}_2\text{O}$ , used as a catalyst carrier. At elevated temperatures it becomes active, and the fine powder is an

auxiliary catalyst. This material is also used as a filler in plastics and cosmetics. Activated alumina F-1, of the Aluminum Co. of America, is a porous form of alumina,  $\text{Al}_2\text{O}_3$ , used for drying gases or liquids. It will remove moisture up to 15% of the dry weight of the alumina. Activated alumina F-6 is this material impregnated with cobaltous chloride which will change color from blue through pale pink to white with progression of the adsorption of moisture. Activated alumina is also used as a catalyst for many chemical processes. Aluminum hydroxide is a white bulky water-insoluble fine powder of specific gravity 2.42 and refractive index 1.535, used as a base for lake pigments, for making gloss white, and as a water-repellent agent in textile and paper coatings. Hydrated alumina C-741 is this material with particles coated with stearic acid for use as a reinforcing pigment for rubber.

Calcined alumina is alumina that has been calcined to a degree that prevents adsorption of more than 0.5 to 2% moisture. It comes in fine powder and is used for electrical insulators, abrasives, and in ceramic mixes. As a refractory for such uses as gas burner tips, alumina will withstand temperatures above 3000°F. The molded material has little porosity or shrinkage, and retains its strength and electrical resistance at high temperatures. It is also resistant to oxidizing and reducing gases. For refractories, a low-soda alumina, with less than 0.15%  $\text{Na}_2\text{O}$ , is used. Tabular alumina is alumina converted to the corundum form by calcining at temperatures below the fusing point, and is marketed as a fine powder or as coarse granules for electrical insulators and refractories. Alumina balls are marketed in sizes from  $\frac{1}{4}$  to  $\frac{3}{4}$  in. for use in heat exchangers, and for reactor and catalytic beds. They are 99% alumina, having high resistance to heat and chemicals, and high heat conductivity. Alumina A-14, of the Aluminum Co. of America, is a calcined alumina for high-grade electrical insulators and ceramics, having 95% min alpha alumina and not more than 0.08% soda. The particle size is 2 to 3 microns. Alumina Al-200, of the Coors Porcelain Co., for high-frequency insulators and ceramic nozzles, gives a molded product with a tensile strength of 25,000 psi, compressive strength of 290,000 psi, and specific gravity 3.36. The coefficient of thermal expansion is half that of steel, and the hardness is about that of sapphire. Alfrax is the trade name of the Carborundum Co. for alumina as a catalyst

carrier and as a refractory. Catalyst carriers are usually bonded into pellets that are 40% porous.

**Aluminum.** Called Aluminium in England. (A white metal with a bluish tinge, symbol Al, atomic weight 26.97, obtained chiefly from bauxite. It is the most widely distributed of the elements next to oxygen and silicon, occurring in all common clays, but it is difficult to extract.) The metal was discovered in 1727, but was obtained only in small amounts until it was reduced electrolytically in 1885. (Aluminum has a specific gravity of 2.70, melting point of 658.7°C, is resistant to corrosion and to many chemicals, but is dissolved by alkalis and hydrochloric acid. It is nonmagnetic, even when highly alloyed with iron. Its physical properties are greatly affected even by slight additions of other elements. A commercial aluminum 99.2% pure may have a strength 25% greater than 99.9% pure aluminum because of the alloying elements, but will be harder. Pure aluminum is next to gold in order of malleability. The tensile strength of cast aluminum is 12,000 psi, with elongation 30% and a Brinell hardness 30. Annealed wrought aluminum, 99.9% pure, has a tensile strength of 9,000 psi, and elongation 60%. The electrical conductivity is 63% that of copper, and the coefficient of expansion is 0.0000137.) This grade is used for electrical conductors.)

The chief impurities in commercial aluminum are copper, iron, and silicon, but sheet aluminum averages 99.3% pure. Alcoa 2S is commercially pure aluminum, 99+ % pure, of the Aluminum Co. of America. It has a specific gravity of 2.72, tensile strength, annealed, of 13,000 psi, elongation 35%, and Brinell hardness 23. When cold-rolled, the tensile strength is 24,000 psi, elongation 5%, and Brinell hardness 44. Alcoa EC, or electrical conductivity grade, is 99.45% min purity to give a conductivity 61% min that of copper. In Norway a grade of aluminum equivalent to anodized 2S has been used for packing fish and meat products instead of tinplate.) Most of the aluminum used for structural products is in the form of alloys. Because of its high strength-weight factor a large part of the production of aluminum goes into transportation equipment and moving parts of machinery. It is also used for ornamental architectural work, containers, cooking utensils, chemical equipment, and for making parts where the light weight and easy working properties are

valued. The metal is transparent to X rays, and is used in thin sheets as ray filters. It extrudes easily, and is used to replace tin alloys for collapsible tubes. In powder and flake form it is used in paints and fireworks, thermit welding, and as a catalyst in organic synthesis.)

Anodized aluminum, originally called Eloxal in Germany, is aluminum treated by electrolytic deposition to give a hard surface coating of aluminum oxide 0.1 to 0.6 mil in thickness to protect the metal from further oxidation. Alumilite is anodized aluminum of the Aluminum Co. of America. Alzak is a bright anodized finish for reflectors. The thickness of the coating is less than 0.0002 in., but it gives a light reflectance of 79%. The reflectivity of polished aluminum is high for all wave lengths. Anodized aluminum can be colored to many shades by chemical treatments. The MHC finish of the Glenn L. Martin Co. consists of an electrochemical coating of aluminum oxide on aluminum to give a wear-resistant surface.

**Aluminum alloy.** Originally the term aluminum alloy, when not further qualified, referred to Aluminum-copper alloys with or without small amounts of other alloying elements. The original Duralumin, of the Durener Metallwerke, contained 4% copper, 0.5 magnesium, and 0.5 manganese. Copper hardens and strengthens aluminum, and also gives age-hardening properties, especially when a small amount of magnesium is present. This alloy rolls well, but is subject to intercrystalline corrosion unless anodized or clad with pure aluminum. The annealed alloy has a tensile strength of 28,000 psi, elongation 22%, and Brinell hardness 50. Federal specifications for aluminum alloy in wrought form call for 3.5 to 4.5% copper, 0.2 to 0.75 magnesium, and 0.4 to 1 manganese. Alcoa 17S, of the Aluminum Co. of America, has a nominal composition similar to Duralumin, with tensile strength when annealed of 26,000 psi, and 62,000 psi when rolled hard and heat-treated.

Aluminum alloys are now classified by their general use characteristics rather than by composition groups, as wrought alloys for construction and manufacturing uses, sand-casting alloys, permanent-mold casting alloys, and die-casting alloys. These alloys are usually given a number with letter symbols to designate the physical condition and treatment, accompanied by the name of the company, or a com-

pany trade name, such as Alcoa alloys of the Aluminum Co. of America and Bohnalite of the Bohn Aluminum & Brass Corp. Some early aluminum alloys were Aldrey, Aludur, Pantal, Alferium, Almag, Similac, Sigmalium, Partinium, Arional. Superduralumin was a duralumin-type alloy with 1.25% silicon. Anticorodal, a German aircraft alloy, had 1% silicon, 0.5 manganese, and 0.5 magnesium. Aerolite had only 1.15% copper, with magnesium, silicon, and zinc in small amounts. The French alloy Almasilium had 2% silicon, while the German Lantal had 2% silicon with some titanium. The Hiduminium alloys developed by the Rolls-Royce laboratories were originally improvements on the German alloys and contained titanium and nickel.

Zinc and tin in aluminum alloys cause hot-shortness, but zinc adds strength, and when balanced with other elements good physical properties are obtained. Magnesium forms a silicide with the silicon present, and also gives age-hardening. Titanium in small amounts increases corrosion resistance. Iron in small amounts increases strength, but causes hot-shortness and intercrystalline corrosion. A small amount of lead gives good machining characteristics for screw-machine work. Alcoa 11S is an alloy of this kind, with 5.5% copper, 0.5 lead, and 0.5 bismuth. It has a tensile strength of 55,000 psi, with elongation 15%, and Brinell hardness 95. Nickel and chromium are also used in some alloys.

Alcoa 24S is used in sheet form, and comes in various tempers and treatments. It contains 4.5% copper, 1.5 magnesium, and 0.6 manganese. The Alclad 24S-T4 has a tensile strength of 64,000 psi, and elongation 19%. Alcoa 61S, used for forging aircraft and marine parts, has 0.25% copper, 0.6 silicon, 1 magnesium, and 0.25 chromium. It is corrosion-resistant, and has a tensile strength of 45,000 psi, elongation 17%, and Brinell hardness 95. This alloy has been used for precision extruded seamless tubing for such parts as mechanical pencils. Reynolds alloy R-301 contains 4.5% copper, 1 silicon, 0.8 manganese, 0.4 magnesium, and may have up to 1% iron and 0.1 chromium. It has a tensile strength of 65,000 psi. It is marketed as a clad metal with a coating containing 1% magnesium and 0.5 manganese for added corrosion resistance. Aluminum alloy 150S, of the Permanente Products Co., is a general-utility sheet metal for drawing and forming. It contains 1.5% magnesium, 0.50 silicon, 0.80 iron,

and small amounts of copper, chromium, zinc, and manganese. In the soft state it has a tensile strength of 21,000 psi, and elongation 25%. It gives a lustrous buffed finish, or a satin anodized finish. Alcoa 63S, which has been used for tubing, oil-pipe lines, and architectural extrusions, has up to 0.85% magnesium, 0.2 to 0.6 silicon, 0.35 max iron, and 0.10 max each of copper, zinc, chromium, and titanium. It has a tensile strength of 30,000 psi, elongation 20%, and Brinell hardness 42.

Aluminum-chromium alloys are used for wrought applications. An alloy developed by the Stockholm Metallographic Institute under the name of Cromal contained 2 to 4% chromium with small amounts of nickel and manganese. The alloy designated as aluminum-chromium alloy in Federal specifications contains 1.1 to 1.4% magnesium and 0.30 chromium. But present commercial alloys contain only small amounts of chromium as a balancing element rather than as a main constituent. For marine and architectural applications, Alcoa 52S may be used as a stronger metal than commercial aluminum. In the  $\frac{3}{4}$ -hard condition it has a tensile strength of 39,000 psi, elongation 10%, and Brinell hardness 74. Alcoa 52S is an alloy with forming characteristics similar to commercial aluminum. It contains 1.3% magnesium, 0.7 silicon, and 0.25 chromium. Alcoa 51S and Bohnalite S51, for such uses as drawn tubing, have 1% silicon, 0.6 magnesium, and 0.25 chromium. Alcoa 51S has a tensile strength of 40,000 psi, elongation 17%, and Brinell hardness 100. Alcoa 56S has a high proportion of magnesium, and is used for wire and for rivets for joining magnesium alloys. It contains 5.2% magnesium, 0.1 manganese, and 0.1 chromium. It is very ductile in the soft state. In the hard condition it has a tensile strength of 62,000 psi, and elongation 6%.

Alloys designated as Aluminum-manganese alloy in ASTM and Federal specifications contain 1 to 1.5% manganese, with small allowable percentages of copper, iron, silicon, and zinc. Many aluminum alloys contain some manganese, but Alcoa 3S contains 1.2% manganese and no other alloying element. This alloy, in the  $\frac{3}{4}$ -hard condition, has been used for making cans. The tensile strength is 25,000 psi, and elongation 14%. Bohnalite S53 is a similar alloy. The Swiss alloy called Aluman, used for corrugated roofing, is also similar. Alcoa 4S has 1.2% manganese and 1 mag-



nesium. This is a very ductile alloy in the soft condition, and the tensile strength is increased about 50% in the hard temper. The tensile strength, soft, is 26,000 psi, with elongation 25% and Brinell hardness 45. Acieral is a European alloy of this class. Navalium is a name given by the British Institute of Naval Architects for Al-Mn-Mg alloys. The alloys containing magnesium form an anodic film on the outside which retards further corrosion. The German alloy known as Seewasser alloy had 2.25% magnesium and 0.2 antimony, and formed a protective coating of antimony oxychloride on the surface.

The most commonly used sand-casting alloys have about 7% copper with silicon or magnesium, or both, and sometimes zinc. They are made by adding a Hardener alloy to the aluminum melt, the hardener alloy containing nominally 50% copper and 50 aluminum, but with an allowable content of zinc, silicon, or other elements. SAE alloy 33 and BES alloy 3-L-11 are made in this way. The English alloys BES No. 362 and BES No. L8 have 11 to 13% copper. Alcoa 112 has 7% copper and 1.7 zinc, and Alcoa 113 has the same copper and zinc with 2% silicon. These alloys have a tensile strength of 24,000 psi, elongation 1.5%, and Brinell hardness 70. Alcoa 43 is an Aluminum-silicon alloy with 5% silicon. Tensile strength is 19,000 psi, with elongation 6%. This alloy is resistant to shock, and is widely used. This type of alloy is also easy to cast and is resistant to corrosion, and finds use for architectural castings.

For strong heat-treated castings, alloys with about 4% copper and a small amount of silicon or magnesium are used. Bohnalite B has 4.5% copper and 0.3 magnesium. Alcoa 195, with 4.5% copper and 0.8 silicon, develops a tensile strength of 32,000 psi with 8.5% elongation, or 40,000 psi with 2% elongation. Alcoa 212, with 8% copper and 1.2 silicon, is a general-purpose casting alloy. Alcoa 122 and Bohnalite J have 10% copper with a slight amount of magnesium. This type of alloy has a good balance of physical properties and is used for pistons. Aluminum-magnesium alloys, with a high percentage of magnesium, have a high combination of tensile and yield strengths, elongation, and resistance to impact. The original German alloy, invented by Dr. Ludwig Mach and called Mach's metal, contained 5% magnesium, and his Magnalium contained 10%. Ulmal was a German alloy with 10% magnesium, 1 silicon, and 0.50 manganese. Alcoa 220 and SAE alloy 324 have 10% magnesium. Ten-

sile strength is 46,000 psi, elongation 14%, and Brinell hardness 75. Aluminum alloy MG-7, of High Duty Alloys, Ltd., is a strong, corrosion-resistant alloy with 7% magnesium, 0.60 manganese, and 0.75 iron. Birmabright is a similar English alloy for salt-water resistance. Small amounts of lead may be added to this type of alloy for free-machining qualities, but it lowers the strength and ductility. Alcoa 214, with 3.8% magnesium, is used for architectural castings because of its good white color when anodized. With a small amount of silicon added, it casts more easily in difficult sections, but the color is not as white.

Aluminum-nickel alloys are favored for such uses as pistons and cylinder heads because of a low coefficient of thermal expansion. A very early alloy called Bersh metal was high in nickel and was used for bearings. Batterium metal, developed by the British National Physical Laboratory, was an aluminum alloy with copper and nickel. The Y-alloy developed by this laboratory had 4% copper, 2 nickel, and 1.5 magnesium. Alcoa 142, also called Lo-Ex alloy, has approximately this composition. Tensile strength is 28,000 psi, with elongation 2% and Brinell hardness 75. Bohnalite Y has about the same composition as Y-alloy, and an alloy called Nickeloy by the Western Electric Co. has a similar composition. Neonalum and Meral were German and Swiss alloys of this type. Magnalite, of the Walker M. Levett Co., and BES alloy L-24 are Y-alloy types. The modified Y-alloys developed by the Rolls-Royce laboratories and produced by High Duty Alloys, Ltd., as Hiduminium, contain lower percentages of copper with some titanium. R-R 50 alloy has 1.2% copper, 1.3 nickel, 0.1 magnesium, 0.18 titanium, and 2.2 silicon. R-R 53 alloy has 2.2% copper, 1.3 nickel, 1.6 magnesium, 0.08 titanium, 1.2 silicon, and 1.4 iron. This alloy was used for die castings. Alcoa 750 has 1% copper, 1 nickel, and 6.5 tin, and is used for engine bearings and bushings. The permanent-mold castings have a tensile strength of 20,000 psi, elongation 10%, and Brinell hardness 45.

Beryllium in small amounts is added to some aluminum alloys. During the Second World War the Germans had very little beryllium, and they used most of the available supplies for adding to aluminum alloys for aircraft castings. It aids the casting, and also increases strength and age-hardening ability. Cerium is also added to some alloys to give a fine grain structure and to increase strength and hard-

ness. Aluminum alloys are marketed under a wide variety of trade names; some have special alloying elements to give particular characteristics while others have company trade names to designate a uniform quality. The French Benet metal is an Al-Mg alloy with a small amount of tungsten to add ductility. The German Ultralumin was a variant of Duralumin. The English Fairey metal was a duralumin-type alloy adapted for forgings. Aeron was a German aircraft alloy of the duralumin type with higher manganese. Titanite, of the Aluminum Smelting & Refining Co., is an Al-Mn casting alloy containing titanium. Londal is a name for wrought alloys of the London Aluminium Co., Ltd. Permite designates aluminum alloys of Aluminum Industries, Inc. Hyblum are wrought alloys of the Sheet Aluminum Corp. Tennal is the name of casting alloys of the National Bronze & Aluminum Foundry Co., and Weisalloy is sheet aluminum of the Henry Weis Mfg. Co.

**Aluminum brass.** There are two distinct types of aluminum brass. The first is a casting brass in which a small amount of aluminum acts as a flux to eliminate impurities and give the brass greater fluidity for intricate castings. The excess of aluminum remaining in the alloy is usually not more than 0.50%. The addition of aluminum also permits the use of higher percentages of lead up to about 5%, making the castings easy to machine. The second type is wrought brass modified with aluminum, producing alloys with properties between the brasses and the aluminum bronzes. Even slight additions of aluminum, dispersed as metal in the alloy and not as oxide, improve the oxidation resistance of brasses, and brass with as little as 0.10% of aluminum will have a bright color when extruded or forged. Larger amounts increase the strength and hardness, but decrease the ductility.

A 60-40 brass containing 1% aluminum has its strength increased about 30% and its hardness about 25%. Revalon, of Revere Copper & Brass, Inc., contains 76% copper, 22 zinc, and 2 aluminum, and is used for condenser tubes. The soft alloy has a tensile strength of 62,000 psi, elongation 50%, Rockwell B hardness 33, while the hard-drawn material has a tensile strength of 83,000 psi, elongation 15%, and hardness 86. It has 22.5% of the electrical conductivity of copper, and is very corrosion-resistant. Ambraloy 927, of the American Brass Co., has the same composition and properties. This alloy is

known in England as High-tensile brass. Ad-aluminum, of the Chase Brass & Copper Co., has 82% copper, 15 zinc, 2 aluminum, and 1 tin. Alconic, of the Scovill Mfg. Co., is a 70-30 brass modified by replacing some zinc with 2% aluminum and 1 nickel.

**Aluminum bronze.** A copper-aluminum alloy with aluminum as the chief alloying element, with or without other alloying materials. Plain additions of aluminum to copper increase the strength up to three times that of the original copper, and change the color from red to pale gold. The commercial alloys usually contain from 5 to 10% aluminum. Single-phase alpha alloys up to 7% aluminum have the structure of pure copper with the aluminum in solid solution, and the alloy is tough and ductile. At about 7.5% aluminum the structure changes from homogeneous to duplex, and the alloy becomes increasingly hard and difficult to cold-work. Chemical control of the alloy is important, as free aluminum oxide may make hard spots. Deoxidizers refine the grain size. Iron is the most common metal used for refining the grain, but nickel, manganese, and zinc affect it in varying degrees.

All of the alloys are resistant to corrosion. They can be cast or forged, but the high-aluminum alloys are difficult to machine because of free aluminum oxide present. The duplex alloys can be hardened by quenching from a high temperature, and drawn. Aluminum bronze is used for high-strength and nonmagnetic parts, condenser tubes, and corrosion-resistant chemical equipment. The hard crystals in a soft matrix make it useful for bearings. The alloys high in aluminum are used for architectural castings to contrast in color with aluminum-silicon alloys.

Standard aluminum bronze for castings contains 8% aluminum. It has a tensile strength, annealed, of 76,000 psi, elongation 55%, and Brinell hardness 125. When hardened, the tensile strength is 134,000 psi, elongation 13%, and hardness 240. The weight is 0.293 lb per cu in, and the melting point 1940°F. Ambraloy 928, of the American Brass Co., and Revere alloy 430, of the Revere Copper & Brass, Inc., have this composition but are wrought alloys. The hard-drawn rod has a tensile strength of 125,000 psi, with elongation 5%. Revere alloy 429 has 95% copper and 5 aluminum. In hard-drawn condenser tubes it has a tensile strength of 70,000 psi, and elongation

25%. Atlas 90, of Ampco Metals, Inc., contains 10% aluminum, and has a tensile strength of 90,000 psi min.

Additions of iron to aluminum bronze increase the strength, refine the grain and reduce the tendency to self-anneal, and improve forging qualities. The copper-aluminum-iron alloys are used for cast dies, gears, and strong wear-resistant parts. They have a hardness up to 325 Brinell. McGill metal, of the McGill Metal Co., is the name of a group of these alloys. A typical analysis is 89% copper, 9 aluminum, and 2 iron. This alloy has a tensile strength up to 90,000 psi, elongation 10 to 20%, and Brinell hardness 160. It is a casting metal, but can be forged, and it machines about the same as medium carbon steel. A casting alloy used for aircraft engine parts, with 10% aluminum and 1 iron, has a tensile strength of 75,000 psi, and Brinell hardness 100. This is Lumen alloy 11-C, of the Lumen Bearing Co., and Grade B in Federal specifications, Grade A having more iron and less aluminum. U.S. Navy aluminum bronze 46B-186 has 7 to 9% aluminum and 2.5 to 4.5% iron. This is SAE alloy 68, and has a tensile strength of 80,000 psi. Daraloy 437, of the Darling Valve & Mfg. Co., is a standard Grade A aluminum bronze used for valve stems, facings, and pressure castings. The tensile strength is 80,000 psi, elongation 18%, and Brinell hardness 90. Resistac, of the American Manganese Bronze Co., has 9% aluminum and 1 iron. When heat-treated, the tensile strength is 90,000 psi, and Brinell hardness 90. Avialite, a similar composition of the American Brass Co., is used for die-pressed parts and for heat-resistant parts for aircraft engines. Atlas 89, of Ampco Metals, Inc., is also this alloy. Ampco metal 12 has 8.5 to 9.3% aluminum and 2.5 to 3.25 iron. The annealed metal has a tensile strength of 80,000 psi, elongation 40%, and Brinell hardness 131. A harder bronze is Ampco metal 18-22 with 10.3 to 11% aluminum and 3 to 4.25 iron. The tensile strength is 100,000 psi, elongation 6%, and Brinell hardness 223. Amcoloy 4640, of this company, is an extruded aluminum-iron bronze with tensile strength up to 105,000 psi, elongation 8 to 12%, and hardness 207 to 229. Ambraloy 930, of the American Brass Co., is a wrought metal with 8% aluminum and 2.5 iron, having a tensile strength of 125,000 psi.

Nickel is also used in aluminum bronzes, especially in those containing iron. It increases the corrosion resistance and produces dense castings suitable as hydraulic castings, but the alloys require more

care in casting. Aurómet 55, of the Aurora Metal Co., contains 76 to 80% copper, 10 to 12 aluminum, 4 to 6 iron, and 4 to 6 nickel. The wrought metal has a tensile strength of 110,000 psi, elongation 2%, and Brinell hardness 250. Small additions of titanium give strength to the aluminum bronzes and act as a deoxidizer. The bronzes containing manganese are classed with the superbronzes. Lead is sometimes added for bearing bronzes, or for free-cutting casting alloys. It reduces the strength rapidly, and only 1.5% is needed for free cutting, though larger additions may be made to increase frictional qualities. Atlas 10 bronze, of Ampco Metals, Inc., has 9% aluminum and 9 lead. The tensile strength is 50,000 psi, and Brinell hardness 55.

Calsun bronze, of the American Brass Co., has 2.5% aluminum and 2 tin. When soft, the tensile strength is 50,000 psi and elongation 30%; when hard-drawn into wire, the tensile strength is 135,000 psi and elongation 4%. Alloy 712, of the Bridgeport Brass Co., is a strong resilient wrought alloy used for flat springs, diaphragms, and small tubing for instruments. It is an aluminum-silicon bronze containing 3.5% aluminum, 1 silicon, and the balance copper. Rolled to spring temper it has a tensile strength of 114,000 psi, elongation 3%, and Rockwell B hardness 97. The electrical conductivity is 12% that of copper. When annealed, the alloy has a tensile strength of 65,000 psi with elongation 55%.

**Aluminum oxide.** An artificial corundum,  $Al_2O_3$ , made by fusing bauxite in an electric-arc furnace at a temperature above 4000°F, and then cooling slowly. The mass is then broken and crushed to grain sizes. When pure, it forms in colorless crystals, and this crystalline material is employed as an abrasive. It is preferred to corundum for most purposes because of its uniformity. The white aluminum oxide used for light-colored abrasive wheels for toolroom grinding is 99.5% pure crystalline aluminum oxide calcined. The term alumina is often used for aluminum oxide abrasives in fine powder forms, but usually it refers to aluminum oxide for other uses.

Aluminum oxide crystals are normally hexagonal in shape, and are minute in size. The larger grain sizes are made up of many crystals, which is a distinctive point from silicon carbide. The specific gravity is about 3.75, and the hardness is about 9 Moh. The chief impurity is titanium oxide, which is extremely hard. When hard, sharp

crystals are required, the highest grades of purity are employed; for average use, the material is generally preferred with some impurities.

Alundum 32, of the Norton Co., is aluminum oxide with each abrasive grain as a single crystal of pure alumina. In the manufacture the crystals grow in a matrix of chemically unstable glass. When the lumps are wet with water this calcium sulphite glass dissolves and leaves the crystals free. The cutting edges are thus the natural edges of the crystal, while in the ordinary crushed material some of the edges may be slag. The German Bikorit abrasive is a white lump material made by the fusion of calcined alumina. Dirubin is a pink-colored abrasive made in the same way except that a small percentage of chromic oxide is added to the alumina. Redurit is a black aluminous lump abrasive made by the fusion of bauxite without any reduction. It was used in wartime for abrasive paper and cloth, but was not suitable for grinding wheels.

Aluminum oxide abrasive is used for grinding wheels for the finishing of high-tensile metals such as hard steels and the hard bronzes. On abrasive paper and cloth it is used for finishing and sanding in the woodworking industries and for finishing hard and tough metals. For abrasive paper the grains are glued to one side of 40- to 130-lb kraft paper. The cloth is marketed in sheets or in belts, plain-glued or waterproof. The usual grain sizes for paper and cloth are No. 16 to No. 500. Grinding compounds for valve grinding are often aluminum oxide grains in oil. The grains are also marketed in kegs and cans in screened grain sizes to No. 240 and in fine flour to No. 600 for use as a metal-polishing abrasive to be glued to the periphery of polishing wheels. For abrasive wheels, there are 20 standard grain sizes from No. 8, the coarsest, which will pass through a screen having 8 openings per linear inch, or 64 per sq in., to No. 240, which will pass through a screen having 240 openings per linear inch. The grade of the wheel, or strength of the bond, is by letter designation, increasing in hardness from E to Z. The aluminum oxide abrasives in all forms are sold under trade names. Alundum, of the Norton Co., Aloxite, of the Carborundum Co., and Lionite, of the General Abrasives Co., Inc., are abrasives of aluminum oxide. Other trade names are Aluminoid, Aluminox, Alulion, Alobrant, Alowalt, Borolon, Borite, Idilite, Clevite, Natalite, Natumite, Bathite, Hytens, Adamite, Adalox, Metalite, Durundum, Sterlith, Staralox, Excelite, and Orelite.

The ultrafine Alumina abrasive powder of the Linde Air Products Co. for polishing glass and for fine grinding is of two kinds. Type A is an Alpha alumina with a hexagonal crystal with particle size of 0.3 micron, density 4.0, and hardness 9 Moh. Type B is a Gamma alumina with a cubic crystal with particle size under 0.1 micron, density 3.6, and hardness 8. Type A cuts faster, but Type B gives a finer finish.

**Aluminum palmitate.** One of the important metallic soaps. A yellow, massive salt, or a fine white powder of the composition  $\text{Al}(\text{C}_{16}\text{H}_{31}\text{O}_2)_3 \cdot \text{H}_2\text{O}$ , made by heating a solution of aluminum hydroxide and palmitic acid. It is soluble in oils, alkalies, and benzol, but insoluble in water, and is used in waterproofing fabrics, paper, and leather, and in paints as a drier. In finishing leather and paper it adds to the gloss. It is also used to increase viscosity in lubricating oils. Another material of the same class is Aluminum resinate,  $\text{Al}(\text{C}_{14}\text{H}_{27}\text{O}_2)_3$ , a brown mass made by heating rosin and aluminum hydroxide. Aluminum oleate,  $\text{Al}(\text{C}_{18}\text{H}_{33}\text{O}_2)_3$ , is a white salt of oleic acid used as a drier. Aluminum stearate,  $\text{Al}(\text{C}_{18}\text{H}_{35}\text{O}_2)_3$ , is a salt of stearic acid. It is repellent to water and is valued for waterproofing fabrics and as a drier, and in waterproofing concrete and stucco. It is also used to give adherence to dyes, and as a flux in soldering compounds. It is a white fluffy powder of 200 mesh, soluble in oils and in turpentine. Grades high in free fatty acid, up to 22%, do not gel readily and are useful as a flattening agent and suspending medium in paints. Grades low in free fatty acid have a thickening effect on solvents. Those with 5 or 6% are used in lubricating grease, and those with about 8% are used in paints.

**Aluminum powder.** Called Aluminum bronze powder when alloyed. The flaked powder used for paints is more properly termed Aluminum flake. Flake powder is made by a stamping process, and used as a pigment in paints and printing inks, in silvering rubber articles, and in plastics. The powder has a high ratio of surface to volume, and the dry powder will ignite easily. All of the grades used for paint contain a major proportion of "very fine," 300 to 400 mesh, and they are revolved in a drum with a lubricant to give luster and also leafing properties to form a metallic surface in the paint by capillary attraction. Aluminum powder burns with an intense heat,



but the powder used in calorizing and for pyrotechnics and explosives is not flaked and polished, but consists of particles of spherical shape free from grease. This powder is called Granulated aluminum, although this designation is also given to larger Aluminum pellets marketed for metallurgical purposes. Aluminum powder is also used for making aerated or porous concrete, and for thermit welding. Aluminum pellets are made by blowing molten metal or by crushing aluminum.

**Aluminum-silicon alloy.** Many aluminum alloys contain some silicon, but the term aluminum-silicon alloy usually refers to casting alloys with from 5 to 13% silicon. These high-silicon alloys are characterized by their ease of casting, corrosion resistance, lightness, and ease of welding. They cast well even in thin sections, but the strength decreases and they become more difficult to machine as the silicon increases. Additions of copper increase the strength and improve the machinability, and also add the property of age-hardening, but decrease corrosion and wear resistance. Slight additions of magnesium also give age-hardening by the formation of  $Mg_2Si$ . The high-silicon alloys also have good thermal conductivity, which makes them suitable for engine pistons and cylinders.

The first of the high-silicon alloys contained 13% silicon. The alloy has a specific gravity of 2.64, being lighter than aluminum. Tensile strength is 24,000 psi, and elongation 5%. Modification by the addition of a small amount of sodium or lithium increases the tensile strength of the 13% alloy to 32,000 psi, and the elongation to 10%. The Modified aluminum alloys were developed in Europe and were covered by patents. Alpax, developed by Aladar Pacz and produced by Light Alloys, Ltd., is a 13% alloy treated with sodium during the casting. The modified alloys were known in Germany as Silumin, and in Italy as Italsil. Telectal was a German alloy modified with lithium. Wilmil, of William Mills, Ltd., Birmasil, of the Birmingham Aluminum Casting Co., Ltd., and MVC aluminum alloy of Metropolitan-Vickers, were English alloys of this class. The 13% alloys are no longer in general use.

Aluminum die-casting alloys are usually high in silicon because of the casting qualities. Alcoa 13, with 12% silicon, has a tensile strength, die-cast, of 39,000 psi with elongation 2%. A modifica-

tion of this type of high-silicon alloy is used for forgings. Alcoa 32S, for forgings, has 12.2% silicon, 0.9 copper, 1.1 magnesium, and 0.9 nickel. The tensile strength of the heat-treated forging is 55,000 psi, elongation 9%, and Brinell hardness 120. Alcoa A132, for permanent-mold castings, has 12% silicon, 1.2 magnesium, 0.8 copper, and 2.5 nickel. The treated castings have a tensile strength of 47,000 psi, elongation 0.5%, and hardness 125. This type of alloy retains its strength well at high temperatures, and in the United States is preferred to the sodium-modified alloys.

Alcoa 384 is a 12% silicon die-casting alloy with also 3.8% copper. Its tensile strength is 46,000 psi, and elongation 1%. Alcoa 360, a die-casting alloy, has 9.5% silicon with 0.5 magnesium. Tensile strength is 44,000 psi with elongation 3%. Alcoa 380 has 9% silicon with 3.5 copper. Its tensile strength is 45,000 psi with elongation 2%. Alcoa 43 is a die-casting alloy with 5% silicon. It has a tensile strength of 30,000 psi with elongation 9%. This alloy in wrought form is widely used for architectural applications. It is similar to ASTM alloy No. 3 and Bohnalite S43. For architectural work it has an attractive white color. Navy alloy 2 is this material with small allowable additions of other elements. Many die-casting and permanent-mold alloys are used with a range of silicon from 5 to 9%, most of which also contain some copper and a small amount of magnesium. These alloys are designated by numbers or company trade names.

**Aluminum steel.** Any steel containing aluminum as an effective element. Aluminum in small quantities was first used in the Hadfield steels as a deoxidizer and to restrict grain growth by forming dispersed nitrides and oxides. It also increases the strength of the steel, but, if the residual aluminum remaining in the steel is considerable, the steel becomes brittle. Aluminum is much used for deoxidizing steel, but it does not usually remain in the steel. Low-alloy steels containing a small amount of aluminum will develop high strength and hardness when heat-treated, but the steels are normally used only as Nitriding steel for casehardening by the nitriding process. The process and the special steel compositions required were developed at the Krupp Works, and the American patents are held by the Nitralloy Corp. of America. Any steel will absorb some nitrogen under special conditions, and in casehardening by cyanide part of the hardness of

the case is due to nitrogen. But nitriding steels refer only to those intended to be subjected to nitriding atmospheres. A nitrided case is formed by heating the steel in an ammonia atmosphere to a temperature of 875°F for a long period and quenching. The ammonia gas decomposes, and the liberated nitrogen combines with the steel, forming nitrides of aluminum, chromium, and molybdenum. The surface hardness of nitrided steel may be as high as 1,200 Brinell, and the steel has a tensile strength up to 190,000 psi. Nitrided steels can be softened, or denitrided, by heating in a fused mixture of potassium and sodium chlorides, which frees the nitrogen as a gas.

A composition range of Nitralloy steel is 0.20 to 0.45% carbon, 0.75 to 1.5 aluminum, 0.9 to 1.8 chromium, 0.4 to 0.70 manganese, 0.15 to 0.60 molybdenum, 0.3 max silicon. Nitralloy is marketed by various steel companies. Nitrad, of the Firth-Sterling Steel Co., is also the name of a nitriding steel. Nitralloy steel is used for tools, gages, gears, and shafts. Unlike the soft core of ordinary case-hardened steels, it will have a tough core with hardness of 400 to 650 Brinell.

Steels containing aluminum are heat resistant and are used for heat-resistant parts and engine valves, but at low temperatures they are weak. Small amounts of aluminum may be added to the chromium steels for greater resistance to oxidation at high temperatures. A cast steel, Circle L18, of the Lebanon Steel Foundry, contains 7.5% aluminum, 37.5 chromium, and little carbon, but this class of heat-resistant alloy is not usually classed with the steels. Aluminized steel is not an alloy steel, but is sheet steel having aluminum sprayed or dipped on the surface and the metal subsequently heat-treated to produce an alloyed surface. Alplate, of the Reynolds Metals Co., is an Aluminum-coated steel made by subjecting the heated steel to the action of a reducing gas and then passing it through an aluminum bath. Aluminized steel, of the American Rolling Mill Co., has an aluminum coating on a soft steel sheet. It will withstand a temperature of 1000°F, and is more corrosion-resistant than tin plate.

**Aluminum-zinc alloy.** An alloy containing a considerable proportion of zinc, although important characteristics may depend upon elements other than zinc. The casting alloys have found greater use in Europe than in the United States. Zinc is a hardener of aluminum,

but the alloys are likely to be hot-short, to be subject to intercrystalline corrosion unless modified with other elements, and they are more difficult to cast than most other aluminum alloys. With high zinc they may be brittle. Skleron, a German alloy, contained 12% zinc, 3 copper, 0.6 manganese, 0.25 silicon, and a slight amount of lithium. Alneon contained 7% or more zinc, 2 to 3 copper, and some nickel. British Engineering Standards alloy BES 2L5 had 13% zinc and 2.7 copper. An early American alloy called Aeron was high in zinc. The wrought alloy Alcoa 72S, with 1% zinc, is used as a coating for Alclad products rather than as a structural material. The permanent-mold casting alloy Alcoa A214 has 1.8% zinc and 3.8 magnesium. Its tensile strength is 27,000 psi, elongation 7%, and Brinell hardness 60. It is tarnish-resistant, and is used for cast cooking utensils. Alcoa 113, with 1.7% zinc, 2 silicon, and 7 copper, is used to replace some silicon alloys where higher strength is needed. The tensile strength is 28,000 psi with elongation 2% and hardness 70 Brinell.

Tenzaloy, of the American Smelting & Refining Co., has 8% zinc, 0.8 copper, and 0.4 magnesium. The castings have good strength and machinability with heat-treatment. The French wrought alloy known as Zircral contains 7 to 8.5% zinc, 1.75 to 3 magnesium, 1 to 2 copper, 0.1 to 0.4 chromium, 0.1 to 0.6 manganese, and 0.7 iron and silicon. This alloy is corrosion-resistant, and has been used in aircraft construction. The tensile strength of drawn bars is about 80,000 psi, with elongation 9%.

Frontier 40E alloy, of the Frontier Bronze Co., contains 5.5% zinc, 1 iron, 0.5 magnesium, 0.5 chromium, 0.4 copper, 0.2 titanium, 0.3 manganese, and 0.3 silicon. It is corrosion-resistant, has a tensile strength of 35,000 psi, elongation 4%, and Brinell hardness 70 to 80. The wrought structural alloys containing zinc developed during the war have high strength and good working qualities. Alcoa 75S, of the Aluminum Co. of America, contains 5.1 to 6.1% zinc, 1.2 to 2 copper, 2.1 to 2.9 magnesium, 0.1 to 0.3 manganese, 0.15 to 0.4 chromium, 0.2 max titanium, 0.5 max silicon, and 0.7 max iron. In heat-treated sheet form it has a tensile strength of 77,000 psi, yield strength 67,000 psi, and elongation 12%.

**Amalgam.** A combination of a metal with mercury. The amalgams have the characteristic that when slightly heated they are soft

and easily workable, and become very hard when set. They are used for filling where it is not possible to employ high temperatures. A native Silver amalgam found in South America contains 26 to 95% silver. Native Gold amalgams are found in California and Colombia, and contain about 40% gold. Although native amalgams are chemical combinations of the metals, some of the artificial amalgams are alloys and others are compounds. Dental amalgams are prepared by mixing mercury with finely divided alloys composed of varying proportions of silver, tin, and copper.

Cadmium amalgam was formerly employed for filling holes in metals and was called Evans' metallic cement. It is a silvery white compound of the composition  $\text{Cd}_5\text{Hg}_8$ , with about 74% mercury, the excess mercury separating out on standing. It softens at about  $100^\circ\text{F}$ , and can be kneaded like wax, remaining soft for a considerable time and then becoming hard and crystalline. It is made by heating the mercury and introducing the cadmium in the form of thin sheet. Tin or bismuth may be added. Amalgams with an excess of cadmium are ductile and can be hammered into sheet. Bismuth amalgams are lustrous, very fluid combinations of mercury and bismuth, used for silvering mirrors. They are also added to white bearing metals to make them more plastic, and to fusible alloys to lower the melting point. Crilley metal was a self-lubricating bearing alloy containing bismuth amalgam. The binary amalgams of mercury and bismuth are usually too fluid for ordinary use.

The usual quaternary alloy has equal parts of bismuth, mercury, tin, and lead, with the proportion of mercury increased to give greater fluidity. A bismuth amalgam containing bismuth, lead, and mercury was used for lead pencils. A Mercury-thallium amalgam, with 8.5% thallium, which freezes at  $-76^\circ\text{F}$ , is used for thermometers for low readings. Mackenzie's amalgam is a two-part amalgam in which each part is a solid but becomes fluid when the parts are ground together in a mortar at ordinary temperatures. One part contains bismuth and mercury, and the other part contains lead and mercury. Sodium amalgam contains from 2 to 10% sodium. It is a silvery-white mass which decomposes water and can be used for producing hydrogen. Potassium amalgam, made by mixing sodium amalgam with potash, is a true chemical compound, and is used for amalgamating with other metals.

**Amber.** A fossil resin found buried in the countries along the Baltic Sea and in Madagascar. It is employed for making varnishes and lacquers and for ornaments. The original German name for the material was *Glassa*, and in early writings it is referred to by the Greek word *Elektron* and the Persian name *Karaba*. It was called *Vernice* by the Italian painters who used it as a varnish resin. Amber came from a coniferous tree, *Pinus succinifera*, now extinct. It is hard, brittle, tasteless but with an aromatic odor, and dissolves in acids. It is sometimes transparent, but usually semitransparent or opaque with a glossy surface, yellow or orange in color. It takes a fine polish. When rubbed, it becomes electrically charged. Amber contains succinic acid in a complex form, and the finest specimens are known as *Succinite*, although this is the name of an amber-colored garnet. The amber of Madagascar is prized for necklaces and pipe mouthpieces. It is semitransparent, wave-streaked, and honey-colored. Synthetic amber is a plasticized phenol-formaldehyde or other synthetic resin. Amberoid is reclaimed scrap amber pieces compressed into a solid, sometimes mixed with pieces of copal or other resin. It has the same uses as amber. Amber oil, distilled from scrap amber, is a mixture of terpenes, and is used in varnish.

**Ambergris.** A solid, fatty, inflammable substance of grayish to black color found in the intestines of some sperm whales or found floating in the ocean. It consists of a paste of indigestible matter from the octopus eaten by the whale. White amber, formed by aging in the ocean, is the finest quality. When dried it pulverizes to a fine dust. Ambergris has a peculiar sweet fragrance and is highly valued as a fixative in perfumes. In Asia it is used as a spice, and in Egypt for scenting cigarettes. Lumps weigh from a few ounces up to 600 lb.

**Amethyst.** A violet or purple transparent quartz. The color is due to manganese and iron oxides, and becomes yellow on heating. It has a density of 2.65, and hardness of 7 Moh. Amethyst is composed of alternate right- and left-hand crystals, and breaks with a rippled fracture instead of the conchoidal fracture of ordinary quartz. The crystals are doubly refractive. It is used for making pivot bearings for instruments, and for needles in recording machines. It is the most esteemed of the quartzes for cutting into gemstones, but only the deep and uniformly colored stones are used as gems and they are not

common. Any large amethyst of deep and uniform color is likely to be synthetic. The chief production of amethyst is in Brazil and Uruguay with some from Montana.

**Ammonia.** A gaseous compound of the formula  $\text{NH}_3$ . It was originally called Alkaline air and Volatile alkali, and later in water solution by the name of Spirits of hartshorn. Ammonia is a by-product in the distillation of coal, but is now produced by passing nitrogen and hydrogen gases and a catalyst through an electric arc. It is readily absorbed by water, which at  $60^\circ\text{F}$  takes up 683 times its own volume of the gas, forming a liquid commonly called ammonia, but which is Ammonium hydroxide, a colorless, strongly alkaline, and pungent liquid of the composition  $\text{NH}_4\text{OH}$  with a boiling point of  $38^\circ\text{C}$ . At  $80^\circ\text{F}$  it contains 29.4% ammonia,  $\text{NH}_3$ , in stable solution. It is also known as Ammonium hydrate and Aqua ammonia. It is used for the saponification of fats and oils, as a deodorant, for cleaning, as a bleaching agent, for etching aluminum, and in chemical processing. Ammonia gas is used in refrigeration, in nitriding steels, and in the manufacture of chemicals. Chlorine unites with ammonia to form Chloramines which are used as solvents and chlorinating agents and as disinfectants. Ammonia does not burn in the air, but a mixture of ammonia and oxygen explodes when ignited. Anhydrous ammonia is purified ammonia gas liquefied under pressure and put up in cylinders. At  $20^\circ\text{C}$  the liquid has a vapor pressure of 122.1 psi. The anhydrous ammonia used for controlled atmospheres for nitriding steel, bright annealing, and sintering metals is 99%  $\text{NH}_3$ , and is oxygen-free. When disassociated by heat each pound yields 45 cu ft of hydrogen and 11 cu ft of nitrogen.

Commercial Smelling salts, sometimes referred to as ammonia, is Ammonium carbonate,  $(\text{NH}_4)_2\text{CO}_3 \cdot \text{H}_2\text{O}$ , forming in colorless or white crystals. Methylamine,  $\text{CH}_3\text{NH}_2$ , a derivative of ammonia, is used in the tanning industry for unhairing skins, and as a catalyst and solvent in the manufacture of synthetic resins. It is a gas and, like ammonia, is soluble in water and handled in water solution. It is more inflammable than ammonia, a 40% solution having a flash point of  $20^\circ\text{F}$ , and the vapors are explosive in air. Another form. Dimethylamine, is more effective for unhairing. In water solution a hydrate is formed,  $(\text{CH}_3)_2\text{NH} \cdot 7\text{H}_2\text{O}$ , which has a low freezing

point,  $-16.8^{\circ}\text{C}$ . Isopropylamine,  $(\text{CH}_3)_2\text{CHNH}_2$ , is used as a replacement for ammonia for many chemical uses, and as a solvent for oils, fats, and rubber. It is a clear liquid of specific gravity 0.686, boiling point  $31.9^{\circ}\text{C}$ , freezing point  $-101^{\circ}\text{C}$ , and flash point  $-15^{\circ}\text{F}$ .

Hydrazine,  $\text{HN}:\text{NH}$ , is a liquid with boiling and freezing points close to those of water. It is used as a propellant fuel for rockets, yielding exhaust products of very high temperature and low molecular weights. With a nickel catalyst it decomposes to nitrogen and hydrogen, and it is a strong reducing agent. It is also used for the production of plastics and chemicals. For industrial applications it may be used in the form of Dihydrazine sulphate,  $(\text{N}_2\text{H}_6)_2\text{SO}_4$ , a colorless, crystalline, water-soluble flake containing 37.5% available hydrazine.

The ammonium radical,  $-\text{NH}_4$ , has the chemical reaction of an alkali metal and forms many important chemicals. The fertilizer, Ammonium nitrate, is made by the action of nitric acid on ammonium hydroxide. It is a colorless to white crystalline hygroscopic powder of the composition  $\text{NH}_4\text{NO}_3$ , specific gravity 1.725, melting point  $170^{\circ}\text{C}$ , decomposing at  $210^{\circ}\text{C}$ , and soluble in water, alcohol, and alkalies. It is also used in pyrotechnics, dental gas, insecticides, freezing mixtures, and explosives. The British explosive Amatol is a mixture of ammonium nitrate and TNT, which explodes violently on detonation. The 50-50 mixture can be melted and poured, while the 80-20 mixture is like brown sugar and was used for filling large shells. Macite, for tree-trunk blasting, is ammonium nitrate coated with TNT, with a catalyst to make it more sensitive. Ammonium perchlorate is another explosive made by the action of perchloric acid on ammonium hydroxide. It is a white crystalline substance of the composition  $\text{NH}_4\text{ClO}_4$ , specific gravity 1.95, is soluble in water, and decomposes on heating. Nitrogen trichloride,  $\text{NCl}_3$ , which forms in reactions of chlorine and ammonia when there is an excess of chlorine, is a yellow oil of specific gravity 1.653, which is highly explosive. Ammonium sulphate,  $(\text{NH}_4)_2\text{SO}_4$ , is a gray crystalline material soluble in water obtained in the distillation of coal, and used as a fertilizer and for fireproofing.

Ammonium chloride, or Sal ammoniac,  $\text{NH}_4\text{Cl}$ , is a white crystalline powder of specific gravity 1.52, used in electric batteries, textile



printing, as a soldering flux, and in making other compounds. Many salts and metallic soaps are also formed in the same manner as with the alkali metals. Ammonium vanadate,  $\text{NH}_4\text{VO}_3$ , is a white to yellow crystalline powder used as a paint drier, in inks, as a mordant for textiles, and in pottery mixes to produce luster. The specific gravity is 2.326, and it decomposes at  $210^\circ\text{C}$ . Ammonium lactate,  $\text{CH}_3\text{CHOHCOONH}_4$ , is a colorless to yellowish sirupy liquid with a slight odor of ammonia, used in leather finishing.

**Ammoniac.** A gum resin from the stems of the *Dorema ammoniacum*, a desert perennial plant of Persia and India. It forms in hard, brittle, brownish-yellow tears, and has a peculiar fetid odor and an acrid taste. It is used in adhesives, in perfumery, and as a stimulant in medicine. In pharmacy it is called Ammoniacum. Oil ammoniac is a yellow liquid distilled from the gum. The specific gravity is 0.890, boiling point  $275^\circ\text{C}$ , and it is soluble in alcohol and benzol.

**Amyl alcohol.** A group of monohydroxy, or simple, alcohols, which are colorless liquids and have the general characteristic that they have five carbon atoms in the molecular chain. Normal amyl alcohol,  $\text{CH}_3(\text{CH}_2)_4\text{OH}$ , called also Fusel oil, Grain oil, Pentanol, and Fermentation amyl alcohol, has a specific gravity of 0.82 and boiling point of  $137^\circ\text{C}$ . It is only slightly soluble in water. It is used as a solvent for oils, resins, varnishes, in the manufacture of amyl acetate, and in rubber vulcanization. Secondary amyl alcohol has a differently arranged molecule,  $\text{CH}_3\text{CHOH}(\text{C}_3\text{H}_7)$ . The specific gravity is 0.82, and flash point  $80^\circ\text{F}$ . It is used in the manufacture of secondary amyl acetate for lacquers, and in chemical manufacture. Tertiary amyl alcohol has the formula  $(\text{CH}_3)_2\text{C}(\text{OH})\text{C}_2\text{H}_5$ , and a camphorlike odor. The specific gravity is 0.81 and boiling point  $102^\circ\text{C}$ . It is slightly soluble in water, but soluble in alcohol and ether. It is used as a flavor, and as a plasticizer in paints, varnishes, and in cellulose plastics. Isoamyl alcohol, or Isobutyl carbinol,  $(\text{CH}_3)_2\text{CHCH}_2\text{CH}_2\text{OH}$ , has a flash point above  $80^\circ\text{F}$ . It is used in pharmaceutical manufacture. Amyl acetate,  $\text{CH}_3\text{COOC}_5\text{H}_{11}$ , called Banana oil because of the odor of bananas, is an ester made by the action of acetic acid on amyl alcohol. It is a colorless oily liquid of specific gravity 0.896 and boiling point  $141^\circ\text{C}$ . It is insoluble in water but soluble in alcohol. It is a good solvent and plasticizer for

cellulose plastics, and is used in cellulose lacquers and adhesives. It is also used in linoleum and oilcloth, and as a banana flavor.

**Aniline.** Also known as Aminobenzene and Phenylamine, and when first made was called Krystallin and Kyanol. A slightly yellowish, oily liquid used in the production of dyestuffs, drugs, perfumes, explosives, plastics, flavors, and many chemicals. With nitric acid as an oxidizer it has been used as a rocket fuel. It is found in coal tar and bone oil, or is made by the reduction of nitrobenzene. The composition is  $C_6H_5 \cdot NH_2$ , boiling point 182 to 185°C, solidifying point -6.2°C, and specific gravity 1.022. It is soluble in alcohol, ether, benzene, and hydrochloric acid. It turns brown in the air, finally oxidizing into a resin. It is marketed +99.5% pure. The vapors of aniline are toxic, and it is poisonous in contact with the skin. It has a powerful effect on the nervous system, and causes decomposition of the blood, requiring complete body insulation in handling.

**Animi gum.** A gum resin obtained from the stem of the plant *Hymenaca courbarii* of Zanzibar and East Africa, and employed in varnishes. It belongs to the group of East African copals, but is distinguished from copal by the ease of solubility in alcohol. The specific gravity is 1.062 to 1.068 and melting point about 245°C. It is also called Gum Zanzibar.

**Anise seed.** The seeds of the annual plant *Pimpinella anisum* grown in the Mediterranean countries and in India. The best grades come from Spain. The seed is used in flavoring in the baking industry. The distilled oil, Anise oil, is used in perfumes and in soaps, and in the liqueur known as Anisette. The oil contains choline, and is used in medicine as a carminative and expectorant.

**Annatto.** One of the chief Food colors. Any food color used commercially in the United States must be nontoxic in the quantities employed, and must be approved under the Food and Drugs Act. Annatto is a salmon-colored dye made from the pulp of the seeds of the tree *Bixa orellana* of the West Indies and tropical America and Africa. It contains Bixin,  $C_{25}H_{30}O_4$ , a dark-red crystalline material, and also Bixol,  $C_{18}H_{30}O$ , a dark-green oily alcohol. Annatto is sometimes called Bixine, and in West Africa it is called Rocou. It is

soluble in oils and in alcohol. Annatto paste is used as a food color especially for butter, cheese, and margarine. It is also used as a stain for wood and for dyeing silk. It was one of the original dyes used by the Indians. A substitute for annatto for coloring butter and margarine, having the advantage that it is rich in vitamin A, is Carrot oil obtained from the common carrot. The concentrated oil has a golden-yellow color and is odorless and tasteless. Carex is a name for carrot oil in cottonseed oil solution used for coloring foods.

A beautiful water-soluble yellow dye used to color foods and medicines is Saffron, extracted from the dried flowers and tips of the saffron crocus, *Crocus sativas*, of Europe, India, and China. It is expensive, as about 4,000 flowers are required to supply an ounce of the dye. Saffron contains Crocin,  $C_{44}H_{70}O_{28}$ , a bright-red powder soluble in alcohol. Safflower, from the orange-colored thistlelike heads of the plant *Carthamus tinctorius*, which are dried and pressed into cakes, produces both red and yellow colors. Besides its use as food color, it is employed for dyeing textiles and cosmetic rouge. The plant is grown in France and in India, and in the latter country it is produced on a large scale for safflower seeds which yield up to 35% of the clear, yellowish Safflower oil used in paints, leather dressings, and for foods.

Another nonpoisonous dyestuff used for coloring foods and in soaps is the green dye Chlorophyll. It is the characteristic coloring matter of all green plants, and is obtained by solvent extraction from the leaves of various plants. It is one of the most interesting of chemicals, and is a sunlight-capturing, food-making agent in plants. It is a complex chemical,  $C_{55}H_{72}O_5N_4Mg$ , its chief building block being Pyrrole,  $(CH:CH)_2NH$ , which can be obtained also from coal tar and bone oil. Chlorophyll is obtained as a crystalline powder soluble in alcohol and melting at  $183^{\circ}C$ . It combines with carbon dioxide of the air to form formaldehyde which is active for either oxidation or reduction of impurities existent in the air, changing such gases to methanol, formic acid, or carbonic acid. It is thus used in household air-purifying agents such as Air Wick and Wizard Wick. In plants, some of the formaldehyde is given off to purify the air, but most of it is condensed in the plant to form Glycollic aldehyde,  $HOCH_2CHO$ , the simplest carbohydrate, and also Glyccric aldehyde, another simple carbohydrate.

**Anode metals.** Metals used for the positive terminals in electroplating. They provide in whole or in part the source of the metal to be plated, and they are as pure as is commercially possible, uniform in texture and composition, and have the skin removed by machining. They may be either cast or rolled, with the manufacture controlled to obtain a uniform grade and to exclude impurities, so that the anode will corrode uniformly in the plating bath and will not polarize to form slimes or crusts. In addition to pure single metals, various alloys are marketed in anode form. The usual brass anode is 80% copper and 20 zinc, but other compositions are used, some containing 1 to 2% tin. Brass anodes are called Platers' brass. Copper anodes for metal plating are usually hot-rolled oval-shaped bars, 99.9% pure, while those for electrotype deposits may be hot-rolled plates, electro-deposited plates, or cast plates. The Copper ball anodes of the Udyllite Corp. are forged instead of cast to give a finer and more even grain. Zinc anodes are 99.9% pure. Nickel anodes are 99+%, rolled or cast in iron molds, or 95 to 97% sand-cast. Lead anodes have low current-carrying capacity, and may be made with a saw-tooth or multiple-angled surface and ribs to provide more area and give greater throwing power. Anodes of other metals are also made with sections gear-shaped, fluted, or barrel-shaped to give greater surface area and higher efficiency. Special anode metals are marketed under trade names, usually accenting the color, hardness, and corrosion resistance of the deposited plate, such as Spekwhite, of the Special Chemical Corp., which gives a white plate harder than nickel. Chilex is the name of a copper-silicon-lead-iron-tin alloy used for anodes in copper refineries. It is insoluble in the acid bath.

**Anthracite.** Also called Hard coal. A variety of mineral coal found in Wales, France, and Germany, but in greatest abundance in an area of about 500 sq mi in northeastern Pennsylvania. It is distinguished by its semimetallic luster, high carbon content, and high specific gravity, which is about 1.70. The carbon content may be as high as 95%, but the usual fixed carbon content is from 78 to 84%. It should give 13,200 Btu per lb. In theory the best grades of anthracite should have 90% carbon, 3 to 4.5 hydrogen, 2 to 5.5 oxygen and nitrogen, and only 1.7 ash. Anthracite, when pure and dry, burns without smoke or smell, and is thus preferred to bituminous coal for

household furnaces. But the coal will absorb a high proportion of water, and commercial coal may be wetted down to add to the weight, thus lessening its efficiency. Hard coal is graded as anthracite and Semianthracite, depending upon the ratio of fixed carbon to volatile matter. When the ratio is 10:1, it is anthracite.

The commercial gradings of anthracite are chiefly by size, varying from three sizes of very fine grains called silt, rice, and buckwheat, to the large size of furnace, or lump, coal. Standard ASTM sizes for anthracite are: broken,  $4\frac{3}{8}$  to  $3\frac{1}{4}$  in.; egg,  $3\frac{1}{4}$  to  $2\frac{7}{16}$  in.; stove,  $2\frac{7}{16}$  to  $1\frac{5}{8}$  in.; chestnut,  $1\frac{5}{8}$  to  $1\frac{3}{16}$  in.; pea,  $1\frac{3}{16}$  to  $\frac{9}{16}$  in.; No. 1 buckwheat,  $\frac{9}{16}$  to  $\frac{5}{16}$  in.; No. 2 buckwheat (rice),  $\frac{5}{16}$  to  $\frac{3}{16}$  in.; No. 3 buckwheat (barley),  $\frac{3}{16}$  to  $\frac{3}{32}$  in. As the coal comes from the breaker, the proportions are about 8% silt, 9 rice, 15 buckwheat, 10 pea, 24 chestnut, 23 stove, and 8 egg. Artificial anthracite, used extensively in Europe, is briquetted coals with a waterproof coating. It burns uniformly.

**Antifreeze compounds.** Materials employed in the cooling systems and radiators of internal-combustion engines to ensure a liquid circulating medium at low temperatures to prevent damage from the formation of ice. The requirements are that the compound must give a freezing point below that likely to be encountered without lowering the boiling point much below that of water, that it must not corrode the metals or deteriorate rubber connections, that it must be stable up to the boiling point, and that it must be readily obtainable commercially. Calcium chloride was early used for automobile radiators but corroded the metals. Oils were also used, but the high boiling points permitted overheating of the engine, and the oils soften rubber. Denatured ethyl alcohol is widely used for automobile radiators. Methanol, or wood alcohol, is less corrosive, but is normally not as available. A 30% solution of ethyl alcohol in water has a freezing point of about 5°F, and a 50% solution freezes at -24°F, which is sufficiently low for winter use in most localities in the United States. Alcohol, however, requires to be renewed frequently because of loss by evaporation.

Glycerol is also used as an antifreeze, a 40% solution in water lowering the freezing point to about 0°F, and a 50% solution to -15°F. It has the disadvantage of high viscosity, requiring forced

circulation at low temperatures, but it does not evaporate easily. Ethylene glycol lowers the freezing point to a greater extent than alcohol and has a high boiling point so that it is not lost by evaporation, but it has a higher first cost and will soften ordinary natural rubber connections. Acetamide in water solution may also be used as an antifreeze. Antifreezes are sold under various trade names. Zerone, of E. I. du Pont de Nemours & Co., Inc., has a methanol base, while Zerex has a base of ethylene glycol. Prestone, of the Union Carbide & Carbon Corp., is ethylene glycol antifreeze. Pyro is an antifreeze of the U.S. Industrial Chemicals, Inc., with a low freezing point. Calcium chloride is used as an antifreeze in fire tanks, sodium chromate being added to retard corrosion.

**Antimonial lead.** An alloy containing up to 25% antimony with the balance lead, used for storage-battery plates, type metal, bullets, tank linings, pipes, cable coverings, bearing metals, roofing, collapsible tubes, toys, and small cast articles. The alloy is produced directly in the refining of some lead ores, but much is also made by adding antimony to soft lead. The alloy is also known as Hard lead, and in England is called Regulus metal. Much of the lead used in the United States is in the form of antimonial lead. The antimony hardens the lead and increases the tensile strength. The usual alloy contains 4 to 8% antimony and has about twice the tensile strength of pure lead. Up to about 0.10% arsenic stabilizes and hardens the alloy, and from 0.25 to 1% tin may be added to improve the casting properties. Antimonial lead of the National Lead Co. for chemical linings contains 6 to 8% antimony, weighs 0.398 lb per cu in., and melts at 475 to 555°F.

A hard lead with 10% antimony and 90% lead has a tensile strength of 8,800 psi, elongation 17%, Brinell hardness 17, and melting point 486°F. Cable lead, used for cable sheathing, contains about 1% antimony. The alloy for collapsible tubes usually contains 2% antimony. Antimonial lead may be used for machine bearings, but for this purpose it usually contains considerable tin and is classed with the babbitt metals. Hoyt metal, used for bearings, contains 6 to 10% antimony. Alloys containing from 70 to 90% lead, 5 to 20 antimony, and 2 to 20 tin, have been used for railway car bearings under the name of Lining metal. Dandelion metal, used for loco-

motive crosshead linings by one railroad, is given as 72% lead, 18 antimony, and 10 tin.

**Antimony.** A bluish-white metal, symbol Sb, having a crystalline scalelike structure. It is brittle and easily reduced to powder. It is neither malleable nor ductile and is used only in alloys or in its chemical compounds. Like arsenic and silicon it is sometimes referred to as a Metalloid having the physical properties of a metal and the chemical properties of a nonmetal. The chief uses in metals are for battery plates, bearings, pipes, cable coverings, solder, and type metals. The specific gravity of the metal is 6.62, melting point 824°F, and Brinell hardness 55. It burns with a bluish light when heated to redness in the air. Antimony imparts hardness and a smooth surface to soft-metal alloys, and alloys containing antimony expand on cooling, thus reproducing the fine details of the mold. This property makes it valuable for type metals. When alloyed with lead, tin, and copper it forms the babbitt metals used for machinery bearings. It is also much used in white alloys for pewter utensils. Its compounds are used widely for pigments.

The chief antimony ore is stibnite, but much antimony is obtained from lead ores and is not separated but is left in the lead as hard lead. The metal antimony is marketed in flat cakes or in broken lumps. The highest grade of pure refined antimony is known as Star antimony because of the glittering spangled appearance on the surface, but the starring is done with lower grades of antimony by special cooling of the ingots. Crude antimony is not antimony metal, but is beneficiated ore, or ore matte, containing 90% or more of metal. High-grade antimony is +99.8% pure, Standard grade is 99 to 99.8% pure, and Chinese is 99% pure.

**Antimony ores.** The chief ore of the metal antimony is Stibnite, an impure form of antimony trisulphide,  $\text{Sb}_2\text{S}_3$ , containing theoretically 71.4% antimony. The usual content of the ore is 45 to 60%, which is concentrated to an average of 92% for shipment as matte. Sometimes gold or silver is contained in the ore. Stibnite occurs in slender prismatic crystals of a metallic luster and lead-gray color with a hardness of 2 Moh. The metal is obtained by melting the stibnite with iron, forming  $\text{FeS}$  and liberating the antimony, or by roasting the ore to produce the oxide which is then reduced with carbon. For

pyrotechnic uses stibnite is liquated by melting the mineral and drawing off the metal which on cooling and solidifying is ground. Stibnite comes from China, Mexico, Japan, Germany, Bolivia, Alaska, and western United States.

Senarmontite, found in Mexico, Nevada, and Montana, is Antimony oxide,  $\text{Sb}_2\text{O}_3$ , occurring in cubic crystals with a yellow color. The specific gravity is 5.2, hardness 2.5, and theoretical metal content 83.3%. Valentinite, also found in the same localities, has the same theoretical formula and antimony content as senarmontite, but has a rhombic crystal structure, a hardness of 3, and a specific gravity of 5.5. These oxides are used as opacifiers in ceramic enamels. Cervantite, found in Mexico, Nevada, and Montana, is Antimony tetraoxide,  $\text{Sb}_2\text{O}_4$ . It has a grayish-yellow color, a specific gravity of 5, hardness of 4.5, and contains theoretically 79.2% antimony. Stibiconite, from the same area, is a massive pale-yellow mineral of the composition  $\text{Sb}_2\text{O}_4 \cdot \text{H}_2\text{O}$ , with a specific gravity 5.1, hardness 4.5, and antimony content 71.8%.

Kermesite, known as Red antimony or Antimony blend, found in Mexico and Italy, is a mineral resulting from the partial oxidation of stibnite. The composition is  $\text{Sb}_2\text{S}_2\text{O}$ , and when pure it contains 75% antimony and 20 sulphur. It occurs in hairlike tufts, or radiating fibers of a dark-red color and metallic luster, with hardness 1.5 and specific gravity 4.5. Another sulphide ore of antimony is Jamesonite,  $\text{Pb}_{12}\text{Sb}_2\text{S}_{15}$ , found in Mexico and western United States. It has a dark-gray color, specific gravity 5.5, hardness 2.5, and contains 20% antimony. When the ore is silver-bearing, it can be worked profitably for antimony. Stephanite is classed as an ore of silver, but yields antimony. It is a Silver sulphantimonite,  $\text{Ag}_5\text{SbS}_4$ , containing 68.5% silver and 15.2 antimony. It occurs massive or in grains of an iron-black color with a hardness of 2 to 2.5 and specific gravity 6.2 to 6.3. It is found in Nevada, Mexico, Peru, Chile, and central Europe.

**Antimony red.** The common name of Antimony trisulphide,  $\text{Sb}_2\text{S}_3$ , also known as Antimony sulphide and Antimony sulphuret, found in impure form in the mineral stibnite, but produced by precipitation from solutions of antimony salts. It comes in orange-red crystals with a specific gravity of 4.56 and melting point  $546^\circ\text{C}$ . It is used as a paint pigment, for coloring red rubber and in safety



matches. Antimony pentasulphide,  $\text{Sb}_2\text{S}_5$ , an orange-yellow powder, was once used for vulcanizing rubber and it colored the rubber red. It breaks down easily when heated, yielding sulphur and the red pigment antimony trisulphide.

**Antioxidant.** A material used to retard oxidation and deterioration of vegetable and animal fats and oils, rubber, or other organic products. Antioxidants embrace a wide variety of materials but in general for antioxidant activity the hydroxy groups must be substituted directly in an aromatic nucleus. In the phenol group of antioxidants the hydrogen atoms must be free. In the naphthol group the alpha compound is a powerful antioxidant. A Synergist may be used with an antioxidant for regeneration by yielding hydrogen to the antioxidant. Synergists are acids such as citric or maleic. Usually, only minute quantities of antioxidants are used to obtain the effect. Ionol, an antioxidant, or Oxidation inhibitor, for rubber, is a tri-substituted phenol with alkyd groups. It is a clear to orange-colored granular powder melting at  $70^\circ\text{C}$ , insoluble in water. Norconidendrin, an antioxidant for fats and oils, is produced from the high-phenol, Confidendrin, obtained from hemlock pulp liquor. Tenox HQ, of the Tennessee Eastman Corp., used to prevent rancidity in margarine, dried milk, and cooking fats, is a purified hydroquinone. Tenox BHA is butylated hydroxy anisole, used for stabilizing lard and animal fats. The presence of small quantities of metallic impurities in oils and fats may deactivate the antioxidants and nullify their effect.

**Antislip metals.** Metals with abrasive grains cast or rolled into them, used for floor plates, stair treads, and car steps. They may be of any metal, but are usually iron, bronze, or aluminum. The abrasive may be sand, but it is more usually a hard and high-melting-point material such as aluminum oxide. In standard cast forms antislip metals are marketed under trade names. Alumalun is the name of an aluminum alloy cast with abrasive grains, made by the American Abrasive Metals Co. Bronzalun is a similar product made of bronze. The Algrip steel of the Alan Wood Steel Co. is steel plate  $\frac{1}{8}$  to  $\frac{3}{8}$  in. thick, with abrasive grains rolled into one face. It is used for loading platforms and ramps.

**Antler.** The bony, deciduous horns of animals of the deer family, used for making handles for knives and other articles. Antlers are true outgrowths of bone, and are not simply hardenings of tissue as are the horns of other animals. Unlike horn, antlers are solid, and have curiously marked surfaces. They are of various shapes and sizes, and are usually found on the male during the mating season, although both sexes of reindeer and American caribou possess them. They grow in from 3 to 4 months, and are shed annually. Antler is imitated by machine carving bone to reproduce the indented surface.

**Argentite.** An important ore of silver, also called Silver glance. It has the composition  $\text{Ag}_2\text{S}$ , containing theoretically 87.1% silver. It usually occurs massive, streaked black and lead gray, with a metallic luster and a hardness of 2 to 2.5. It is found in Nevada, Arizona, Mexico, South America, and Europe. Argyrodite is another silver ore found in Bolivia, and is a source of the rare metal germanium. When pure, it has the composition  $4\text{Ag}_2\text{S} \cdot \text{GeS}_2$ , and contains 5 to 7% germanium. A similar mineral, Canfieldite, found in Bolivia, has 1.82% germanium and some tin.

**Argols.** Also called Wine lees. A reddish crust or sediment deposited from wine, employed for the production of tartaric acid, cream of tartar, and rochelle salts. It is crude Potassium acid tartrate, or Cream of tartar,  $\text{KH}(\text{C}_4\text{H}_4\text{O}_6)$ . When grape fermentation is complete, the wine is drawn off and placed in storage tanks where the Lees settles out. The amount of tartrate varies in different types of wine, from 0.1 to 1.0 lb of cream of tartar per gallon. From wines clarified by refrigeration, as much as 1 to 3 lb per gal of tartrate crystallizes out. Cream of tartar is also obtained from Grape pomace, which is the residue skins, seeds, and pulp, containing 1 to 5% tartrate. The grape pomace is used for fertilizer and animal feed. Wine stone is cream of tartar, 70 to 90% pure, which crystallizes on the walls of wine storage tanks. Purified cream of tartar is a colorless to white crystalline powder of specific gravity 1.956, soluble in water, used in baking powders.

Tartaric acid is a colorless crystalline product of the composition  $\text{HOOC}(\text{CHOH})_2\text{COOH}$ , with melting point  $170^\circ\text{C}$  and soluble in water and in alcohol. It has a wide variety of uses in pharmaceuticals,

and in effervescent beverages, and as a mordant in dyeing. The pods of the tamarind tree, *Tamarindus indica*, of India, contain 12% tartaric acid and 30 sugars. They are used in medicine and for beverages under the name of Tamarind. Rochelle salts is Potassium sodium tartrate,  $\text{KNa}(\text{C}_4\text{H}_4\text{O}_6) \cdot 4\text{H}_2\text{O}$ , a colorless to bluish-white crystalline solid of specific gravity 1.79, melting point  $75^\circ\text{C}$ , and soluble in water and in alcohol. It is used in medicines and in silvering mirrors. Like quartz, it is doubly refractive, and is used in piezoelectric devices where the water solubility is not a disadvantage, as in phonograph pickups.

**Argon.** A gaseous element, symbol A, occurring free in the atmosphere to the extent of 0.935%. Its liquefying point is about  $-187^\circ\text{C}$ . It is obtained by passing atmospheric nitrogen over red-hot magnesium, forming magnesium nitride and free argon. The density is about one and one-half that of air. It is an inactive element and forms no known compounds. Argon is employed in incandescent lamps to give increased light and to prevent vaporization of the filament, and it is used instead of helium for shielding electrodes in welding magnesium and aluminum.

**Arsenic.** A soft, brittle, poisonous element of steel-gray color and metallic luster, symbol As. The melting point is  $850^\circ\text{C}$ , and specific gravity 4.8. It is allotropic, with metallic and nonmetallic properties, and forms many compounds. When heated in the air, it burns to Arsenious anhydride with white odorous fumes. The bulk of the arsenic used is employed in insecticides, rat poisons, and weed killers, but it has many industrial uses, especially in pigments. It is also used in poison gases for chemical warfare. The white, poisonous powder commonly called arsenic is Arsenic trioxide, or Arsenious oxide,  $\text{As}_2\text{O}_3$ , also known as White arsenic. When marketed commercially, it is colored pink to designate it as a poison. White arsenic is marketed as Refined, +99% pure, High-grade, 95 to 99%, and Low-grade, -95%. Arsenic is added to antimonial lead alloys and white bearing metals for hardening and to increase fluidity, and to copper to increase the annealing temperature for such uses as radiators. It is also used in lead shot to diminish cohesion. The common ores of arsenic are the arsenical iron pyrites, realgar, smaltite, and orpiment. It is also a by-product from copper smelters, recovered by distillation.

**Arsenic acid.** A white crystalline solid of the composition  $(\text{H}_3\text{AsO}_4)_2 \cdot \text{H}_2\text{O}$ , produced by the oxidation of white arsenic with nitric and hydrochloric acids. It is soluble in water and in alcohol, has a specific gravity of 2 to 2.5, and a melting point of  $35.5^\circ\text{C}$ . Arsenic acid is sold in various grades, usually 75% pure, and is used in glass manufacture, in printing textiles, and in insecticides.

**Arsenic disulphide.** Also known as Ruby arsenic, Red arsenic glass, and Red orpiment. It is an orange-red, poisonous powder with specific gravity 3.5, and melting point  $307^\circ\text{C}$ , obtained by roasting arsenopyrite and iron pyrites. The composition is  $\text{As}_2\text{S}_2$ . It is employed in fireworks, as a paint pigment, and in the leather and textile industries. Another arsenic sulphur compound used as a pigment is Orpiment, found as a natural mineral in Utah, Peru, and in central Europe. It is an Arsenic trisulphide,  $\text{As}_2\text{S}_3$ , containing 39% sulphur and 61 arsenic. The mineral has a foliated structure, a lemon-yellow color, and a resinous luster. The specific gravity is 3.4, hardness 1.5 to 2, and melting point  $300^\circ\text{C}$ . Artificial arsenic sulphide is now largely substituted for natural orpiment, and as a pigment is referred to as King's yellow.

**Arsenic ores.** Arsenopyrite, also called Mispickel, is the most common ore of arsenic. It is used also as a source of white arsenic, and directly in pigments and as a hide preservative. The composition is  $\text{FeAsS}$ . It occurs in crystals or massive, of a silvery-white to gray-black color and a metallic luster. The specific gravity is 6.2 and hardness 5.5 to 6. Arsenic is usually not a primary product from ores, but is obtained as a by-product in the smelting of copper, lead, and gold ores. A source of white arsenic is the copper ore, Enargite,  $\text{Cu}_2\text{S} \cdot 4\text{CuS} \cdot \text{As}_2\text{S}_3$ , containing theoretically 48.3% copper and 19.1 arsenic. It occurs in massive form with a hardness of 3, specific gravity of 4.45, and is gray, with a pinkish variety known as Luzonite. The mineral is commonly intertwined with Tennantite,  $5\text{Cu}_2\text{S} \cdot 2(\text{CuFe})\text{S} \cdot 2\text{As}_2\text{S}_3$ , a mineral of a gray to greenish color. Realgar, known also as Ruby sulphur and Red orpiment, is a red or orange arsenic disulphide,  $\text{As}_2\text{S}_2$ , occurring with ores of lead and silver in monoclinic crystals. The hardness is 1.5, and specific gravity 3.55. It has been used as a pigment. Another ore is Smaltite, or Cobalt pyrites,  $\text{CoAs}_2$ , occurring in gray masses of specific gravity 6.5 and

hardness 5.5. It occurs with ores of nickel and copper. It may have nickel and iron replacing part of the cobalt, but it is also an ore of cobalt.

**Asbestos.** The commercial name for several varieties of fibrous minerals, the fibers of which are valued for their heat-resistant and chemical-resistant properties, and are made into fabrics, paper, insulating boards, and insulating cements. The long fibers are used for weaving into fireproof garments, curtains, shields, and brake linings. The short fibers are compressed with binders into various forms of insulating boards, shingles, pipe coverings, paper, and molded products. The original source of asbestos was the mineral Actinolite, but the variety of Serpentine known as Chrysotile now furnishes most of the commercial asbestos. Actinolite and Tremolite, which furnish some of the asbestos, belong to a great group of widely distributed minerals known as Amphiboles which are chiefly metasilicates of calcium and magnesium with iron sometimes replacing part of the magnesium. They occur granular, in crystals, compact such as Nephrite which is the Jade of the Orient, or in silky fibers as in the iron Amphibole asbestos mined in the United States. The color varies from white to green and black. This type is more resistant to high temperatures than chrysotile.

**Chrysotile** is a highly fibrous variety of serpentine. It is a hydrated silicate of magnesia,  $2\text{SiO}_2 \cdot 3\text{MgO} \cdot 2\text{H}_2\text{O}$ , and has a silky, strong fiber that can be spun and woven into fabrics. The color is white to greenish. The fibers from different mines vary in diameter and flexibility, but the very thin flexible ones can be separated out readily for weaving into light fabrics. Chrysotile is mined chiefly in Vermont, Quebec, Arizona, Turkey, and Rhodesia. Only about 8% of the total mined is long spinning fiber, the remainder being too short for fabrics or rope. The Turkish fiber is up to  $\frac{3}{4}$  in. in length. Asbestos produced in Quebec is chrysotile occurring in serpentized rock in veins  $\frac{1}{4}$  to  $\frac{1}{2}$  in. wide, though veins as wide as 5 in. occur. The fibers run crosswise of the vein, and the width of vein determines the length of fiber. Blue asbestos, from South Africa, is the mineral **Crocidolite**,  $\text{NaFe}(\text{SiO}_3)_2 \cdot \text{FeSiO}_2$ . The fiber has high tensile strength and is acid-resistant, and is used in packings and in asbestos-cement pipe. The fiber length is  $\frac{1}{8}$  to  $1\frac{1}{2}$  in.

The classes of Cape asbestos from South Africa are chrysotile, Amosite, and Transvaal blue. Amosite has a coarse, long, resilient fiber, and is used chiefly in insulation, being difficult to spin. It comes in white and dark grades, and the fibers are graded also by length from  $\frac{1}{8}$  to  $1\frac{1}{2}$  in. It is a type of crocidolite. The name amosite was originally a trade name for South African asbestos, but now refers to this type of mineral. Transvaal blue is a whitish, iron-rich, Anthophyllite,  $(MgFe)SiO_3$ , noted for the length of its fiber. The best grades are about  $1\frac{1}{2}$  in. in length. The fibers are resistant to heat and to acids, and the stronger fibers are used for making acid filter cloth and for fireproof garments. This type of asbestos is also found in the Appalachian range from Vermont to Alabama. Canadian, Vermont, and Arizona asbestos is chrysotile; that from Georgia and the Carolinas is anthophyllite. Canadian asbestos is graded as crude, mill fibers, and shorts. Crudes are spinning fibers  $\frac{3}{8}$  in. or longer, hand-cobbed. Mill fibers are obtained by crushing and screening. Shorts are the lowest grades of mill fibers. Rhodesian asbestos is graded in five C & GS grades separated by screen boxes. Kenya asbestos is anthophyllite, and that from Tanganyika is largely amphibole. Nonspinning asbestos is graded as shingle stock,  $\frac{1}{4}$  to  $\frac{3}{8}$  in.; paper stock,  $\frac{1}{8}$  to  $\frac{1}{4}$  in.; and shorts,  $\frac{1}{16}$  to  $\frac{1}{8}$  in. The shorts are washed and ground for use as resistant filler in molded plastics. In England this material is known as Micro asbestos.

Asbestos fabrics are often woven mixed with some cotton. For brake linings and clutch facings the asbestos is woven with fine metallic wire. Asbeston, of the U.S. Rubber Co., is full asbestos fabric in various weaves and weights. The 8-oz open-weave fabric is used for cable insulation. The close-woven 16-oz cloth is used for aircraft air ducts. The 20-oz fabric is used for fireproof clothing. An Absorbent fabric used for wiping cloths and dish towels is made from 20% asbestos fiber and 80 cotton. The dyed fabric shows color only in the cotton since the asbestos does not absorb the dye. The Colorbestos drapery fabric of Johns-Manville has the warp of cotton with the asbestos surrounding the warp threads so that the fabric is flameproof. It weighs 0.92 lb per yd in plain weave, and 1.1 lb in pattern. Asbestos wick, used for calking, is made of strands of carded long asbestos fiber twisted in the form of a soft rope, usually  $\frac{1}{4}$  in. in diameter. Asbestos rope is larger diameter material made by twisting

or braiding several strands of wick. Asbestos felt, used for insulation, is usually made by saturating felted asbestos with asphalt, although synthetic rubber or other binder may be used. Asbestos shingles, for fireproof roofing and siding of houses, are normally made of asbestos fibers and portland cement formed under hydraulic pressure. They are in the natural gray color or are colored with black or green pigments. Another type of asbestos used for some insulation is Paligor-skite, known as Mountain leather, found in Alaska. It is a complex mineral which may be an alteration product of several asbestos minerals. It absorbs moisture, and is thus not suited to the ordinary uses of asbestos, but it can be reduced to a smooth pulp which is molded with a resistant plastic binder into a lightweight insulating board.

**Asbestos board.** A construction or insulating material in sheets made of asbestos fibers and portland cement molded under hydraulic pressure. Ordinary board for the siding and partitions of warehouses and utility buildings is in the natural mottled-gray color, but pigmented boards are also marketed in various colors. The specific gravity of asbestos board is about 2.0, and it will withstand temperatures to about 1000°F. The boards are dense and rigid, but can be worked easily with carpenters' tools. Usual thicknesses are  $\frac{3}{16}$ ,  $\frac{1}{4}$ , and  $\frac{3}{8}$  in. Asbestos board is marketed under trade names such as Industal, Apac board, and Linabestos, of the Keasbey & Mattison Co., and Transite of Johns-Manville. Sheetflextos, of the former company, is a flexible asbestos-cement wallboard in  $\frac{1}{8}$  in. thickness in natural gray or waxed decorative colors. Corrugated asbestos, used for roofing and siding of industrial buildings, has a thickness of  $\frac{3}{8}$  in., and the usual corrugation of the sheet has a pitch of 4.2 in. The weight is 3.75 lb per sq ft.

Asbestos lumber is asbestos-cement board molded in the form of boards for flooring and partitions, usually with imitation wood grain molded into the surface. Asbestos siding, for house construction, is grained to imitate cypress or other wood and is pigmented with titanium oxide to give a clear white color. Asbestos roofing materials may also be made with asphalt or other binder instead of cement. Fiberock, of the Philip Carey Co., is a roofing board composed of asbestos fibers impregnated with asphalt. Asbestos millboard is asbestos fibers compressed into sheets with a small amount of binder.

**Copperclad**, of Johns-Manville, is a roofing material consisting of 2-oz electro-sheet copper bonded to asbestos felt. **Asbestos ebony**, of this company, is an electrical panel board made of asbestos cement bonded under high pressure with an insulating compound. It has good dielectric strength, will withstand temperatures to 300°F, and has a specific gravity of 2.05. **Ebonized asbestos**, of the Ambler Asbestos Shingle & Sheathing Co., is asbestos molded into sheets with an asphalt binder, and used for panels.

**Asbestos paper.** A thin asbestos sheeting made of asbestos fibers bonded usually with a solution of sodium silicate. It is strong, flexible, white in color, and is fireproof and a good heat insulator. For covering steam pipes and for insulating walls it is made in sheets of two or three plies. For wall insulation it is also made double with one corrugated sheet to form air pockets when in place. Thin sheets, 6 lb per 100 sq ft, up to 32 lb, or  $\frac{1}{16}$  in. thick, are employed for gaskets and electrical insulation. Crimped asbestos paper is also used for pipe insulation to give dead air spaces between layers. **Amblerite**, of Keasbey & Mattison Co., is thin sheet made of asbestos fibers with a resilient binder, used for packing for superheated steam and chemical fittings. **Uni-Syn** sheet packing, of this company, is made by treating long asbestos fibers with Buna-S rubber and felting under pressure. It is resilient and resistant to chemicals. **Prenite**, of the B. F. Goodrich Co., is Neoprene-bonded asbestos sheet used for chemical packings. **Cohrlastic**, of the Connecticut Hard Rubber Co., is asbestos paper coated with white silicone rubber. The thickness is 0.024 in. It has a dielectric strength of 400 volts per mil, withstands temperatures to 500°F, and is resistant to acids and alkalis. **Terratex**, of the General Electric Co., is asbestos paper with a clay binder in very thin sheets for high-voltage insulation. **Quinterra**, of Johns-Manville, is flexible asbestos paper in thicknesses from 0.0015 to 0.020 in., made by a pulping process and used for insulation.

**Ash.** The wood of a variety of species of ash trees valued for uses where strength, hardness, stiffness, and shock resistance are important. Most of the species give dense, elastic woods that polish well, but they do not withstand exposure well. The color is yellowish, which turns brown on exposure. The woods from the different species vary in their qualities, and are likely to be mixed in commercial shipments.



but the general quality is high. Ash is used for quality cooperage such as food tubs, flooring, veneer, vehicle parts, tool handles, bearings, and trim lumber. American ash and Canadian ash, also called Cane ash, White ash, and Biltmore ash, come chiefly from the tree *Fraxinus americana* which grows over a wide area east of the Mississippi River. Arkansas ash is from *F. platycarpa*; Japanese ash, also called Tamo, is from *F. mandschurica*; and European ash is from *F. excelsior*. European ash is heavier than American ash, and is tough and elastic. It is valued for hockey sticks, tennis rackets, and tool handles. Japanese ash is a close-grained wood, and is browner in color than American ash.

White ash weighs 41 lb per cu ft dry; Red ash, *F. pennsylvanica*, 39 lb per cu ft; and Green ash, *F. pennsylvanica lanceolata*, also called Water ash and Swamp ash, 44 lb. This latter tree grows over the widest area throughout the states east of the Rockies, and is commercially abundant in the Southeast and Gulf states. All of these woods vary in tensile strength from 11,000 to 17,000 psi. White ash has a compressive strength perpendicular to the grain of 2,250 psi. Mountain ash and Black ash, *F. nigra*, are also species of American ash. The latter, also called Brown ash and Hoop ash, is a northern tree and was formerly used in aircraft construction. It has a specific gravity of 0.53 when oven-dried, a compressive strength perpendicular to the grain of 1,260 psi, and a shearing strength parallel to the grain of 1,050 psi. Oregon ash, *F. oregona*, is somewhat lighter and not as strong as white ash. It grows along the west coast of Canada. Blue ash, *F. quadrangular*, grows in the Central states. Pumpkin ash, *F. profunda*, grows in the lower Mississippi Valley and in Florida. A wood that has similar uses to ash, for handles, levers, and machine parts, but is harder than ash, is Hornbeam. It is from the tree *Ostrya virginiana* of the Eastern states of the United States. The wood is very hard, tough, and strong, but is available only in limited quantities.

**Aspen.** The wood of the aspen tree, *Populus tremula*, used chiefly for match stems and for making excelsior, but also for some inside construction work. The color is yellowish, and it is tough and close-grained. The tree is native to Europe. The American aspen is from the tree *P. tremuloides*, called also American poplar, and from the

Largetooth aspen, *P. grandidentata*. Both species are also called Poplar, and the lumber may be mixed with poplar and cottonwood. The trees grow in the Lake and Northeastern states and in the West. The heartwood is grayish white to light brown with a lighter colored sapwood. It is straight-grained with a fine and uniform texture, but is soft and weak. It has a disagreeable odor when moist. The wood is used for excelsior, matches, boxes, and for paper pulp. The pulp is easily bleached. Salicin is extracted from the bark.

**Asphalt.** A bituminous, brownish to jet-black substance, solid or semisolid, found in various parts of the world. It consists of a mixture of hydrocarbons, is fusible and largely soluble in carbon disulphide. It is also soluble in petroleum solvents and in turpentine. The melting points range from 32 to 38°C. Large deposits occur in Trinidad and Venezuela. Asphalt is of animal origin as distinct from coals of vegetable origin. Native asphalt usually contains much mineral matter, and crude Trinidad asphalt has a composition of about 47% bitumen, 28 clay, and 25 water. Artificial asphalt is a term applied to the bituminous residue from coal distillation mechanically mixed with sand or limestone. Asphalt is used for roofings, road surfacing, insulating varnishes, acid-resistant paints, and for cold-molded products. The material has been known and used since earliest times, the clay bricks of the buildings of Babylon having been cemented with asphalt. The Greek word for native asphalt was Asphaltos, and the Latin word Bitumen. The latter word now means the asphalt clean of earthy matter. The word comes from the original Sanskrit word Gwitu-men, meaning pitch, and the word Pitch now applies chiefly to tars used as roofing or coating materials. In general, bitumens have the characteristics that they are fusible and are totally soluble in carbon disulphide, as distinct from the Pyrobitumens, albertite, elatarite, and coals, which are infusible and relatively insoluble in carbon disulphide. Pyrogenous asphalts are the residues from the distillation of petroleum or from the treatment of wurtzilite. Asphaltite is a general name for the bituminous asphaltic materials which are difficultly fusible, such as gilsonite and grahamite.

Rock asphalt, or Bituminous rock, is a sandstone or limestone naturally impregnated with asphalt. The asphalt can be extracted from it, or it is used directly for paving and flooring. Kyrock is a

rock asphalt from Kentucky consisting of silica sand of sharp grains bound together with a bituminous content of about 7%. The crushed rock is used as a paving material. Albertite is a type of asphalt found originally in Albert County, New Brunswick, and first named Albert coal. It belongs to the group of asphalts only partly soluble in carbon disulphide, infusible, and designated as Carboids, although they are true asphalts and not of vegetable origin. The commercial albertite is a type called Stellarite from Nova Scotia. It is jet-black, brittle, contains 22 to 25% fixed carbon, and yields oil and coke when distilled. It is easily lighted with a match, and burns with a bright, smoky flame, throwing off sparks. The albertite found in Utah is called Nigrite and contains up to 40% fixed carbon. A species found in Angola is called Libollite. These materials are weathered asphalts. Ipsonite is a final stage of weathered asphalt. It is black in color, infusible, only slightly soluble in carbon disulphide, contains 50 to 80% fixed carbon, and is very low in oxygen. It is found in Oklahoma, Arkansas, Nevada, and in various places in South America. The Rafaelite found in large beds on the eastern slopes of the Andes Mountains in Argentina is a form of ipsonite.

Cutback asphalt is asphalt liquefied with petroleum distillates, used for cementing down floor coverings and for waterproofing walls. Protective coatings based on asphalt cutback form economical paints for protection against salts, alkalies, and nonoxidizing acids at temperatures up to 110°F. They are black in color, but may be pigmented with aluminum flake. They are often marketed under trade names such as Atlastic 31, of the Atlas Mineral Products Co., and Protek-Coat, of the Davison Chemical Co. Emulsified asphalt is an asphalt emulsion in water solution, used for floor surfacing, painting pipes, and waterproofing concrete walls. Emulsified asphalts may be marketed under trade names such as Elastex, of the Truscon Laboratories, and Ebontex, of the Philip Carey Co. Thermotex, of the latter company, is an emulsified asphalt mixed with asbestos fibers, used for painting steam pipes. Brunswick black is a mixture of asphaltite with fatty-acid pitch in a volatile solvent, used for painting roofs. Amiesite, of the Amiesite Asphalt Co., is asphalt mixed with rubber latex, or is a premixed asphalt with an aggregate employed for road filling. Flooring blocks and Asphalt tiles are made in standard shapes and sizes from mixtures of asphalt with fillers and pigments. Elastite, of

the Philip Carey Co., is a block made of about 35% asphalt, 15 fiber, and 50 mineral filler. It is used for factory floors. Accotile, of the Armstrong Cork Products Co., is a resilient and chemical-resistant floor tile made of asbestos fibers, mineral pigments, and asphalt binder. Asphalt is also used for cold-molded products, such as Gummon, of the Garfield Mfg. Co., which is composed of asbestos fibers molded with an asphalt binder. Oil asphalt, Petroleum asphalt, Petroleum pitch, or Asphalt oil, is the heavy black residue left after removing the tar tailings in the distillation of petroleum. It contains 99% bitumen, is not soluble in water, and is durable. As it adheres well to metals, wood, or paper, and forms a glossy surface, it is used in roofings, or mixed with natural asphalt for paints and coatings. It is also used for roads. Vanadisets, of the Wilson Carbon Co., Inc., is a series of resin fractions of petroleum asphalt with small amounts of vanadium pentoxide, varying from semisolids to a brittle solid. They are used as softeners for rubber and in bitumen paints.

**Babassu oil.** An oil similar to coconut oil obtained from the kernels of the nut of the palm tree *Attalea orbignya* which grows in vast quantities in northeastern Brazil. Most of the commercial nuts come from Maranhão. There are 2 to 5 long kernels in each nut, the kernel being only 9% of the heavy-shelled nut, and these kernels contain 65% oil. A bunch of the fruits contain 200 to 600 nuts. The oil is very high in lauric acid, and is a direct substitute for coconut oil for soaps, as an edible oil, and as a source of lauric, capric, and myristic acids. The melting point of the oil is 22 to 26°C, specific gravity 0.868, iodine value 15, and saponification value 246 to 250. Tucum oil, usually classed with babassu but valued more in the bakery industry because of its higher melting point, is from the kernels of the nut of the palm *Astrocaryum tucuma* of northeastern Brazil. The oil is similar but heavier with melting point up to 35°C. In Colombia it is called Guere palm.

Another similar oil is Murumuru oil, from the kernels of the nut of the Palm *A. murumuru*, of Brazil. The name is a corruption of the two Carib words marú and miorú, meaning bread to eat. The oil contains as much as 40% lauric acid, with 35% myristic acid, and some palmitic, stearic, linoleic, and oleic acids. It is usually marketed as babassu oil. The Awarra palm, *A. janari*, of the Guianas, yields

nuts with a similar oil. Cohune oil is a white fat from the kernels of the nut of the palm *Attalea cohune* of Mexico and Central America. It is a small tree yielding as many as 2,000 nuts a year. The oil has the appearance and odor of coconut oil, and contains 46% lauric acid, 16 myristic, 10 oleic, with also stearic, capric, and linoleic acids. All of these oils yield a high proportion of glycerin which is in combination with the fatty acids. Cohune oil has a melting point of 18 to 20°C, saponification value 252 to 256, iodine value 10 to 14, and specific gravity 0.868 to 0.971. The cohune nut is much smaller than the babassu but is plentiful and easier to crack. Curua oil is from the nut of the palm *A. spectabilis* of Brazil. It is similar to cohune oil and is used for the same purposes in soaps and foods. Mamarron oil is a cream-colored fat with the odor and characteristics of coconut oil, obtained from another species of *Attalea* palm of Colombia. Another oil high in lauric acid, and similar to babassu oil, is Corozo oil obtained from the kernels of the nuts of the palm *Corozo oleifera* of Venezuela and Central America. Macanilla oil is a similar oil from the kernels of the nuts of the palm *Guilielma garipaes* of the same region. Buri oil is from the nuts of the palm *Diplothemium candescens* of Brazil.

**Babbitt metal.** The original name for tin-antimony-copper white alloys used for machinery bearings, but the term now applies to almost any white bearing alloy with either tin or lead base. The original babbitt, named after the inventor, was made by melting together 4 parts by weight of copper, 12 tin, and 8 antimony, and then adding 12 parts of tin after fusion. It consisted, therefore, of 88.9% tin, 7.4 antimony, and 3.7 copper. This alloy melts at 462°F. It has a Brinell hardness of 35 at 70°F, and 15 at 212°F. As a general-utility bearing metal, the original alloy has never been improved greatly, and makers frequently designate the tin-base alloys close to this composition as Genuine babbitt. Some of the early competitive alloys varied in composition, but usually for the purpose of conserving tin. Thurston's bearing metal contained 9 to 10% copper, 20 antimony, and the balance tin. Jacna metal had 70% lead, 10 tin, 19 antimony, and a small amount of bismuth. Husman's alloy, used originally on the German railways, had about 74% tin, 11 antimony, 4 copper, 10 lead, and 0.4 zinc. Karmash's alloy contained considerable zinc.

Commercial white bearing metals now known as babbitt are of three general classes: Tin-base, with more than 50% tin hardened with antimony and copper, and used for heavy, pounding service; Intermediate, with 20 to 50% tin, having lower compressive strength and more sluggish as a bearing; Lead-base, made usually with antimonial lead with smaller amounts of tin together with other elements to hold the lead in solution. These Lead-base babbitts are lower in cost and also serve to conserve tin in times of scarcity of that metal, but they are suitable only for light service, although many ingenious combinations of supplementary alloying elements have sometimes been used to give hard, strong bearings with little tin. The high-grade babbitts, however, are usually close to the original babbitt in composition. SAE babbitt for connecting-rod bearings has 86% tin, 5 to 6.5 copper, 6 to 7.5 antimony, and not over 0.35 lead. A babbitt of this kind will have a compressive strength up to 20,000 psi, while the high-lead alloys have only 15,000 psi. Adamant alloy, of the Magnolia Metal Co., is a genuine babbitt with tensile strength of 12,850 psi, Brinell hardness 22.8, and pouring range 875 to 1050°F.

Copper hardens and toughens the alloy and raises the melting point. Lead increases the fluidity and raises the antifriction qualities, but softens the alloy and decreases its compressive strength. Antimony hardens the metal and forms hard crystals in the soft matrix which improves the alloy as a bearing metal. Only 3.5% of antimony is normally dissolved in tin. In the low-antimony alloys copper-tin crystals form the hard constituent, and in the high-antimony alloys antimony-tin cubes are also present. Alloys containing up to 1% arsenic are harder at high temperatures and are fine-grained, but arsenic is used chiefly for holding lead in suspension. Zinc increases hardness but decreases frictional qualities, and with much zinc the bearings are inclined to stick. Even minute quantities of iron harden the alloys, and iron is not used except when zinc is present. Bismuth reduces shrinkage and refines the grain, but lowers the melting point, and lowers the strength at elevated temperatures. Cadmium increases the strength and fatigue resistance, but any considerable amount lowers the frictional qualities, lowers the strength at higher temperatures, and causes corrosion. Nickel is used to increase strength but raises the melting point. The normal amount of copper in babbitts is 3 to 4%, at which point the maximum fatigue-resisting properties are ob-

tained with about 7% antimony. More than 4% copper tends to weaken the alloy, and raises the melting point. When the copper is very high, tin-copper crystals are formed and the alloy is more a bronze than a babbitt. Parsons' white brass is a hard tin-base white alloy with both SnSb and SnCu crystals in the matrix.

Babbitts are marketed under many trade names, and some makers class the high-lead alloys as Antifriction metal rather than as babbitt. The antifriction metal of the Bunting Brass & Bronze Co. contains 75% lead, 15 antimony, and 10 tin. Leantin, of the Lumen Bearing Co., is a high-lead alloy; Cosmos metal is a lead-base alloy with small amounts of tin and antimony; Stannum metal is a high-tin alloy for hard-service bearings; Lubeco metal is a medium-composition babbitt; and Lotus metal, for motor bearings, is a lead-base alloy with higher percentages of tin and antimony. Hoo Hoo metal, of the National Bearing Metals Div., American Brake Shoe Co., contains no lead, but is a tin-base alloy with copper, nickel, and antimony. Nickel babbitt, of this company, is a tin-copper-nickel alloy with a compressive strength of 24,600 psi, and a Brinell hardness 29. A grade of Rex babbitt, developed by this company as a substitute for high-tin babbitt during the war, contains only 10% tin together with antimony, copper, and lead in proportions to give strength and frictional properties. The compressive strength is 17,500 psi, Brinell hardness 25, and pouring temperature 625 to 675°F. Silver babbitt of this company is a lead-copper alloy with no tin, but with a small percentage of silver to aid retention of the lead and to give hardness at elevated temperatures. Copaloy, of the Michigan Smelting & Refining Co., is a lead-tin-antimony alloy with a small percentage of copper. Bearingoy, of the Williams Alloy Products Co., is a soft lead alloy used where lubrication is poor. Glyco is the name of a group of lead-base alloys of Joseph T. Ryerson & Son, Inc. Satco, of the National Lead Co., is a high-melting-point alloy for heavy service. It melts at 788°F. Tinité, of the Ajax Metal Co., is a tin-base metal hardened with copper. Ajax bull, of this company, contains 76% lead, 7 tin, and 17 antimony.

**Bagasse.** The residue left after grinding sugar cane and extracting the juice, employed in making paper and fiber building boards. In England it is called Megass. The fibers are long, and mat together

to form a strong, tough, light, absorptive board. The finer fibers of bagasse in Cuba and Jamaica are soaked in molasses and used as a cattle feed under the name of Molascuit. Celotex is the trade name of the Celotex Corp. for wallboard, paneling, and acoustical tile made from bagasse fibers. Ferox-Celotex is the material treated with chemicals to make it resistant to fungi and termites. Celo-Rock is the trade name for Celotex-gypsum building boards. Acousti-Celotex is Celotex perforated to increase its sound-absorbing efficiency. Aconitic acid,  $C_3H_3(COOH)_3$ , occurs in bagasse and is extracted from Louisiana cane. The acid is esterified for use as a plasticizer for vinyl resins, or, when sulphonated, as a wetting agent.

**Balata.** A nonelastic rubber obtained chiefly from the tree *Manilkara bidentata* of Venezuela, Brazil, and the Guianas. It is similar to gutta percha and is used as a substitute, but the tree has not been cultivated. The material contains a high percentage of gums and is more tacky than rubber, but it can be vulcanized in the same manner as rubber. Balata has been used principally for transmission and conveyor belts. For conveyer belts heavy duck is impregnated with balata gum solution and vulcanized. The belts have high tensile strength, good flexibility, and wear resistance. The wood of the balata tree is used for cabinetwork and for rollers and bearings. It is called Bulletwood in the Guianas, but this name is also applied to the wood of the gutta-percha trees of Asia which have about the same characteristics. The wood is extremely hard, durable, and weighs 66 lb per cu ft. It has a deep-red color and a fine, open grain.

**Balloon cloth.** A plain-woven cotton fabric used originally as a base material in making coated fabrics for the construction of balloons, but now used also in many industries under the same name. The various grades differ in weight, thread count, and strength. Grade HH, having 120 threads per inch in each direction, is most widely used. A Navy fabric has a weight of 2.05 oz per sq yd and a tensile strength of 38 psi in each direction. When several layers are built up and rubberized or plastic-coated, they may be on the bias, and the outside layer coated with aluminum paint to reduce the heat absorption. Gas cell fabric is a single-ply, coated balloon cloth. Airplane cloth, used for fabric-covered training planes, is a plain-woven cotton fabric of 2-ply combed yarns mercerized in the yarn. It is



usually 4 oz per yd, but wide fabrics may be 4.5 oz. The cotton is  $1\frac{1}{2}$  in. min staple, and the threads per inch are 80 to 84.

**Balsa wood.** The wood of large and fast-growing trees of the genus *Ochroma* growing from southern Mexico to Ecuador and northern Brazil. It is the lightest of the commercial woods and combines also the qualities of strength, stiffness, and workability. It is about one-fourth the weight of spruce, with a structural strength only half that of spruce. The crushing strength is 2,150 psi. The wood is white to light yellow or brownish and weighs about 8 lb per cu ft from a 4-year-old tree. Wood from a 6-year-old tree weighs 10 to 12 lb per cu ft. Its peculiar cellular structure makes it valuable as an insulating material for refrigeration. It is also used for life preservers, buoys, floats, paneling, vibration isolators, insulating partitions, and inside trim of aircraft. The small pieces are used for model airplanes. Balsa sawdust is valued as a lightweight filler for plastics. Much of the commercial wood is from the tree *O. grandiflora* of Ecuador. The Barrios balsa, *O. concolor*, grows from southern Mexico through Guatemala and Honduras. Limon balsa is from the tree *O. limonensis* of Costa Rica and Panama, and the Santa Marta balsa is the *O. obtusa* of Colombia. Red balsa is from the *O. velutina* of the Pacific Coast of Central America. The balsa known in Brazil as Sumaúma is from a kapok tree *Ceiba pentandra*. It is used for life preservers and rafts, and is quite similar to balsa. A Japanese lightweight wood used for floats, instruments, and where lightness is required is Kiri, from the tree *Paulownia tomentosa*. It weighs 20 lb per cu ft.

**Balsam fir.** The wood of the coniferous tree *Abies balsamea* of the United States and Canada. It is brownish white in color, soft, and has a fine, even grain. It is not strong and not very durable, and is used chiefly for pulpwood and for packing boxes and light construction. The weight is 26 lb per cu ft. Canada balsam is produced from the buds. Southern balsam fir is Frazer fir, from the tree *A. fraseri* of the Appalachian Mountains. The wood is similar to balsam fir and has the same uses.

**Bamboo.** A genus of gigantic treelike grasses, of the order *Graminaceae*, of which the *Bambusa arundinacea* is the most common species. It grows most commonly in the East Indies and in

southern Asia, but many species have been brought to Latin America and to the southern United States. The stems of bamboo are hollow, jointed, and have an extremely hard exterior surface. They sometimes reach more than 1 ft in diameter and are often 50 ft high, growing in dense masses. The *B. spinosa* of the Philippines grows as much as 10 ft in one week. Bamboo is a material of innumerable uses. The stalks are used for making pipes, buckets, baskets, walking sticks, fishing poles, rug-winding poles, lance shafts, window blinds, mats, arrows, and for building houses and making furniture. The weight is about 22 lb per cu ft. Tonkin bamboo is strong and flexible, and is used for making fishing poles. Tali bamboo of Java, *Gigantochloa apus*, is used for construction. Betong bamboo is *G. asper*, and is one of the largest species. Giant bamboo, *Dendrocalamus gigantea*, of Ceylon, grows to a height of 100 ft. The fast-growing Eeta bamboo is used in India as a source of cellulose for rayon manufacture.

**Barite.** Sometimes spelled Baryte, and also called Heavy spar, and in some localities known as Tiff. A natural Barium sulphate mineral of the theoretical composition  $\text{BaSO}_4$ , used chiefly for the production of lithopone, but also ground and used as a pigment for paints, plastics, linoleum, rubber, cloth, and paper, and in chemical manufacture. For the latter purpose it is specified 90 to 95% pure  $\text{BaSO}_4$ , with not more than 1% ferric oxide. Prime white and floated grades are used for coating paper. Artificial barite, Permanent white, and Blanc fixe are names for white, fine-grained precipitated paint grades. Micronized barite, for rubber filler, is a fine white powder of 400 to 1,000 mesh. Barite is widely distributed and especially associated with ores of various metals or with limestones. It occurs in crystals or massive. It may be colorless, white, or light shades of blue, red, and yellow, and transparent to opaque. Its hardness is 3 to 3.5, and specific gravity 4.4 to 4.8. It is insoluble in water. The mineral is produced in the Western states and from Virginia to Georgia. The barite of Cartersville, Ga., contains 96%  $\text{BaSO}_4$ , 0.6 iron, with silica, alumina, and traces of calcium, strontium, and magnesium. Large deposits of high-grade barite occur in Nova Scotia. In the West much ground crude barite is used as a drilling mud in oil wells. The white pigment marketed by the American Zinc Sales Co. under the name of Azolite is 71% barium sulphate and 29% zinc sulphide in 325-mesh powder.

Sunolith, of Wishnick-Tumpeer, Inc., is a similar product. A substitute for barite for some filler uses is Witherite, an alteration mineral of the composition  $\text{BaCO}_3$ , which is Barium carbonate, found associated with barite. Precipitated barium carbonate is a white, tasteless, but poisonous powder used in rat poisons.

**Barium.** A metallic element of the alkaline earth group, symbol Ba. It occurs in combination in the minerals witherite and barite which are widely distributed. The metal is silvery white in color and can be obtained by electrolysis from the chloride, but it oxidizes so easily that it is difficult to obtain in the metallic state. It oxidizes on contact with the air and decomposes water. Its melting point is  $850^\circ\text{C}$ , and specific gravity 3.78. The most extensive use of barium is in the form of its sulphate as a pigment. It is also used in chemical manufacturing, and its salts are employed for deoxidizing alloys of copper, tin, lead, and zinc. It is introduced into lead-bearing metals by electrolysis to harden the lead.

**Barium chloride.** A colorless crystalline material of the composition  $\text{BaCl}_2 \cdot 2\text{H}_2\text{O}$ , or in anhydrous form without the water of crystallization. The specific gravity is 3.097, and melting point  $860^\circ\text{C}$ . It is soluble in water to the extent of 25% at  $20^\circ\text{C}$  and 37% at  $100^\circ\text{C}$ . In the mechanical industries it is used for heat-treating baths for steel either alone or mixed with potassium chloride. The molten material is free from fuming and can be held at practically any temperature within the range needed for tempering steels. It is also used for making boiler compounds, for softening water, as a mordant in dyeing and in printing inks, in tanning leather, in photographic chemicals, and in insecticides. Barium chlorate,  $\text{Ba}(\text{ClO}_3)_2 \cdot \text{H}_2\text{O}$ , is a colorless crystalline powder soluble in water. The melting point of the anhydrous material is  $414^\circ\text{C}$ . It is used in explosives as an oxygen carrier, and in pyrotechnics for green-colored light.

**Barium nitrate.** Also called Nitrobarite. A white, crystalline powder of the composition  $\text{Ba}(\text{NO}_3)_2$ , with specific gravity of 3.24, melting at  $592^\circ\text{C}$ , and decomposing at higher temperatures. It is a barium salt of nitric acid obtained by roasting barite with coke, leaching out the precipitated barium sulphide, precipitating as a carbonate by the addition of soda ash, and then dissolving in dilute nitric acid.

It has a bitter metallic taste and is poisonous. Barium nitrate is used in ceramic glazes, but its chief use is in Pyrotechnics. It gives a pale-green flame in burning, and is used for green signals and flares, and for white flares in which the delicate green is blended with the light of other extremely luminous materials. It is also used as an oxygen carrier in Flare powders and to control the time of burning of the aluminum or magnesium. Sparklers are composed of aluminum powder and steel filings with barium nitrate as the oxygen carrier. Barium oxalate,  $\text{BaC}_2\text{O}_4$ , another barium salt, is also used in pyrotechnics as a combustion retarder.

**Barley.** The seed grains of the annual plant *Hordeum vulgare* of which there are many varieties. It is one of the most ancient of the cereal grains, and was the principal source of bread flour until the sixteenth century. The plant is hardy, with a short growing season, and can be cultivated in cold latitudes and at high altitudes, giving high yields per acre. The grains grow in a dense head with three spikelets, and the six-rowed variety has a high protein content, but has low gluten, thus making a poor breadstuff. Pearl barley is the husked and polished grain. About two-thirds of the barley grown in the United States is now used for animal feed, as it produces lean meat in cattle. The chief industrial use is for making Malt, for which the two-rowed varieties with low protein and thin husk are used. Malt is barley that has been germinated by moisture and then dried. Malting develops the diastase enzyme, which is capable of converting the insoluble starch into soluble starch and then into sugars. It is used for brewing beer and for malt extracts. Caramel malt is browned with high-temperature drying, and is used for the dark-colored Bock beer. Barley straw is employed in Europe and Asia for making braided plaits for hat making. In America barley straw is used for packing.

**Basalt.** A dense, hard, dark-brown to black igneous rock, consisting of feldspar and augite and often containing crystals of green olivine. It occurs as trap or as volcanic rock. The specific gravity is 2.87 to 3, and it is extremely hard. Masses of basalt are frequently found in columns or prisms, as in the celebrated basalt cliffs of northern Ireland. The rock is often wrongly classed as a granite. Basalt is used in the form of crushed stone for paving, as a building stone,

and for making rock wool. A Russian cast basalt used for electrical insulators is called Angarite. In Germany cast basalt has been used as a building stone, for linings, and for industrial floors. It is made by melting the crushed and graded basalt, and then tempering by slow cooling. The structure of the cast material is dense with needlelike crystals, and has a hardness of 8 to 9 Moh. Basalt glass is not basalt, but is pumice.

**Basswood.** The wood of several species of lime trees, *Tilia americana*, *T. heterophylla*, *T. glabra*, and *T. pubescens*, all native to the United States and Canada. The European Lime wood, from the tree *T. cordata*, is not called basswood. The wood of the *T. glabra*, called in the Eastern states the Lime tree and the Linden, and also the White basswood, *T. heterophylla*, is used for containers, furniture, and such millwood as blinds. It is soft, light in weight, and has a fine, even grain, but is not very strong or durable on exposure. The white sapwood merges gradually with the yellow-brown heartwood. The specific gravity is 0.40 when oven-dried, and the compressive strength perpendicular to the grain is 620 psi.

**Bate.** A term employed in the leather industry for materials used to free the skins of lime and to make them soft and flaccid before tanning by bringing the collagen into a flaccid or unswollen condition. Since ancient times dung has been used for this purpose, and until very recently the American tanning industry imported dog dung from Asia Minor for bating leather. Artificial bates are now used because of their greater uniformity and cleanliness. Boric acid is sometimes used for deliming, and gives a silky feel to the leather, but most bates have both a deliming and an enzyme action. Trypsin is a group of enzymes from the pancreatic glands of animals, and its action on skins is to dissolve the protein. They are generally used with ammonium chloride or other salt. Oropen, of Rohm & Haas Co., Inc., is this material carried in wood flour and mixed with a deliming salt. Sulfamic acids are also used as bates.

**Bauxite.** A noncrystalline, earthy white to reddish mineral, massive or in grains, having a composition  $\text{Al}_2\text{O}_3 \cdot 2\text{H}_2\text{O}$ , containing theoretically 74% alumina. It is the most important ore of aluminum, but is also used for making aluminum oxide abrasives, for refrac-

ories, white cement, and for decolorizing and filtering. The chief production in the United States is in Arkansas, Georgia, and Alabama, but less than 15% of the world output is in the United States. The important producing countries are the Guianas, Hungary, France, and Italy, but large deposits are found in Indonesia, Brazil, Jamaica, Haiti, the Pacific Islands, and other places. Bauxite is graded on the  $\text{Al}_2\text{O}_3$  content. High-grade bauxite, Grade A, contains a minimum of 55%  $\text{Al}_2\text{O}_3$ , and a maximum of 8 silicon. Grade B contains a minimum of 50%  $\text{Al}_2\text{O}_3$  with a silicon content from 8 to 16%. Chemical grades should have less than 2.5%  $\text{Fe}_2\text{O}_3$ . Grades appearing in price quotations with up to 84% alumina content are calcined and are based on the dehydrated alumina content of the ore. One long ton of crude bauxite yields 0.87 long ton of dried bauxite, which is sufficient to produce one short ton of alumina, which in turn yields 1,000 lb of aluminum metal. By present methods of aluminum production it requires about 1.2 lb of soda ash to remove 1 lb of silica from the bauxite, and about a pound of alumina and a pound of soda are lost in the red mud residue unless special methods are taken. Thus, bauxite for aluminum production should be low in silica, preferably less than 7%. Much of the Arkansas bauxite contains 13% silica. Bauxite has a high melting point,  $1820^\circ\text{C}$ , and can be used directly as a refractory.

Cement-making white bauxite from Greece ranks very high in alumina content. Brazilian, Arkansas, and Indian ores also contain some titanium oxide, and the Surinam ore has as high as 3%  $\text{TiO}_2$ . Two kinds of bauxite are found in Italy, a dark-red variety containing 54 to 58%  $\text{Al}_2\text{O}_3$ , and only 2 to 4  $\text{SiO}_2$ , but having 22 to 26%  $\text{Fe}_2\text{O}_3$ , and 2 to 3  $\text{TiO}_2$ , and a light-red variety containing 60 to 66%  $\text{Al}_2\text{O}_3$ , 5 to 9 silica, 10 to 16 iron oxide, and 3 to 5 titanium oxide. The best French white bauxite contains 66 to 74% alumina, 6 to 10 silica, 2 to 4 iron oxide, and 3 to 4 titanium oxide. It is preferred for ceramic and chemical purposes, while the best grade of the red variety is used for producing aluminum, and the inferior grades for refractories and for cement manufacture. Malayan and Indonesian bauxite averages 57 to 60%  $\text{Al}_2\text{O}_3$ , 6.7  $\text{Fe}_2\text{O}_3$ , 3 to 5  $\text{SiO}_2$ , and 0.9 to 1  $\text{TiO}_2$ . The large deposits on Ponape and other Pacific Islands average 50 to 52% alumina, 3 to 6 silica, and 10 to 20 iron oxide. These ores were used by the Japanese for the production of aluminum.

Phosphatic bauxite, from the island of Trauhira off the coast of Brazil, is a cream-colored porous rock containing 31.5% alumina, 25.2  $P_2O_5$ , 7.3 iron oxide, 6.8 silica, and 1.3 titania. Diaspore,  $Al_2O_3 \cdot H_2O$ , mined in Missouri, and Gibbsite,  $Al_2O_3 \cdot 3H_2O$ , from the Guianas, are bauxites also used for refractories. Filter bauxite, or Activated bauxite, is bauxite that has been crushed, screened, and calcined, and is usually in 20- to 60- and 30- to 60-mesh grades. It may be sold under trade names such as Porocel and Florite. It is preferred to fuller's earth for oil-refinery filtering because it can be re-vivified indefinitely by calcining. Calcined bauxite for the abrasive industry is burned bauxite and contains 78 to 84% alumina. Laterite, or Ferroginous bauxite, has been used in Europe to produce alumina and iron. The laterite of Oregon contains 35% alumina, about 35 iron oxide, and about 7 silica. Low-alumina, high-silica bauxites can be lime-sintered to release the sodium aluminate which goes back into the process while the silicate goes out with the calcium, thus giving high alumina recovery with low soda loss.

**Bearing bronze.** Any bronze used for bearing purposes, but usually referring to bronzes containing considerable lead. As an element in bearing metals lead has been called the wax of metals, forming the soft matrix or foundation for the hard crystals, but lead is not easy to keep in solution and the alloys require controlled casting. A high lead content in bronzes improves the antifriction qualities, but reduces the strength and hardness. Bronzes with about 30% lead are called Plastic bronze. They are superior in strength to the babbitt metals, and are used for heavy mill bearings. The so-called Bearing brasses, used for railway-car journals, are not brasses, but are lead bronzes with about 65% copper, 5 to 10 tin, and up to 30 lead. They seldom contain zinc, but the railway bearing metal called in England by the name of Bush metal contains 72% copper, 14 tin, and 14 yellow brass ingot metal. The Journal bronze of the U.S. Navy contains 82 to 84% copper, 12.5 to 14.5 tin, 2.5 to 4.5 zinc, and 1 lead. The ASTM bearing bronzes have from 70 to 85% copper, 5 to 10 tin, and 5 to 25 lead, with the zinc kept below 0.50% as an undesirable element. The 85-10-5 bronze has a tensile strength of 28,000 psi, a compressive deformation limit of 18,000 psi, and a Brinell hardness of 60. The 70-5-25 bronze has a tensile strength

of 15,000 psi, and a hardness of 40. Zinc is used, however, where higher strengths are needed, if the copper-tin is high and the zinc remains alloyed with the copper in the softer matrix. SAE alloy 660, and Bunting bronze 72, used for electric motor bearings, contain 83% copper, 7 tin, 7 lead, and 3 zinc. This alloy has a tensile strength of 34,000 psi, compressive limit 22,000 psi, and Brinell hardness 58. Asarcon 773, of the American Smelting & Refining Co., has a similar composition, but the bars and cylinders are produced by continuous casting to give a dense, even-grained structure.

Bearing bronzes are marketed under a variety of trade names such as Ajax metal, of the Ajax Metal Co., and Johnson bronze, of the Johnson Bronze Co. The Tiger bronze, of the National Bearings Div., American Brake Shoe Co., is a copper-tin bronze with particles of lead evenly dispersed to give low coefficient of friction. It comes in cast bars and cylinders with tensile strength 30,000 psi and Brinell hardness 53. Magnolia isotropic bronze, of the Magnolia Metal Co., is die-cast in bars and cylinders to produce a homogeneous structure that gives longer wear life than a sand-cast bronze. Tensile strength is 30,000 psi, elongation 8.5%, and Brinell hardness 70.

Bearing bronzes are now often made in thin sheet rolled to the form of the bearing, providing better strength with a steel or iron backing. Johnson bronze 40, for sheet bearings, is SAE bronze 795. It contains 90% copper, 9.5 zinc, and 0.5 tin, giving a Rockwell B hardness of 65 to 71. Johnson bronze 44 is SAE bronze 791, with 86 to 90% copper, 3 to 4.5 tin, 3.5 to 4.5 lead, and 3.5 to 5 zinc, having a Rockwell B hardness of 65 to 71.

An addition of small amounts of nickel to bearing bronzes helps to keep the lead in solution and improves the resistance to compression and shock. Iron up to 1% increases the resistance to pounding and hardens the bronze, but reduces the grain size and tends to segregate the lead. Some early bearing bronzes were made with antimony instead of lead, but the binary Copper-antimony alloys are highly crystalline, and the crystalline purple-colored material called by the alchemists Regulus of Venus was a 50-50 copper-antimony alloy. An early bearing bronze contained 16% lead, 7 antimony, and small amounts of nickel and tin. A copper-antimony alloy used by the Hamilton Gear & Machine Co. for worm gears contains 7 to 8% antimony, 1.5 to 2.5 nickel, and the balance copper. It casts well and



has a triplex structure that makes a good bearing metal. The tensile strength, sand-cast, is 32,000 psi, with elongation 7%. A white alloy used in France under the name of Palium Z for heavy-duty bearings contains 4.5% copper, 4 lead, 2.6 tin, 0.6 magnesium, 0.3 manganese, 0.3 zinc, and the balance aluminum.

**Bearing materials.** White metals and bronzes are most frequently used for machine bearings, but wood, glass, plastics, and other materials are also employed. Wood is one of the oldest of bearing materials, and is still considered an excellent material for large, low-pressure, and slow-speed bearings. The hardwoods are used, and since they absorb oil and grease little attention is required for lubrication. Lignum vitae was widely used for large marine main-shaft bearings until the introduction of molded, laminated, plastic bearings. The guaiac gum contained in lignum vitae softens at the bearing temperature and provides a good lubricant. The laminated plastic bearings with fabric base have a low coefficient of friction, and will operate with only water as the lubricant. Plastic bearings are also employed where electrical insulation is required. These materials have a compressive strength up to 36,000 psi. Plastic bearings are not easily wetted by water, and a small amount of alkaline sodium oleate is added to the water lubricant. Nylon bearings require no lubricant for light loads at high speed, and are suitable for textile machinery where oil might soil the fabrics. Rubber bearings are used where resilience is needed. Water may be used as the lubricant.

Almost any commercial metal can be used for bearings, but certain metals and alloys are particularly suited for bearings, chiefly because of the fact that a proportion of hard crystals occurs in a background, or matrix, of softer metal, thus supporting the shaft and permitting the free circulation of the lubricant. In the soft babbitt metals these crystals are formed largely by the antimony, while in the bronzes the crystals consist of a chemical compound of copper and tin. One of the metals must have wettability or affinity for lubricants because metal-to-metal contact usually results in high heat, scoring, and galling, or the tearing out of pieces of metal.

Cast iron is an excellent bearing metal because of the hard carbides, a soft background of iron, and considerable graphitic carbon which acts as a lubricant. The stainless steels are poor bearing metals and

tend to stick and seize. Brass is not much used for bearings since zinc causes sticking, but a bearing alloy known as Tissier's metal was a high-copper brass with 1% arsenic to give a crystalline structure. The alloy marketed by the Buckeye Brass & Mfg. Co. under the name of Hy-speed for high-speed bearings, contains 88% copper, 7 tin, and 5 zinc. In white metals the formation of the structure is affected by the melting times, and a well-cast alloy of inferior composition may result in a better bearing than a high-grade alloy that is poorly cast.

Aluminum bearings have high corrosion resistance against organic acids, good thermal conductivity, have higher strength than other white-metal alloys, and are equal to babbitts in antiseizure properties. They have the disadvantage of high coefficient of expansion. Aluminum alloys for bearings must have a matrix of aluminum through which are dispersed undissolved constituents. An alloy with 4% silicon and 4 cadmium is used. Other alloys have tin, nickel, and copper or silicon.

Unlike metals are invariably used for shaft and bearing, and the wear is taken in the bearing. The choice of a bearing metal is usually a compromise of hardness, compressive strength, coefficient of friction, and degree of lubrication. In general, the tin-base alloys have low coefficients of friction and are tough and capable of withstanding shocks, but the copper bronzes are capable of withstanding heavier loads. Between the two, almost any desired combination can be obtained, depending upon the proportions of copper, tin, antimony, and lead. Load-carrying capacity is figured on the projected area surface. Babbitts are usually limited to 300°F operating temperatures, and the tin and lead bronzes to 500°F. Nickel or silver in small amounts improves the hardness and strength of babbitts at higher temperatures. Some constituents of the alloys have a catalytic action on the lubricants. Tin in a bearing metal reduces the tendency of the lubricating oil to sludge, but the presence of an alkali metal may have an injurious effect on the oil.

Self-lubricating bearings may be porous white metals or bronzes impregnated with oils or graphite, or they may be oil-impregnated wood. Copper sponge, used for bearings, is made by molding a mixture of copper powder and a volatile organic material, sintering to drive off the volatile matter and adhere the copper particles, and then

impregnating the porous copper with lead. Molded carbon is also used for bearings where there is need for resistance to corrosive chemicals. Purabon 5, of the Pure Carbon Co., is a carbon-graphite mixture molded in the form of bearings and bushings for use in chemical and food equipment.

Widely various trade names are used to designate bearing materials. Ryertex is the name of a laminated plastic bearing material, and Aqualite, of the National Vulcanized Fibre Co., is the name of laminated plastic marine bearings. Parock, of Raybestos-Manhattan, Inc., is an oilless bearing made with graphite bonded with 20% vulcanized rubber. The coefficient of friction is 0.1 to 0.13 dry and 0.05 to 0.08 wet. Nolu is an oil-impregnated wood bearing of the Nolu Oilless Bearing Co., and Woodex is an impregnated wood bearing of the Neveroil Bearing Co. These woods are normally maple, but lignum vitae may be used. Phosphor lignum, of the latter company, is a hardwood oil-impregnated bearing. Powdiron, of the Bound Brook Oil-Less Bearing Co., is a porous iron sintered bearing that will hold up to 25% lubricant.

**Beech.** The wood of several species of beech trees, *Fagus atropunicea*, *F. ferruginea*, and *F. grandifolia*, common to the eastern parts of the United States and Canada. The wood is strong, compact, fine-grained, durable, and of a light color similar in appearance to maple. The weight is 47 lb per cu ft. It is employed for tool handles, shoe lasts, gunpowder charcoal, veneer, cooperage, pulpwood, and for small wooden articles such as clothespins. The beech formerly used for aircraft, *F. grandifolia*, has a specific gravity, oven-dried, of 0.66, a compressive strength perpendicular to the grain of 1,670 psi, and a shearing strength parallel to the grain of 1,300 psi. The wood may be obtained in large pieces, as the tree grows to a height of 100 ft and a diameter of 4 ft. It grows from the Gulf of Mexico northward into eastern Canada. White beech refers to the light-colored heartwood. Red beech is from trees with dark-colored heartwood. The sapwood of beech is white tinged with red and is almost indistinguishable from the heartwood. The wood is noted for its uniform texture and its shock resistance. Beech is used extensively in Germany for pulping to produce rayon.

Antarctic beech, *F. antarctica*, known locally as Rauli, grows exten-

sively in southern Chile. It is commonly called by the Spanish word Roble, or oak, in South America, and is used for cooperage to replace oak. It has a coarser grain than American beech. European beech, *F. sylvatica*, is reddish in color, has a close, even texture, is not as heavy as American beech, but is used for tools, furniture, and small articles. New Zealand beech, known as Red beech and Tawhai, is from the very large tree *Nothofagus solandri*. The wood weighs 44 lb per cu ft, is brown in color, and has high strength and durability. Silver beech, of New Zealand, is *N. menziesii*. The trees grow to a height of 80 ft and a diameter of 2 ft. The wood is light-brown, straight-grained, strong, and weighs 34 lb per cu ft. It is used for furniture, implements, and cooperage.

**Beef.** The edible meat from full-grown beef cattle, *Bos taurus*. The meat from the younger animals that have not eaten much grass is called Veal and is lighter in color and softer. The production of beef and beef products is one of the great industries of the world. In the industrial countries, much of the beef is prepared in organized packing plants, but also the production from city slaughterhouses is important. After slaughter and preparation of the animal, the beef is marketed in animal quarters either chilled or frozen. Fresh-killed beef from local slaughterhouses is also chilled to remove animal heat before marketing. The amount of marketable beef averages 55 to 61% of the live weight of the animal. The hide is from 5 to 7%, the edible and inedible fat and tallow are 3.5 to 7.5%, and the bones, gelatin, and glue material are 2.8 to 4.9%. The average live weight of cattle slaughtered in American packing plants is 980 lb. From 10 to 17% of the live weight may be shrinkage and valueless materials, although the Tankage, which includes entrails and scraps, is sold as fertilizer. Offal includes tongues, hearts, brains, tripe (stomach lining), livers, tails, and head, and may be from 3 to 5.5% of the live weight. The Glands are used for the production of insulin. Lipids is the name for a yellow waxy solid melting at 100°C, extracted from beef spinal cord after removal of cholesterol. It contains phosphatides and complex acids, and is used in medicine as an emulsifier and anticoagulant.

Canned beef, which includes Corned beef, Canned hash (beef mixed with potatoes), and various Potted meats, is not ordinarily

made from the beef of animals suitable for sale as chilled or frozen beef, but is from tough or otherwise undesirable meat animals, or from animals rejected by Government inspectors as not suitable for fresh beef. In the latter case the beef canned is held at high temperature for a sufficient length of time to destroy any bacteria likely to be in the fresh meat. Federal specifications for canned corned beef require freedom from skin, tendons, and excessive fat, and a maximum content of not more than 3.25% salt and 0.2 saltpeter. Beef extract was first made by Prof. Justus von Liebig in 1840 as a heavy concentrated paste that could be kept indefinitely. It is now made on a large scale in both paste and cube forms, and used for soups and hot beverages. Dehydrated beef is lean beef dried by mechanical means into flake or powder forms. It is semicooked and, when wet with water, resumes its original consistency but with a somewhat cooked taste. Its advantage is the great saving in shipping space. Beef is also marketed in the form of Dried beef, usually sliced and salted. Jerked beef, or Tasajo, is beef that has been cut into strips and dried in the sun. It is used in some Latin-American countries, but has a strong taste.

**Beeswax.** The wax formed and deposited by the honey bee, *Apis mellifica*. The bees build combs for the reception of the honey, consisting of two sheets of horizontal, six-angled prismatic cells formed of wax. After the extraction of the honey, the wax is melted and molded into cakes. New wax is light yellow, but turns brown with age. It may be bleached with sunlight or with acids. It is composed largely of a complex long-chain ester, Myricil palmitate,  $C_{15}H_{31}COOC_{30}H_{61}$ , and Cerotic acid,  $C_{25}H_{51}COOH$ . The specific gravity is 0.965 to 0.969, and the melting point  $63^{\circ}C$ . It is easily colored with dyes, and the Germans marketed powdered beeswax in various colors for compounding purposes. Beeswax is used for polishes, candles, leather dressings, adhesives, cosmetics, molded articles, as a protective coating for etching, and as a filler in thin metal tubes for bending. It is frequently adulterated with paraffin, stearin, or vegetable waxes, and the commercial article may be as low as 50% pure. The standards for the Toilet Goods Assoc. require that it shall contain no carnauba wax, stearic acid, paraffin, or ceresin, and shall not show more than 0.01% ash content. Beeswax is produced in many parts of the world as a

by-product of honey production from both wild and domesticated bees, the honey being used as a sweetening agent or for the making of alcoholic beverages. Honey varies greatly in flavor owing to the different flowers upon which the bees feed, but the chemical properties of both the honey and the wax vary little. Honey is composed largely of fructose. West Africa produces much wax from wild bees. Abyssinia is a large producer of beeswax, where the honey is used for making Tej, an alcoholic drink. The ancient drink known as Mead was fermented honey. Scale wax is produced by removing the combs from the hives, thus forcing production of wax which is dropped in scales or particles by the bees and prevented from being picked up by a screen.

**Bell metal.** A bronze used chiefly for casting large bells. The composition is varied to give varying tones, but the physical requirements are that the castings must be uniform, compact, and fine-grained. The standard is 78% copper and 22 tin, which alloy weighs 0.312 lb per cu in., is yellowish red, has a fine grain, is easily fusible, and gives a clear tone. Increasing the copper slightly increases the sonorous tone. Large bells of deeper tone are made of 75% copper and 25 tin. Big Ben, at Westminster, cast in 1856, contains 22 parts copper and 7 tin. Another bell metal, containing 77% copper, 21 tin, and 2 antimony, is harder, giving a sharper tone. An alloy for fire-engine bells contains 20% tin, 2 nickel, 0.1 silicon for deoxidation, and the balance copper. The nickel reduces the tendency to embrittlement from pounding. A bell metal marketed by the Lumen Bronze Co. contains 80% copper and 20 tin, deoxidized with phosphorus. Silver bell metal, for bells of silvery tone, is a white alloy containing 40% copper and 60 tin. This type of alloy, with tin contents up to as high as 60%, is also used for valves and valve seats in food machinery.

**Belt dressings.** Compounds employed to soften and improve the surface of belts used to drive machinery. They are usually compounded of waxes, degreas, fats, tallow, castor oil, fish oil, or corn oil, and may contain sulphonated oils or rosin. Vegetable oils, neats-foot oil, and fish oils act as lubricants for the leather, but mineral oils dissolve and soften the leather. Rosin is used to give grip to the belt, but it makes the leather dry and fills the pores so that the belt

cannot be lubricated. Belt dressings are marketed under many trade names.

**Ben oil.** A colorless to yellow oil obtained from the seeds of trees of the genus *Moringa*, notably *M. aptera*, *M. oleifera*, and *M. pterygosperma*, of Arabia, Egypt, India, and the Sudan. The latter species is also grown in Jamaica. The seeds contain 25 to 34% oil varying from a liquid to a solid, with specific gravity 0.898 to 0.902, saponification value 179 to 187, and iodine value 72 to 113. It is used in cosmetics and as a lubricant for fine mechanisms.

**Bentonite.** Also known as Wilkinite. A Colloidal clay which has the property of being hydrophilic, or water swelling, some clay absorbing as much as five times its own weight of water. It is used in emulsions, adhesives, for oil-well drilling mud, to increase plasticity of ceramic clays, and as a bonding clay in foundry molding sands. In combination with alum and lime it is used in purifying water as it captures the fine particles of silt. Because of its combined abrasive and colloidal properties it is much used in soaps and washing compounds. The Wyoming type, from Wyoming and South Dakota, has a soapy feel. It is a hydrous silicate of alumina containing about 62%  $\text{SiO}_2$ , 22  $\text{Al}_2\text{O}_3$ , 4 iron oxide, 4 of magnesia and calcia, and 2 of alkali metal oxides. The Mississippi type from the South differs only in physical properties. It does not swell like the Wyoming, and is much used for filtering and decolorizing oils. Volclay, of the American Colloid Co., is Mississippi bentonite. The magnesium bentonite of the desert areas of California, called Hectorite, is a colloidal magnesium silicate containing about 55% calcite in minute crystals. It is also distinguished from bentonite by a content of about 3% magnesium fluoride. The Eyrte, of F. E. Schundler Co., Inc., is this type of material marketed in 200 mesh and showing a fibrous structure under the electron microscope. It is used as an emulsifying and plastizing agent, as a clarifier, in adhesives and oil-drilling mud, and for paper filler.

**Benzene.** Also called by the German name Benzol. A colorless, highly inflammable liquid of the composition  $\text{C}_6\text{H}_6$ . It is an aromatic hydrocarbon product of coal tar obtained as a by-product of coke ovens or in the manufacture of gas, and also made synthetically from

petroleum. Its molecular structure is the closed benzene ring with six CH groups in the linkage, which forms a convenient basic chemical for the manufacture of a great variety of other chemicals. It is also an excellent solvent for waxes, resins, rubber, and other organic materials, although the fumes are toxic. It is also employed as a fuel or for blending with gasoline or other fuels. Industrially pure benzene has a distillation range from 78.1 to 82.1°C, a specific gravity of 0.875 to 0.886, and a flash point below 60°F. The pure nitration grade, used for nitrating and for making organic chemicals, has a 1°C boiling range starting not below 79.2°C, and a specific gravity of 0.882 to 0.886. Benzene has a characteristic odor, is soluble in alcohol but insoluble in water.

Nitrobenzene,  $C_6H_5NO_2$ , is a highly poisonous and inflammable liquid made by the action of nitric and sulphuric acids on benzene, used in soaps and cosmetics. It is called Myrbane oil as a perfuming agent. The nitrated derivative called Benzedrine, which has been used by aircraft pilots to ward off sleep, is Phenylaminopropane,  $C_6H_5 \cdot CH_2 \cdot CHNH_2 \cdot CH_3$ , a colorless liquid. It causes a rise in blood pressure and stimulates cerebral activity which lasts several hours, but it has a depressant effect on the intestinal muscles, causing loss of appetite and delayed activity of the stomach. Diphenyl carbonate,  $(C_6H_5)_2CO_3$ , is used for the manufacture of chemicals where two benzene rings are desired. It is a white crystalline water-insoluble solid melting at 78°C. Benzyl alcohol,  $C_6H_5CH_2OH$ , is a colorless liquid soluble in water, having a boiling point of 205.2°C and a freezing point of -15.3°C. It is also called Phenylcarbinol, and is used as a solvent for resins, lacquers, and paints. Benzyl chloride,  $C_6H_5CH_2Cl$ , is a colorless liquid of specific gravity 1.103 and boiling point 179°C, which was used as a lachrymatory poison gas in chemical warfare, and is employed in the production of molding plastics. Benzyl cellulose is a thermoplastic molding plastic of the Imperial Chemical Industries, Ltd., produced by the action of benzyl chloride and caustic soda on cellulose. The plastic is noninflammable, resistant to acids, can be molded easily, and is produced in various grades by different degrees of benzylation. Benzyl dichloride,  $C_6H_5CH \cdot Cl_2$ , is a liquid heavier than benzyl chloride and has a higher boiling point, 212°C, but was also used as a war gas and disseminated as a poisonous mist.



**Beryllium.** A steel-gray, lightweight, very hard metallic element, symbol Be, formerly known as Glucinum. The specific gravity is 1.84, melting point  $1285^{\circ}\text{C}$ , and hardness 6 to 7 Moh, or hard enough to scratch glass. The metal produced by the Goldschmidt electrolysis process is 99.5% pure, but is brittle and crystalline and is rolled only when hot. It does not corrode easily, as an oxidized film protects it from further oxidation. The pure metal is expensive, but has many uses, such as electrodes in neon signs, and for windows in X-ray tubes and atom-smashing cyclotrons as it will transmit certain short waves. Small amounts of beryllium will harden 18-carat gold to 300 Brinell. It combines with iron, and can be used for casehardening iron and steel. Its chief use is for hardening copper, producing the hard alloys known as beryllium bronze. The metal is marketed usually as a master alloy of Beryllium copper, with 12% beryllium and 88 copper, for making alloys.

Beryllium occurs very widely distributed in many minerals, but the chief ore is the mineral Beryl, and the high-grade ore comes mostly from Brazil, Argentina, India, Australia, and South Africa. The metal is expensive to reduce. Beryl,  $3\text{BeO} \cdot \text{Al}_2\text{O}_3 \cdot 6\text{SiO}_2 \cdot \text{H}_2\text{O}$ , occurs in pale-yellow rhombic crystals in pegmatite dikes. The crystals are  $\frac{1}{4}$  to  $\frac{1}{2}$  in. in diameter, with a specific gravity of 2.63 to 2.90, and a hardness of 7.5 to 8. The ore may contain up to 12% beryllium oxide, but most ore averages 4% metal. The Indian ore contains a minimum of 12% BeO, and the beryl of Ontario has 14% BeO, or 5 metallic beryllium. The rose-pink and rose-red variety of flawless beryl crystals found in Madagascar and known as Morganite is cut into gem stones. The colors are blue, green, and yellow. The dark-blue stone is made by the natives by heating green beryl in a pan over a fire. The Emerald is a flawless beryl colored green with chromium. High-grade natural emeralds are produced in Colombia. They have been found in the United States at only one place, North Carolina. The beautiful yellowish-green gem stone known as Brazilianite is not a beryl, but is a hydrous sodium-aluminum phosphate, and is softer. Synthetic beryl is made in Europe for use as bearings in watches and instruments. Igmerald is a German synthetic emerald. The Synthetic emeralds made by the Chatham Research Laboratories are grown from high-purity alumina, beryllia, and silica, with traces of  $\text{Cr}_2\text{O}_3$  and  $\text{Fe}_2\text{O}_3$  to give the green color. The secondary ores of

beryllium, Bertrandite, Herderite, and Beryllonite contain only slight quantities of the metal and are not commercial. Helvite is a complex mineral found associated with garnet in New Mexico and contains considerable beryllium. It has the composition  $3(\text{Be}, \text{Mn}, \text{Fe})_2\text{SiO}_4 \cdot (\text{Mn}, \text{Fe})\text{S}$ , is in cubical crystals of various colors from yellow through green to dark brown, and has the appearance of garnet. The specific gravity is 3.3, and hardness 6.5.

Artificial Beryllium oxide, a colorless to white crystalline powder of the composition  $\text{BeO}$ , has a specific gravity of 3.025, and a very high melting point,  $4660^\circ\text{F}$ . The oxide is known as Beryllia, and in mineralogy as Bromellite. It is used for refractories that must withstand great thermal shock. Because of its insulating value at high temperatures it is used for high-frequency insulators, and because of its great hardness it is valued as a grinding and polishing powder for hard metals. It is also used in fluorescent lamps, and in the nuclear reactions in the production of plutonium. The oxide has the property of transforming radiation of a given wave length into radiation of a longer wave length. Thin films of beryllia deposited on silver by cathodic treatment from a solution of beryllium salts are used to protect the silver from discoloration. The thin films are invisible, but heavier films give a faint iridescent coloring. Degussit is a German sintered beryllium oxide used to produce gastight glazes in ceramics. Beryllium compounds cause skin tumors, and also damage the lungs when inhaled.

**Beryllium bronze.** Alloys of copper and beryllium containing usually not more than 3% beryllium. They are sometimes designated as beryllium copper, although this term is more generally used to mean the master foundry alloys. The alloys are tough, hard, and have a bronzelike crystalline structure. They are noted for their fatigue resistance, and were first employed in Germany for locomotive bearings and for springs. Beryllium bronze is now employed for springs, nonsparking tools, plastic molds, and strong mechanical parts. Silicon in small amounts is added to beryllium bronze to harden and strengthen the alloy further by the formation of  $\text{Be}_2\text{Si}$ . Nickel and cobalt also form chemical compounds with beryllium. A small amount of nickel refines the grain and increases the ductility. It is especially useful for this purpose in castings. A very small

amount of iron, 0.25%, improves the structure and increases the hardness. A cast beryllium bronze produced by Ampco Metals, Inc., has 2.5% beryllium, and has a hardness of 325 to 375 when heat-treated. Berylco alloy 165, produced by the Beryllium Corp. in rods and strip, contains 1.7% beryllium. The No. 1 hard alloy has a tensile strength of 100,000 psi, can be bent 180° without fracture, and has an electrical conductivity 23% that of copper. Alloys for plastic molds usually have about 2% beryllium, and will harden to 365 Brinell. The wrought alloy called beryllium copper by the American Brass Co. has 2 to 2.5% beryllium and 0.25 to 0.50 nickel. The soft material has a tensile strength of 70,000 psi, elongation 45%, and hardness 110 Brinell, while the heat-treated alloy has a tensile strength of 193,000 psi, elongation 2%, and hardness 365 Brinell. It is valued for springs. Beryllium copper of this kind is also used for spot-welder contacts, and about 1.5% titanium may be added to give hardness stability at elevated temperatures. Wrought beryllium bronze is marketed regularly in the form of rods, wire, and strip.

A much used alloy contains 2% beryllium, 0.3 cobalt, and the balance copper. The annealed alloy has a tensile strength of 80,000 psi, and a Rockwell B hardness 85. When hardened, the tensile strength is 170,000 psi, and the Rockwell C hardness is 37. Ampcoloy 91, of Ampco Metal, Inc., Tuffalloy 55, of the Welding Sales & Engineering Co., and Trodaloy 1, of the General Electric Co., are Beryllium-cobalt alloys with 2.6% cobalt, 0.40 beryllium, and the remainder copper. The cast metal has a tensile strength of 90,000 psi, elongation 10%, and electrical conductivity 45% that of copper. The hardness is 96 Rockwell B. The wrought metal, used for springs and tips for soldering irons, has a tensile strength of 60,000 psi, and will withstand higher temperatures than regular beryllium bronze. This alloy, of the Wilber B. Driver Co., for resistance wire, is called Beraloy C. The Trodaloy 7, of the General Electric Co., contains 0.40% chromium, 0.10 beryllium, and the balance copper. It is used for high-strength electrical parts. A high-conductivity beryllium bronze for electrical parts has 0.50% beryllium and a small amount of silver. Tensile strength is 90,000 psi, and the electrical conductivity is 60 to 65% that of copper.

A Beryllium-cobalt alloy intermediate in physical characteristics between beryllium bronze and phosphor bronze contains only 0.5%

beryllium, with 2 to 3 cobalt, and the balance copper. The heat-treated alloy has a hardness of 92 to 98 Rockwell B, and an electrical conductivity 50 to 60% that of copper. A much used alloy contains 2% beryllium, 0.3 cobalt, and the balance copper. When heat-treated it has a tensile strength of 170,000 psi, and hardness 37 Rockwell C. Beryllium alloy 50, of the Beryllium Corp., contains 0.35% beryllium, 1.55 cobalt, and 1 silver. The tensile strength is up to 130,000 psi, and the electrical conductivity is 50% that of copper.

An alloy with 2.5% of beryllium and the balance nickel hardens to 600 Brinell when heat-treated. A Beryllium-nickel alloy for springs has 1.9% beryllium, 0.50 manganese, and the remainder nickel. The tensile strength, cold-rolled and heat-treated, is 200,000 psi, with elongation of 6%. It is noted for high torsional endurance. The fatigue-resistant properties of beryllium-copper alloys have been utilized in such uses as setting diamonds in drill bits. Vankalite is a trade name of a beryllium-copper alloy used for this purpose. Viculoy is the name of a group of beryllium bronzes of the Akron Bronze & Aluminum Co. for high-strength castings to replace aluminum bronze and manganese bronze for gears and corrosion-resistant marine parts.

**Bessemer steel.** Steel made by blowing air through molten iron. The process was developed by Henry Bessemer in England in 1860 and made possible for the first time the production of steel on a large scale. The process is now employed extensively as a preliminary step in the production of other steels, but much bar steel is made by this process. Ferromanganese and sometimes steel scrap are added to the steel when pouring into the ladle in order to regulate the content. In the blowing process the chemical action between the oxygen of the air and the molten mass increases the temperature, and the air then forms the chief fuel as the carbon is oxidized and driven off. The blowing requires only a few minutes, and the carbon is reduced to 0.04% or less. The carbon desired in the steel is then regulated by the addition of carbon to the melt. The two processes, known as acid and basic, differ in the type of refractories employed for lining the converters, and there is a difference in the resulting steel since the acid process does not remove as much sulphur and phosphorus. The acid process is used principally in the United States, and the basic process

is employed in Europe where the product is called Thomas steel. The lining of an acid converter is made of highly refractory acid material, usually ganister or mica schist. The converters are normally of 5 to 25 tons capacity. Acid Bessemer pig iron should contain about 1% silicon, but the sulphur and phosphorus must be low. An acid bessemer steel to be free cutting has a content of 0.09 to 0.13% phosphorus and 0.075 to 0.15 sulphur, but these amounts are too high for structural steels, so that bessemer steel is mostly employed in rod form for making screw machine products. A good quality acid bessemer steel contains about 0.15% carbon, 0.40 to 0.80 manganese, and up to 0.08 each of sulphur and phosphorus. For basic bessemer steel the converter has a basic lining of burned dolomite, and the basic bessemer iron has less silicon to avoid the production of much silica. The high-phosphorus pig irons of Europe are made into steel by this process, as the basic lining aids in the elimination of the phosphorus and sulphur, although lime is also added at the beginning of the blow. During the war, Synthetic steel scrap to replace ordinary steel scrap for open-hearth steel was made in bessemer converters by partly blowing and then casting into ingots for the furnace charge.

**Birch.** The wood of the birch trees, of which more than 15 varieties grow in the Northeastern and Lake states of the United States and in Canada, and other varieties in Europe and north Asia. The birch of north Europe is called Russian maple. The wood of the American birches has a yellow color, is tough, strong, hard, and close-textured, and polishes well. It has a fine wavy grain sometimes beautifully figured, and can be stained to imitate cherry and mahogany. Birch is used in construction work for trim and paneling, for furniture, and for turned articles such as handles, shoe pegs, clothespins, toys, and woodenware. The lumber usually includes the wood of several species. It has a specific gravity, oven-dried, of 0.68, a compressive strength perpendicular to the grain of 1,590 psi, and a shearing strength parallel to the grain of 1,300 psi. Yellow birch, *Betula lutea*, is the most abundant. It is also called Silver birch and Swamp birch. The commercial wood includes that from the Gray birch, *B. populifolia*. Sweet birch, *B. lenta*, ranks next in importance. It is also called Black birch, Cherry birch, and Mahogany birch, and

may be marketed together with yellow birch. Sweet birch may also include River birch, *B. nigra*, but sweet birch is a heavier and stronger wood. Paper birch, *B. papyrifera*, is the variety known as Canoe birch because the silvery-white flexible bark was used by the Indians in making canoes. It is also referred to as Silver birch, and is much used for pulpwood. It is similar to and mixed with White birch, *B. alba*, the wood of which is strong, elastic, and uniform, and is much used in Vermont and New Hampshire for making spools, bobbins, handles, and toys. Yellow birch of the Canadian border reaches a height of 60 to 80 ft and a diameter up to 2 ft. A 50-year-old tree has a diameter of about 5 in. and a height of 40 ft.

**Birch oil.** A viscous, yellowish, poisonous oil with a characteristic birch odor, obtained by distillation from Birch tar, which is a product of the dry distillation of the wood of the white birch tree. Birch oil has a specific gravity of 0.956. It contains phenols, cresol, and xylenol, and is used in disinfectants and in pharmaceuticals. It is also called Birch tar oil, and in pharmacy is known as Oil of white birch. Sweet birch oil, also known as Betula oil, is a lighter volatile oil distilled from the steeped bark of the *B. lenta*, or sweet birch. It contains methyl salicylate, and is used as a flavoring agent, in perfumes, in dressing fancy leathers, in cleaning solutions and soaps, and as a disinfectant to neutralize odors of organic compounds.

**Bismuth.** An elementary metal, symbol Bi, sometimes occurring native in small quantities. American bismuth is obtained chiefly as a by-product in the refining of lead and copper. Foreign bismuth comes largely from the mineral bismuthinite. The chief production of bismuth is in the United States, Peru, Canada, Bolivia, and Mexico. The metal has a grayish-white color with a reddish tinge, is very brittle, and powders easily. It thus has few uses in its pure state. The specific gravity is 9.75, melting point 271°C, and hardness 73 Brinell. The thermal conductivity is less than any other metal except mercury, and the coefficient of expansion is 0.00000731 per deg F. It is the most diamagnetic of all the metals. It has the property of expanding 3.32% when changing from the liquid to the solid state, which makes it valuable in type-metal alloys and in making small castings where sharp impressions of the mold are needed. The metal imparts to lead and tin alloys hardness, sonorousness, luster, and a lowered

melting point. By regulating the amount of bismuth the alloys can be cast to fill the mold without expansion or contraction on cooling. It is used in white alloys for molds for casting plastics, and because of the property of lowering of the melting point it is valued in fusible alloys and in soft solders. Very fine Bismuth wire used for thermocouples is drawn in glass tubes.

Bismuth steel, with a very small content of bismuth, is used for transformer sheets. It has increased electrical resistance without diminished electrical permeability and lowered hysteresis. About 0.5% bismuth is used in some 18-8 stainless steels instead of selenium to add machinability without impairing the corrosion resistance. Bismuth is also used in amalgams, and is employed in the form of its salts in pigments, in pharmaceuticals as an antacid, and in many chemicals. For medicinal purposes bismuth must be completely free of traces of arsenic. About 45% of the total bismuth production is used in pharmaceuticals, and about 30% in solders and white metals. The paint pigment known as Pearl white is Bismuth oxychloride,  $\text{BiOCl}$ , a white crystalline powder of specific gravity 7.717, insoluble in water. Another bismuth pigment is Bismuth chromate,  $\text{Bi}_2\text{O}_3 \cdot 2\text{CrO}_3$ , a water-insoluble orange-red powder. The material known in medicine as bismuth is Bismuth phosphate,  $\text{BiPO}_4$ , a white powder insoluble in water.

**Bismuthinite.** An ore of the metal bismuth, found in Bolivia, Peru, central Europe, Australia, and western United States. It is Bismuth trisulphide,  $\text{Bi}_2\text{S}_3$ , containing theoretically 81.3% bismuth. The richest Bolivian ores contain more than 25% bismuth, and concentrates from northwest Argentina contain 40 to 48% bismuth. The mineral has a massive foliated structure with a metallic luster, a lead-gray streaked color, and a hardness of 2. The concentrated ore is roasted and smelted with carbon, and the resulting impure bismuth is refined by an oxidizing fusion. Other bismuth ores are Bismite, or Bismuth ocher,  $\text{Bi}_2\text{O}_3 \cdot 3\text{H}_2\text{O}$ , containing theoretically 80.6% bismuth, and Bismutite,  $\text{Bi}_2\text{O}_3\text{CO}_3 \cdot \text{H}_2\text{O}$ , containing theoretically 78.3% bismuth, both of which are widely distributed minerals.

**Bituminous coal.** Also called Soft coal. A variety of coal with a low percentage of carbon, and easily distinguished from anthracite by the property of losing moisture and breaking up into small pieces.

Because of its cheapness it is the coal used most extensively for industrial fuel, but is not preferred for household use because of its smoke and odor. However, considerable of the fine or powdered coal called Slack coal is used in making fuel briquettes. Bituminous coal is widely distributed in many countries, and is found in 28 states of the United States. The estimated American reserves are 1,400 billion tons, with a normal production exceeding 350 million tons annually. Much low-grade coal is also available, the Bureau of Mines estimating that the coal fields of the United States cover 350,000 sq mi, or one-ninth of the total area of the country. Much bituminous coal is used for the production of coke, coal tar, and chemicals. The bituminous coals vary in quality from near lignite to the hard grades near anthracite, called Semibituminous coal, depending upon their geologic age. They are not true bitumens. The specific gravity of clean bituminous coal is 1.75 to 1.80. The best steam coals are the semibituminous grades from West Virginia, Virginia, Pennsylvania, and some parts of the Middle West. The latter is very compact and is extracted in large blocks, called Block coal. Good coals for industrial use should give 13,500 to 14,500 Btu per lb, have from 55 to 60% fixed carbon, and 30 to 37 volatile matter. The best grades are in lumps. The Coking coals are the higher-carbon grades low in sulphur, and with capacity to leave the residue coke in large firm lumps. Seacoal is a name for finely ground bituminous coal used in sand mixtures for molds for cast iron to prevent fusing of the sand to the castings. A high-volatile, low-ash, low-sulphur coal is used for this purpose.

**Blackbutt.** The wood of several species of fast-growing eucalyptus trees native to Australia but now grown in other countries and sometimes used as a substitute for oak. The trees include *Eucalyptus pilularis* and *E. patens*. The wood is gray to brown in color, is hard, close-grained, tough and durable, but is inclined to warp and crack. The weight is about 58 lb per cu ft.

**Blackfish oil.** A pale-yellow waxy oil extracted from the Pilot whale, Porpoise, or Blackfish, *Globicephala melas*, found off the North Atlantic Coast as far south as New Jersey, and the *G. ventricosa* of other seas. The blackfish averages 15 to 18 ft in length, with a weight of about 1,000 lb. The oil has a saponification value of 290, iodine value 27, and specific gravity 0.929. The Dolphin oil.



of the common dolphin, *Delphinus delphis*, of all seas, is also classed as blackfish oil, as is also the oil of the Killer whale, *Grampus orca*, of all seas. The oil is used as a lubricant for fine mechanisms, in cutting oils, and for treating leather. The product from the head and jaw is of the best quality, and is known as Jaw oil, although the best grade of sperm oil is also called jaw oil. The jaw oil from blackfish does not oxidize easily, and is free flowing at low temperatures, having a pour point of  $-20^{\circ}$  F. It consists of 71% mixed acids, of which 86% is Valeric acid,  $C_4H_9COOH$ , and 13% oleic and palmitic acids.

**Boiler plate.** Originally, a high-grade plain iron or steel plate of  $\frac{9}{16}$  in. thickness or heavier, used for making steam boilers, but the term came to mean plate of this kind for any purpose, and plates  $\frac{1}{4}$  in. thick or thinner are referred to as sheet. Actually, boiler plates for boilers, tanks, and chemical equipment, and Flange plates for dished ends, are now made in various alloy steels to incorporate high strength, corrosion resistance, and creep resistance, and also in clad steels. Ordinary boiler plate is divided into firebox, flange, and extra-soft. A plain steel firebox plate contains not more than 0.30% carbon, 0.30 to 0.50 manganese, and not more than 0.40 each of sulphur and phosphorus. Flange plates contain less carbon. The tensile strength is about 60,000 psi. Boiler-tube steel may be carbon steel or alloy steels, and may be hot-rolled or cold-drawn. But the tubes are given an internal hydrostatic test and marked with the test pressure used.

**Bone black.** Also called Animal charcoal and Bone char. Charred bone ground to a fine silky powder for use as a pigment or as a decolorizing agent for sugar and oils. It has a deep, dense, bluish-black color especially valued for engraving inks of depth and tone, and also to give a dull velvety black finish to coated paper. Its covering power, however, is inferior to that of carbon black, as it has only about 10% carbon and has a very high ash content. The best blacks may be treated with acid to remove the lime salts. Federal specifications for bone black for pigment require that 97.5% shall pass through a 325-mesh screen. For filtering, the material is used from 4 to 16 mesh. The specific gravity is 2.6 to 2.8. Bone black is made by calcining dried bones in airtight retorts after they have been freed

from fat and ground to a coarse powder. One short ton of dried bones yields about 700 lb of bone black. About 75% of the bone black production is used for refining sugar and sirups. It may be sold under trade names such as Filt-char. Drop black is the spent bone black from the decolorizing of sugar, which has been washed and reground for pigment use. Ivory black, having the same uses as bone black, is made by heating the refuse of ivory-working in a closed retort and then grinding to a fine powder. Aquablak No. 1, of the Binney & Smith Co., is a colloidal water dispersion of bone black used to give a velvety black color to inks, water paints, and leather finishes.

**Bones.** The dried bones from cattle and from Asiatic buffalo form an important item in international commerce. In general, organized packing plants do not ship much bone, but utilize it for the production of glue, gelatin, bone meal, and fertilizer. The bones shipped from packing plants are called Packer bones, but the source of much commercial bone is from slaughterhouses, local retail meat shops, and the bones from farms and fields known as Prairie bones and Camp bones, the latter name being from the Argentine word campo, meaning field. Tabulated production of commercial bone in the United States is less than 50,000 short tons annually, which is only a small part of bone available from animal slaughter, but in Europe the production of commercial bone more nearly approaches the available bone. American imported bone comes from Argentina, Canada, Cuba, Uruguay, Brazil, South Africa, and India. Selected flat shinbones are used for making buttons, knife handles, novelties, and artificial antler. Large quantities were formerly used for making brush handles, but for this use plastics are now employed.

In processing bones for buttons and handles about 90% of the bone is scrap pieces and sawdust which is made into Raw bone meal for packing steel for heat-treatment, for making gelatin, and for fertilizer. Casehardening bone, for carbonizing steel, and Bone meal, for animal feed, are processed to remove fats and prevent rancidity, and also steam-sterilized. Fertilizer bone is bone meal that is of too fine mesh for carbonizing use or for making bone black, but it is not cooked or processed, and has an analysis of about 45% ammonia and 50 phosphate of lime. Knucklebones, and also the hard shinbones,

are preferred for gelatin manufacture. Dissolved bone, used for fertilizer, is ground bone treated with sulphuric acid, or the residue bone after dissolving out the gelatin with acid. The Steamed bone meal produced as a residue by-product of the glue factories and soup factories is suitable only for fertilizer, but it contains only 1% ammonia. The steamed bone meal for animal feed is merely steam-sterilized raw bone.

Bone oil, used in sheep dips and disinfectants, and in insecticides and fungicides, is a chemically complex oil with a pungent disagreeable odor derived as a by-product in the destructive distillation of bones. It contains nitrides, pyrroles, pyridine, and aniline.

**Borax.** A white or colorless crystalline mineral used in glass and ceramic enamel mixes, as a scouring and cleansing agent, as a flux in melting metals and in soldering, as a corrosion inhibitor in anti-freeze liquids, as a constituent in fertilizers, in the production of many chemicals and pharmaceuticals, and as a source of boron. Borax is a hydrous Sodium borate, or tetraborate, first obtained from Tibet under the Persian name Borak, meaning white. Tincal is the natural borax,  $\text{Na}_2\text{O} \cdot 2\text{B}_2\text{O}_3 \cdot 10\text{H}_2\text{O}$ , obtained originally through Persia from Tibet, and later found in quantity in western United States. The specific gravity is 1.75, hardness 2 to 2.5, and melting point  $1125^\circ\text{F}$ . It contains 47.2% water, and is readily soluble in water. The borax from California and Nevada known as Colmanite is Calcium borate,  $2\text{CaO} \cdot 3\text{B}_2\text{O}_3 \cdot 5\text{H}_2\text{O}$ . That known as Kernite, or Rasorite, is another variety of Sodium borate of the composition  $\text{Na}_2\text{O} \cdot 2\text{B}_2\text{O}_3 \cdot 4\text{H}_2\text{O}$ . Ulexite, or Boronatocalcite, is found in western United States, Chile, Bolivia, and Peru, and has the composition  $\text{Na}_2\text{O} \cdot 2\text{CaO} \cdot 5\text{B}_2\text{O}_3 \cdot 16\text{H}_2\text{O}$ , but the ulexite of Chile and Bolivia is also mixed with sodium and calcium sulphates and sodium and magnesium chlorides. The dried mineral contains 45 to 52% boric acid. Priceite, or Pandermite, chiefly from Asia Minor, is  $5\text{CaO} \cdot 6\text{B}_2\text{O}_3 \cdot 9\text{H}_2\text{O}$ . Borax is found in great quantities in the desert regions of the western states, and in the Andean deserts of South America, where the borate deposits are in land-locked basins at altitudes above 11,000 ft. The colmanite is usually associated with ulexite, shale, and clay, and is concentrated to 40%  $\text{B}_2\text{O}_3$ . Kernite ore from Kern County, California, contains about 29%  $\text{B}_2\text{O}_3$  and is concentrated to

45%. Federal specifications for borax call for not less than 99.5% hydrous sodium borate in three grades from large crystals to fine white powder. Pyrobar is a crystalline anhydrous borax of the American Potash & Chemical Co., produced from the brine of Searles Lake.

**Boric acid.** Also called Boracic acid and Orthoboric acid. A white, crystalline powder of the composition  $B_2O_3 \cdot 3H_2O$ , derived by adding hydrochloric or sulphuric acid to a solution of borax and crystallizing. It is also obtained from the boron ores of California, Chile, Bolivia, and Peru as one of a number of chemicals. It occurs naturally in volcanic fissures in Italy as the mineral Sassolite,  $B_2O_3 \cdot 3H_2O$ . The specific gravity is 1.435 and melting point  $1050^\circ F$ . It is soluble in water and in alcohol. Boric acid is used as a preservative and weak antiseptic, in glass and pottery mixes, in the tanning industry for deliming skins by forming calcium borates soluble in water, as a flux in soldering and brazing, for surface-hardening steels, and in cosmetics and pharmaceuticals.

**Borneo tallow.** A hard, brittle, yellowish-green solid fat obtained from the seed nuts of trees of the family *Dipterocarpaceae* of Borneo, Java, Sumatra, and Malaya. They include the *Shorea aptera*, *S. robusta*, *S. stenoptera*, *Hopea aspera*, and *Pentacme siamensis*, which trees also produce copals and valuable woods. The kernels of the nuts of the *S. stenoptera* contain 45 to 60% fat, which is used chiefly as a substitute for cocoa butter. It contains 39% stearic acid, 38 oleic, 21.5 palmitic, and 1.5 myristic acid. The specific gravity is 0.852 to 0.860, saponification value 185 to 200, iodine value 29 to 38, and melting point  $34$  to  $39^\circ C$ . The seeds are exported as Sarawak illipé nuts or Pontianak illipé, but they are not the same as the Illipé nuts and Illipé tallow from the species of *Bassia* of India. Illipé butter, also called Mowrah butter and Bassia butter, is from the seed nuts of the trees *B. longifolia* and *B. latifolia*, of India. The oil content of the seeds is 50 to 60%. The crude fat is yellow to green in color, but the refined product is colorless with a pleasant taste. It is used as a food, and in soaps and candles. Phulwa butter, or Indian butter, is from the seed nuts of the *B. butyracea* of India. It is white, stiffer than lard, and is used as a food. Siak tallow is from the *Palanquium oleosum* of Malaya. The

fat is yellow to greenish, and is used as a substitute for cocoa butter. Jaboty fat is a similar heavy oil from the kernels of the fruit of the tree *Erisma calcaratum* of Brazil. It contains 44% palmitic acid, 28 myristic, and 4 stearic acid, and has a melting point of 40 to 46°C. The tropical forests of Brazil, Africa, and southern Asia abound in trees that produce a great variety of nuts from which useful fats and oils may be obtained.

**Boron.** A metallic element, symbol B, closely resembling silicon. When pure, it is in the form of hard red crystals of specific gravity 2.45, or a brownish amorphous powder of specific gravity 1.73. At about 600°C it ignites and burns with a brilliant green flame, but its melting point in a nonoxidizing atmosphere is about 2300°C. It is obtained by the electrolysis of fused boric oxide from the mineral borax, but it is used only in its compounds, the most widely used of which are borax and boric acid. Minute quantities of boron are used in steels for casehardening by the nitriding process to form a boron nitride, and in other steels to increase strength and hardness penetration. In these steels as little as 0.003% is beneficial, forming an iron boride, but above about 0.008% the steel becomes brittle and hot-short. Boron steels are used for crankshafts and for hot-rolled spring steels. In cast steels for hard tools as much as 1.5% boron may be used, but these steels cannot be forged or machined. In cast iron, boron inhibits graphitization and serves as a deoxidizer. It is added to iron and steel in the form of ferroboration made by reducing boric acid in molten iron. Electromet ferroboration, of the Electro Metallurgical Co., has 18 to 25% boron and 3 max each of silicon and aluminum. Boron compounds are employed for fluxes and deoxidizing agents in melting metals. Boron trichloride,  $\text{BCl}_3$ , is a fuming liquid of specific gravity 1.434 and boiling point 12.5°C, used as a catalyst, as a chlorinating agent, and in the production of borates and borides. In combination with carbon, boron forms the hard abrasive boron carbide, and in combination with chromium it forms the hard abrasive Chromium boride,  $\text{CrB}$ , marketed under the name of Colmonoy for oil-well drilling.

**Boron carbide.** A fine, black, crystalline powder of great hardness used as an abrasive or compressed into drawing dies, gages, pestles, and pharmaceutical mortars. It is made by fusing together boric acid and

carbon in an electric furnace. The composition is either  $B_6C$  or  $B_4C$ . The boron carbide of the first composition is extremely hard and crystalline, but it contains an excess of flake graphite mixed with the carbide. It can be used thus as a deoxidizing agent for casting copper, and also as a lapping abrasive since the graphite acts as a lubricant. Boroflux, of the General Electric Co., is boron carbide with flake graphite used as a flux. The boron carbide marketed by the Norton Co. under the name of Norbide is  $B_4C$ , and is free of graphite. It is used as a hard abrasive, and in molded form for plug and ring gages. Boron carbide molded without a binder has a compressive strength of 300,000 psi, and for gages gives an extremely long wear life since the hardness is above 9 Moh. The coefficient of expansion is 0.0000045 per deg C, or only one-third that of steel, and it has a density of 2.52, or less than that of aluminum. The melting point is about  $2450^{\circ}C$ . Boron carbide powder for grinding and lapping comes in standard mesh sizes up to 240, and in special finer sizes up to 800. The usual grinding powders are 220 and 240, and the finishing powder is 320.

**Boxwood.** The wood of the Turkish boxwood tree *Buxus sempervirens*, native to Europe and Asia but also grown in America. It is used for rulers, instruments, engraving blocks, and inlay work. The wood is light yellow, hard, and has a fine grain and a dense structure that does not warp easily. The weight is about 65 lb per cu ft. African boxwood, or Cape boxwood, comes from the tree *B. macowanii*, of South Africa, and is similar to boxwood but is softer. Kamassi wood is a hard, fine-grained wood from the tree *Gonioma kamassi*, of South Africa, sometimes substituted for boxwood, but it does not have the straight grain of boxwood. It is valued for loom shuttles. Coast gray boxwood, or Gippsland boxwood, of New South Wales, is from the tree *Eucalyptus bosistoana*. It is a durable wood of uniform texture but it has an interlocking grain. The Maracaibo boxwood, or Zapatero, which comes chiefly from Venezuela, is from the tree *Casearia praecox*. It comes in straight knotless logs 8 to 10 ft long and 6 to 10 in. in diameter. The light-yellow wood has a fine uniform texture and straight grain. It replaces Turkish boxwood for all purposes except for wood engravings. The Ginkgo wood used in China for making chessmen and chessboards is from the large tree

*Ginkgo biloba* which appears to be the sole survivor of a family of trees with fernlike leaves once very abundant. The wood is white to yellowish, light in weight, fine textured, and easy to work.

**Brake lining.** A term generally referring to the treated and compressed fabric materials for lining the brake bands of motor vehicles and machinery, and not including wood block linings. Brake linings may be impregnated woven fabrics, or they may be compressed fibers cemented together with a heat-resistant binder. The binder may be rubber, synthetic rubber, plastic, or a silicate. The coefficient of friction of asbestos fabric against steel is from 0.27 to 0.38, as compared with 0.16 for cast iron against steel. This coefficient may be increased still further with treated binders, or it may be reduced with interwoven wire. A typical brake lining is made by twisting asbestos yarns with fine wire strands, treating with silicate of soda solution, and then weaving into a fabric which is impregnated with rubber or other frictional binder and subjected to heat and pressure. In Germany, aluminum or steel wire of a diameter of 0.03 mm was used as a substitute for asbestos and bonded with synthetic rubber. Brake linings are usually marketed under trade names. Raybestos, of Raybestos-Manhattan, Inc., is brake lining and Clutch lining of various grades made of asbestos fibers and fine wire impregnated and bonded under pressure. The coefficient of friction is 0.45. Autobestos, of the Keasbey & Mattison Co., is made of chrysotile fiber molded with a binder.

**Brass.** An alloy of copper and zinc, although some brasses also contain other elements. The brasses constitute one of the most important groups of alloys because of their ease of working, corrosion resistance, and attractive appearance. They are more ductile than corresponding copper-tin alloys, or bronzes, but are not as hard and do not contain the hard crystals that make bronzes valuable as bearing metals. Zinc added to copper causes a progressive lowering of the melting point, from the 1949°F of the 95-5 brass to the 1616°F of the 50-50 brazing metal. Ten per cent of zinc gives a bronze color; 15%, golden; from about 20 to 38% the color is yellow. When the zinc exceeds 45%, the color becomes silvery white, and the alloy is brittle, rapidly losing the characteristics of brass. The maximum ten-

sile strength is reached at 55% copper, and the maximum ductility at about 70% copper content.

Alpha brass is the form of brass having less than 36% zinc all dissolved in the copper, and the alloy has the same structure as copper. It is easily cold-worked. Beta brass, with the zinc between 36 and 45%, contains the compound  $\text{CuZn}$ . It is the best brass for hot working. Gamma brass, with the zinc above 45%, has  $\text{Cu}_2\text{Zn}_{11}$  crystals in the alloy, and is not easily worked either hot or cold. More than 75% of all commercial wrought brass is the alpha brass known as high brass with 65% copper and 35 zinc, but the 70-30 alpha alloy called cartridge brass is widely used for deep drawing. The standard red brass of the mills, containing 85% copper and 15 zinc, is much used for hot-water pipes for corrosive conditions. The 80-20 alloy known in the mills as low brass is very ductile, easily drawn, and has a fine golden-yellow color. It is much used for cheap jewelry and novelties.

Although the tensile strength of cold-worked brass is high, 85,000 psi for the 60-40 muntz metal, the modulus of elasticity is much lower, proportionally, than that of steel. Brass is annealed for drawing and bending by quenching in water from a temperature of about  $1000^{\circ}\text{F}$ . Simple copper-zinc brasses are made in standard degrees of temper, or hardness. This hardness is obtained by cold rolling after the first annealing, and the degree of hardness depends upon the percentage of cold reduction. When the thickness is reduced one number of the Brown & Sharpe gage, or about 10.9% reduction, the resulting sheet is known as  $\frac{1}{4}$  hard. The other grades are  $\frac{1}{2}$  hard, hard, extra hard, spring, and finally extra spring, which is a reduction of 10 numbers on the Brown & Sharpe gage, or about 68.7% reduction without intermediate annealing. Degrees of softness in annealed brass are measured by the grain size, and annealed brass is furnished in grain sizes from 0.010 to 0.150 mm. The ASTM standard grain sizes are: 0.015 to 0.025 mm for light anneal, 0.035 mm for drawing or rod anneal, 0.050 mm for intermediate anneal, 0.70 mm for soft anneal, and 0.120 for dead-soft anneal. Brasses with smaller grain sizes are not as ductile as with larger grain sizes, but they have smoother surfaces and require less polishing.

Even slight additions of other elements to brass alter the character-



istics drastically. Slight additions of tin change the structure, increasing the hardness, but reducing the ductility. Small amounts of tin, arsenic, or antimony are added to the Naval brasses used for condenser tubes in order to inhibit dezincification from the corrosive salts in the water. Admiralty metal usually has 0.01% arsenic to prevent corrosion, and some tin to increase strength and hardness. Lead in small amounts improves the cutting qualities of brass, but reduces the ductility and the impact strength. The alloys known as clock brass contain lead. Iron hardens the alloy and reduces the grain size, making it more suitable for forging, but making it difficult to machine. Manganese increases the strength, increases the solubility of iron in the alloy, and promotes the stabilization of aluminum, but makes the brass extremely hard. Such alloys are called manganese bronze rather than brass. Slight additions of silicon increase the strength of brass, but large amounts promote brittleness, loss of strength, and danger of oxide inclusions. Nickel increases strength and toughness, but when any silicon is present the brass becomes extremely hard and more a bronze than a brass.

Casting brasses are usually made from brass ingot metal and are seldom plain copper-zinc alloys. The most widely used alloy is the one usually designated as composition metal, containing 85% copper, 5 tin, 5 zinc, and 5 lead. In melting brass for casting, any overheating causes loss of zinc by vaporization, thus lowering the zinc content. Small amounts of antimony, or some arsenic, are used to overcome this dezincification. The casting brasses are roughly divided into two classes as red casting brass and yellow casting brass, which are various compositions of copper, tin, zinc, and lead to obtain the required balance of color, ease of casting, hardness, and machining qualities.

**Brass ingot metal.** Commercial ingots made in standard composition grades and employed for casting various articles designated as brass and bronze. They are seldom true brasses, but are composition metals intermediate between the brasses and the bronzes, and their selection for any given purpose is based on a balance of the requirements in color, strength, hardness, ease of casting, and machinability. Brass ingot metal is usually made from secondary metals, but, in general, the grading is now so good that they will produce high-grade uniform castings. In producing the ingot metal there is careful sort-

ing of the scrap metals, and the impurities are removed by remeltings. An advantage of ingot metal over virgin metals is the ease of controlling mixtures in the foundry. The ASTM designates eight grades for brass ingot metal. No. 1 grade, the highest in copper, contains 88% copper, 6.5 zinc, 1.5 lead, and 4 tin, with only slight percentages of impurities. The No. 8 grade contains 63.5% copper, 34 zinc, 2.5 lead, and no tin. The Red brass ingot, of H. Kramer & Co., contains 80 to 82% copper, 3 to 4 tin, 5 to 7 lead, and the balance zinc. Yellow ingot, for plumbing fixtures, contains 65% copper, 1 tin, 2 lead, and the balance zinc. The most widely used ingot metal is the ASTM alloy No. 2, which is the 85-5-5-5 alloy known as composition metal. Yellow brass, or Yellow casting brass, is frequently cast from ASTM ingot No. 6, which contains 72% copper, 22 zinc, 4 lead, and 2 tin. It has a tensile strength of 20,000 to 25,000 psi, elongation 15 to 20%, Brinell hardness 40 to 50. It is yellow in color, and makes clean, dense castings suitable for various machine parts except bearings.

**Brazil nuts.** Also called Para chestnut. The nuts of the large tree *Bertholletia excelsa* growing wild in the Amazon Valley. The trees and nuts are called Tacari in Brazil and Toura in French Guiana. The tree begins to bear in 8 years and yields up to 1,000 lb of large round fruit pods containing 18 to 24 hard-shelled kernels which are the commercial nuts. The shelled kernels are several times the size of the peanut, and have a pleasant nutty flavor. The kernels contain 67% of a pale yellow oil of specific gravity 0.917, saponification value 192 to 200, and iodine value 98 to 106. The oil contains 51% oleic acid, 19 linoleic, 2 myristic, 3 stearic, and 12 palmitic. It is a valuable food oil, and is also a good soap oil, but is normally too high in price for this purpose as the nuts are more valued for eating as a nut or for confections.

**Brazilwood.** The wood of the trees *Caesalpinia brasiliensis*, *C. crista*, and *C. echinata*, of tropical America, and *C. sappan*, of Ceylon, India, and Malaya. The latter species is called Sappanwood. Brazilwood formerly constituted one of the most valuable exports from Brazil to Europe as a dyewood. It produces purple shades with a chrome mordant and crimson with alum. Brazilwood extract is still valued for silk dyeing, wood staining, and for inks. The wood is

prized for such articles as violins and fine furniture. It has a rich bright-red color, and takes a fine, lustrous polish.

**Brazing metal.** A common name for high-copper brass used for the casting of such articles as flanges that are to be brazed on copper pipe. Federal specifications for brazing metal call for 84 to 86% copper and the balance zinc. Brazing brass, of the American Brass Co., has 75% copper and 25 zinc. Some alloys also contain up to 1% lead for ease of machining. It also makes the metal easier to cast, as the high-copper brasses are difficult to cast. A brazing brass of the U.S. Navy contains 0.3% lead. The term brazing metal is also applied to Brazing rods of brass or bronze used for joining metals. The joining of iron or steel by brazing is essentially different from welding in that the brazing metal has a lower fusion point than iron, and the base metal is not fused. It is a type of high-temperature soldering, although there is some surface alloying between the brazing metal and the base metal. A common brazing rod is the 50-50 brass alloy with a melting point of 1616°F. The SAE designates this alloy as Spelter solder. The joints made with it are inclined to be brittle. Brazing wire, of the Chase Brass & Copper Co., contains 59% copper and 41 zinc, while the Brazing solder, for brazing high-zinc brasses, has 51% copper and 49 zinc. The Phos-copper, of the Westinghouse Electric Corp., is a phosphor copper which gives joints with 98% the electrical conductivity of copper. It flows at 1382°F.

Brazing rods for brazing brasses and bronzes are usually of a composition similar to that of the base metal. For brazing cast iron and steel, various bronzes, naval brass, manganese bronze, or silicon bronze may be used. Brass rods may contain some silicon to lessen the vaporization by forming a film. Sifbronze, an English brazing rod, contains some ferromanganese and tin. It gives high-strength joints. Small amounts of silver added to the high-copper brazing metals give greater fluidity and better penetration into small openings. A series of brazing alloys of varied compositions to give a range of colors, hardnesses, and strengths, is marketed by the Eutectic Welding Alloys, Inc., as Eutechrom, Eutecrod, and Bronzochrom.

**Brick.** The most ancient of all artificial building materials, consisting of clay molded to standard shape, usually rectangular, and burned to a hard structure. In some areas bricks, known as Adobe

bricks, are still made by baking in the sun, and a modern adaptation of sun-baked brick, called Bitudobe, has a binder of emulsified asphalt. Commercial bricks in the United States and in Europe are all of hard-burned clay. They are used for buildings, walls, and paving, and are classified apart from the bricks of fireclays used for refractories. Brick clays are of two general classes. The first consists of noncalcareous clays or shales composed of true clay with sand, feldspar grains, and iron compounds, which when fired become buff, or salmon in color. The second class comprise calcareous clays containing up to 40% calcium carbonate, and are called Marls. When fired, they are yellowish. Brick clays of the first type are widely distributed. Iron oxide in them varies from 2 to 10%, and the red color of common brick depends largely on this content. In practice the composition of bricks varies widely, but much of the difference is also in the burning as well as in the method of pressing. Pressed brick is a stiff mud brick made under high pressure. It is homogeneous, and has increased density and strength. Building brick made by machine of ground and tempered clay has great uniformity of strength and color. Such brick is made by pressing soft, stiff, or dry. The burning is done in kilns at temperatures from 900 to 1250°C. The calcareous clays require a temperature of 1200°C to bring about chemical combination. The bricks are sorted according to hardness and color, both largely resulting from their position in the kiln. The hardest bricks are used for paving, and Paving brick is usually a hard-burned common brick. Floor brick is highly vitrified brick. The common hard brick for building has a crushing strength of 5,000 to 8,000 psi, and weighs 125 lb per cu ft. The common standard for building brick size is  $8\frac{1}{4}$  by 4 by  $2\frac{1}{2}$  in.; other sizes are also used, especially 8 by  $3\frac{7}{8}$  by  $2\frac{1}{4}$ . Specially sized paving bricks are  $8\frac{1}{2}$  by 4 by 3 or  $8\frac{1}{2}$  by 4 by  $3\frac{1}{2}$  in. Sand-lime bricks for fancy walls are of sand and lime pressed in an atmosphere of steam. They are not to be confused with the sand-lime bricks used for firebrick, which are of refractory silica sand with a lime bond. Various types of ceramic glazes and semi-glazes are used on some building bricks, especially on the yellow bricks.

**Bristles.** The stiff hairs from the back of the hog, used chiefly in making brushes. The very short bristles, rejects, and scrap pieces are

used for filler in plastics. The best brush bristles do not include hair from the sides of the animals, nor the product from the fat meat animals killed in the slaughterhouses. They come mostly from types of semiwild swine grown in cool climates, notably northern China and Russia. Bristles are in form similar to a tiny tube outwardly covered with microscopic scales and filled with a fatty substance. The so-called flag, or split end, gives the valuable paint-carrying characteristic for brushes. The taper of the bristle gives the brush stiffness at the base and resiliency toward the end. Quality varies according to the type of animal, climate, and feeding. The colors are white, yellow, gray, and black. They are graded by locality, color, and length, and in normal times the name of the place at which they are graded, such as Tsingtao, Hankow, and Chungking, is an indication of the grade. The best fibers are more than 3 in. in length. The Chinese natural black bristles are sometimes sold at a premium. American bristles from Chester hogs are light in color and are of high quality. Bristles from the Duroc hog are bronze in color, are stiff, and are superior to most Chinese grades. Those from the Poland China hogs are black and stiff, but they have a crooked flag and are of poor quality. Artificial bristles of high quality are made of nylon fibers. Casein bristles are made by extruding a hydrochloric acid solution of casein, stretching the fiber, and hardening with parabenzoquinone and formaldehyde. These fibers have good paint-carrying capacity and good wear resistance, but are dissolved by some paint solvents.

**Bromine.** An elementary material, symbol Br. It is a reddish-brown liquid having a boiling point of  $58^{\circ}\text{C}$ . It gives off very irritating fumes, and is highly corrosive. It belongs to the halogen group of elements, and is less active than chlorine but more so than iodine. It is soluble in water. Bromine never occurs free in nature, but is obtained by electrolysis of salt solutions, and is marketed 99.7% min purity with specific gravity not less than 3.1. It occurs in sea water to the extent of 60 to 70 parts per million, or 0.006%. A pound of bromine is obtained from 2,000 gal of sea water. It is also produced as a by-product from the brine wells of Michigan, and from the production of chemicals at Searles Lake, California, at which lake the bromine concentration is 12 times that of sea water. It is used in the manufacture of dyes, photographic chemicals, poison

gases for chemical warfare, pharmaceuticals, ethyl fluid for gasoline, disinfectants, and in many chemicals. It is also employed in the extraction of gold.

**Bronze.** An alloy of copper and tin, but the name is now applied to many copper alloys that have the crystalline, bronzelike structure, such as silicon bronze, aluminum bronze, and manganese bronze. In the true bronzes, tin is the predominating alloying element with the copper, but some brasses are called bronzes because of their color, or because they contain some tin. Most commercial copper-tin bronzes are now modified with zinc, lead, or other elements. Bronze is essentially a (casting metal) while brass is used mostly in wrought forms. Unlike zinc, (the tin forms a crystalline structure valued for (bearing metals)) But tin does not deoxidize copper, and the tin oxide stays in the melt. Small amounts of phosphorus are used to reduce the oxide to give stronger castings. Aluminum is sometimes used as a deoxidizer, but not more than 0.25% can be added without increasing the hardness and reducing the working properties. (Small amounts of zinc are added to give sharper castings free from blow holes.) (Small amounts of lead make the castings easier to machine, but even a small quantity of lead reduces the strength.)

A copper-tin bronze is hard in proportion to the amount of  $\text{Cu}_3\text{Sn}$  crystals it contains, which depends upon the amount of tin and the rate of solidification. The hard crystals are formed at high temperatures and by chilling; softer  $\text{Cu}_{19}\text{Sn}_{11}$  crystals are formed at low temperatures. Bronzes containing more than 90% copper are reddish; below 90% the color changes to orange-yellow which is the typical bronze color. The maximum strength is with 80% copper and 20 tin. (Ductility rapidly decreases with the increase of tin up to 20%, after which it practically disappears until 80% is reached, when it again increases. Above 20% tin the alloy rapidly becomes white in color and loses the characteristics of bronze. The high-tin alloys are also subject to what is known as tin sweat. The amount of tin used in bronzes seldom reaches 20%. The Copper-tin alloy known as Cothias metal, containing 67% copper and 33 tin, is a master alloy used for adding copper and tin to zinc-base alloys. Bronzes have a lower thermal conductivity than brasses. The average coefficient of expansion is 0.0000098. A 90-10 bronze weighs 0.317 lb per cu in.;

an 80-20 bronze weighs 0.315 lb per cu in. The 80-20 bronze melts at 1868°F, and a 95-5 bronze melts at 2480°F.

In a modified 90-10 type of bronze, the zinc is usually from 2 to 4%, and the lead up to 1%. A cast bronze of this type will have a tensile strength of about 40,000 psi, an elongation 15 to 25%, and a hardness 60 to 80 Brinell, those high in zinc being the stronger and more ductile, those high in lead being weaker. Bronzes of this type are much used for general castings and are classified as composition metal in the United States. In England they are called Engineer's bronze. An alloy designated as Hard bronze by one automotive company contains 88% copper, 7 tin, 3 zinc, and 2 lead. It makes clean, dense castings and machines well. The tensile strength is 30,000 psi, and elongation 12%. An alloy designated as special hard bronze contains 88% copper, 10 tin, and 2 zinc. It is stronger and harder, and is used for gears and heavy-duty castings, but it is difficult to machine. Merco bronze, of the Merco Nordstrom Valve Co., has 88% copper, 10 tin, and 2 lead, deoxidized with phosphorus. It machines well, and has a tensile strength of 42,000 psi, and elongation 17%. The Free-cutting bronze marketed by the Riverside Metal Co. as Mixture 44 contains 92% copper, 4 lead, and 4 tin. It machines to close tolerances at high speed.

Architectural bronze, or Art bronze, is formulated for color and is very high in copper. One foundry formula for art bronze of a dull-red color calls for 97% copper, 2 tin, and 1 zinc. For ease of casting, however, they are more likely to contain lead, and a Gold bronze for architectural castings contains 89.5% copper, 2 tin, 5.5 zinc, and 3 lead. In leaded bronze the hard copper-tin crystals aid in holding the lead in solution. These bronzes are resistant to acids and are grouped as valve bronze, or as bearing bronze because of the hard crystals in a soft matrix. Federal specifications for bronze give 10 grades in a wide variation in tin, zinc, and lead. The ASTM designates five grades of bronze casting alloys. Alloy No. 1 contains 85% copper, 10 tin, and 5 lead; Alloy No. 5 contains 70% copper, 5 tin, and 25 lead. The British Coinage copper is a bronze containing 95.5% copper, 3 tin, and 1.5 zinc.

**Bronze powder.** Pulverized or powdered bronze or brass made in flake form by stamping from sheet metal. It is used chiefly as a paint

pigment and as a dusting powder for printing. In making the powder the sheets are worked into a thin foil which becomes harder under the working and breaks into small flakes. Lubricant keeps the flakes from sticking to each other. Usually stearic acid is used, but in the dusting powder hot water or nonsticky lacquers are used. The powder is graded in standard screens, and is then polished in revolving drums with a lubricant. This gives it the property of leafing, or forming a metallic film in the paint vehicle. The leaf is also called Composition leaf, or Dutch metal leaf, when used as a substitute for gold leaf. Flitters are made by reducing thin sheets to flakes, and are not as fine as bronze powder.

The compositions of bronze powder vary, and seven alloys form the chief commercial color grades from the reddest, called pale gold, which has 95% copper and 5 zinc, to the rich gold which has 70% copper and 30 zinc. Colors are also produced by heating to give oxides of deep red, crimson, or green-blue. The powder may also be dyed in colors, using tannic acid as a mordant, or treated with acetic acid or copper acetate to produce antique finish. The color or tone of bronze powders may also be adjusted in paints by adding a proportion of mica powder. A white bronze powder is made from aluminum bronze, or the silvery colors are obtained with aluminum powder. The bronze powder of 400 mesh used for inks is designated as extra fine. The fine grade, for stencil work, is 325 mesh. Medium fine, for coated paper, has 85% of the particles passing through a 325-mesh screen and 15% retained on the screen. Near mesh, for paint pigment, has 30% passing through a 325-mesh screen. A 400-mesh powder has 500 million particles per gram. The old name for bronze powder is Gilding powder. It is also called Gold powder when used in cheap gold-colored paints, but bronze powders cannot replace gold for use in atmospheres containing sulphur, or for printing on leather where tannic acid would corrode the metal.

**Broomcorn.** A plant of the sorghum family, *Holcus sorghum*, grown in the Southwest, in Illinois and Kansas, and in Argentina and Hungary. It is used for making brushes and brooms, and for the stems of artificial flowers. The jointed stems of the dwarf variety grown in the semiarid regions are 12 to 24 in. long, but the standard brush corn is up to 30 in. long. The fibers are yellow in color and,



when dry, are coarse and hard. They are easily cleaned and readily dyed. As a brush material they have the objection that they break easily, and are therefore unsuited for mechanical brushes for hard service. Broom root, or Rice root, is similar to broomcorn, and is suitable for mixing with it or for coarse brushes. It is from a type of grass, *Epicampes macroura*, of Mexico and Guatemala. The fiber is obtained from the shredded roots.

**Brush fibers.** Industrial brushes are made from a wide variety of fibers, varying from the fine and soft camel's hair to the hard, coarse, and brittle broomcorn. Bristles from the hog form one of the most common, but tampico and piassava fibers are important for polishing brushes. The Vegetable fibers used for brushes are tough and stiff as compared with the finer flexible and cohesive fibers used for twine and for fabrics. They may, however, come from the same plant, or even from the same leaf, as the textile fibers, but be graded out for stiffness. Palmetto fiber is from the cabbage palm tree, *Sabal palmetto*, of Florida. Whiskbrooms and brushes are made from the young leaf-stalks, and stiff floor sweeps from the leaves.

A fiber finer than palmetto is obtained from the twisted roots of the Scrub palmetto, *S. megacarpa*. Arenga fiber is a stiff, strong fiber from the stems of the palm tree, *Arenga saccharifera*, of the East Indies. The finest grades resemble horsehair. Kittool is a similar strong, elastic fiber from the large leaves of the palm tree, *Caryota urens*, of India and Ceylon. It is very resistant, and is valued for machine brushes. Gomuti fiber and Chinese coir are fibers from other species of this palm. Bass, or Raphia, is a coarse fiber used for hard brushes and brooms. The heavier piassava fibers are also known as bass, but bass is from the leaves of the palm tree, *Raphia vinifera*, of West Africa. Darwin fiber, used for brooms and scrubbing brushes in Australia, is from the *Gabnia trifida*. Crin is from the leaves of a palm tree of Algeria, although the word crin originally referred to horsehair. Crin vegetal, or Vegetable crin, is fiber from the leaf of the Yatay palm, *Diplothemium littorale*, of Corrientes Province, Argentina. Horsehair, from the manes and tails of horses, is used for brushes.

Vegetable and animal fibers are not resistant to alkalies or acids and cannot be wetted with them. The artificial fibers of plastics such

as nylon are resistant to many chemicals. For hard-service mechanical brushes, and for resistance to strong chemicals, brush fibers are of steel, brass, or aluminum wire. Brush wire for rotary-power brushes for metal brushing is soft to hard-drawn steel wire usually 0.005 in. in diameter, but finer wire is used to give a soft brush. Brush wire used by the Osborn Mfg. Co. for soft rotary brushes is a soft steel wire 0.0025 in. in diameter with 242,144 wires in a 1½ in. diameter brush 2 in. long.

**Buckram.** A coarse, plain-woven open fabric similar to cheese-cloth, but heavily sized with gums or water-resistant resins. It is usually of cotton, but may be of linen. It may be white or in plain colors, and is employed as a stiffening material, for bookbindings, shoe inner soles, and interlinings for leather goods.

**Buffing compositions.** Materials used for buffing or polishing metals, consisting usually of dolomitic lime with from 18 to 25% saponifiable grease as a bond. The lime acts as the abrasive, and in some compositions is partly replaced by other abrasives such as emery flour, tripoli, pumice, silica, or rouge. Harsher abrasives are used in the compositions employed for the cutting-down or buffing operations. Abrasive grains are selected for combinations of hardness, toughness, and sharpness, from the soft iron oxide to the hard and sharp aluminum oxide. Buffing compositions are usually sold under trade names for definite uses rather than by composition. Metal polishes for hand use are now usually liquids. The pastes, formerly known as Putz cream and Brass polish, contained tripoli or pumice with oxalic acid and paraffin. The liquid polishes now generally contain finer abrasives such as pumicite or diatomite, in a soap detergent, together with a solvent such as naphtha, and sometimes pine oil or an alkali.

**Building sand.** Selected sand used for concrete, for mortar for laying bricks, and for plastering. Early specifications called for sand grains to be sharp, but rounded grains are now preferred because of fewer voids in the mixture. Building sand is normally taken from deposits within a reasonable haul of the site of building, and is not usually specified by analysis, but should be a hard silica sand that will not dissolve. Pure white sand for finish plaster is made by grinding

limestone. Building sand is required to be clean, with not more than 3% clay, loam, or organic matter. ASTM requirements are that all grains must pass through a  $\frac{3}{8}$ -in. sieve, 85% through a No. 4 sieve, and not more than 30% through a No. 50 sieve. For brick mortar all of the sand should pass through a  $\frac{1}{4}$ -in. sieve. For plaster, not more than 6% should pass through a No. 8 sieve. Flooring sand for mastic flooring is a clean sand passing through a No. 3 sieve, with 7% passing through a No. 100 sieve. Roofing sand is a fine white silica sand. Paving sand is divided into three general classes: that for concrete pavements, that for asphaltic pavements, and that for grouting.

The U.S. Bureau of Public Roads requires that sand for concrete pavements should all pass through a  $\frac{1}{4}$ -in. sieve, 5 to 25% should be retained on a No. 10 sieve, from 50 to 90% on a No. 50 sieve, and not more than 10% should pass through a No. 100 sieve. Not more than 3% of the weight should be matter removable by elutriation. For asphaltic pavements small amounts of organic matter are not objectionable in the sand. All should pass through a  $\frac{1}{4}$ -in. sieve, 95 to 100% through a No. 10 sieve, and not more than 5% through a No. 200 sieve. Grouting sand should all pass through a No. 20 sieve, and not more than 5% through a No. 200 sieve. Chat sand, used for concrete pavements, is a by-product of zinc and lead mines. It is screened through a  $\frac{3}{8}$ -in. sieve.

**Building stone.** Any stone used for building construction may be classed as building stone, but the stones, in order of importance, used in the United States for building are limestone, granite, sandstone, basalt, and marble. Granite and limestone are among the most ancient of building materials and are extremely durable. Two million limestone and granite blocks, totaling nearly 8 million long tons, were used in the pyramid of Ghizeh built about 2980 B.C., the granite being used for casing. Availability, or a near supply, may determine the stone used in ordinary building, but for public buildings stone is transported long distances. Some sandstones, such as the red sandstone of the Connecticut Valley, weather badly, and are likely to scale off with penetration of moisture and frost. Granite will take heavy pressures and is used for foundation tiers and columns. Limestones and well-cemented sandstones are employed extensively above the foundations. Nearly half of all the limestone used in the United

States in block form is Indiana limestone. Marble has a low crushing strength and is usually an architectural or facing stone.

Crushed stone is used for making concrete, for railway ballast, and for road making. The commercial stone is quarried, crushed, and graded. Much of the crushed stone used is granite, limestone, and Trap rock. The latter is a term used to designate basalt, gabbro, diorite, and other dark-colored fine-grained igneous rocks. Graded crushed stone usually consists of only one kind of rock and is broken with sharp edges. The sizes are from  $\frac{1}{4}$  to  $2\frac{1}{2}$  in., although larger sizes may be used for massive concrete aggregate. Screenings below  $\frac{1}{4}$  in. are employed largely for paving. Granite granules for making hard terrazzo floors are marketed in several sizes, and in pink, green, and other selected colors. Roofing granules are graded particles of crushed rock, slate, slag, porcelain, or tile, used as surfacing on asphalt roofing and shingles. Granules have practically superseded gravel for this purpose. Black Amphibole ryolite may be used, or gray basalt may be colored artificially for granule use. The Suzorite rock of Quebec contains feldspar, pyroxenite, apatite, and mica, and is treated to remove the mica. Ceramic granules are produced from clay or shale fired and glazed with metallic salts. They are preferred because the color is uniform. Slate granules are used for surfacing prepared roofing.

**Bunting.** A lightweight worsted fabric, plain-woven, and dyed in solid colors. It is employed mostly for making flags, for box lining, and other industrial uses. It wears well, and does not fade easily. Cotton bunting is a thin, soft, flimsy fabric of closer weave than cheesecloth. It is dyed in solid colors, or printed, and usually fades easily. It is used for cheap flags, decorations, and industrial linings and coverings.

**Burlap.** A coarse, heavy cloth made of plain-woven jute, or jute-like fibers, and used for wrapping and bagging bulky articles, for upholstery linings, and as a backing fabric for linoleum. Finer grades are also used for wall coverings. The standard burlap from India is largely from jute fibers, but some hibiscus fibers are used. For bags and wrappings, the weave is coarse and irregular, and the color is the natural tan. The coarse grades such as those used for wrapping cotton bales are sometimes called gunny in the United

States, but Gunny is a general name for all burlap in Great Britain. Dundee, Scotland, is the important center of burlap manufacture outside of India, but considerable quantities are made from native fibers in Brazil and other countries. Burlap is woven in widths up to 144 in., but 36, 40, and 50 in. are the usual widths. Hessian is the name of a 9½-oz plain-woven finer burlap made to replace an older fabric of the same name woven from coarse and heavy flax fibers. When dyed in colors, it is used for linings, wall coverings, and upholstery. Bithess was a name for Hessian fabric coated with bitumin used in India to spread over soft earth areas as a seal for a top coating to form airplane runways. Brattice cloth is a very coarse, heavy, and tightly woven jute cloth, usually 20 oz per sq yd used for gas breaks in coal mines, but a heavy cotton duck substituted for the same purpose is called by the same name. Most burlap for commercial bags is 8, 9, 10, and 12 oz, feed bags being 8 oz and grain bags 10 oz.

**Butadiene.** Also called BivinyI and Erythrene. A colorless gas of the composition  $\text{CH}_2\text{:CH}\cdot\text{CH}\text{:CH}_2$  used in the production of synthetic rubber. It unites easily with many reagents and is used for the production of many other compounds. In contact with air or oxygen it forms peroxides that are explosive, and must be safeguarded with inhibitors when shipped. Butadiene has a boiling point of  $-3^\circ\text{C}$ , and a specific gravity of 0.6272. Commercial butadiene is at least 98% pure, with normal butane and butenes as the impurities. It contains 0.01% of phenyl beta naphthylamine or other oxidation inhibitor. It is easily produced by the dehydrogenation of butane from natural gas or petroleum.

**Butter.** An edible fat made from cow's milk by curdling with bacterial cultures and churning. The production of butter is one of the large industries of the western nations, with an annual production exceeding 10 billion pounds, 30% of which is made in the United States. Other important producers are Germany, Holland, the Scandinavian countries, Australia, New Zealand, Canada, Ireland, and Argentina. More than 80% of the butter produced in the United States is made in factories as Creamery butter subject to Federal inspection, as distinct from Farm butter not subject to the regulations of interstate trade. Creamery butter is an important raw material in the bakery and confectionery industries. Federal regulations require

that creamery butter shall be made exclusively from milk or cream, with or without salt and coloring matter, and shall contain not less than 80% by weight of milk fat, not over 15% moisture, and not over 2.5% salt. Butter varies greatly in color and flavor from the feed of the animal, the processing, and the storage. The natural color is whitish in winter and yellow in summer when the animal feeds on green pasturage. Commercial butter is usually brought to a uniform yellow by coloring with annatto. Musty, garlicky, and fishy flavors may be caused by noxious weeds eaten by the animal; cheesy or yeasty flavors may be from stale cream; metallic, greasy, scorched, or alkaline flavors may be from improper processing. Almost all American butter is salted. Argentine butter is usually unsalted.

United States grades for creamery butter range from 93 score for the best butter of fine flavor and body down to 85 score for the lowest grade having pronounced obnoxious weed flavor and defects in body, color, or salt. The grading, or scoring, of butter is done by experts. The flavor is determined by the senses of taste and smell. The flavor, body, color, and salt are rated independently, and points, or scores, are subtracted for defects. The body and texture of the butter are determined by the character of the granules and their closeness. The most common body defects are gumminess, sponginess, crumbliness, and stickiness. The most common defect in color is lack of uniformity with waves or mottles. Defects in salting are excessive salt and undissolved salt grains. Butter held in storage at improper temperatures is likely to develop rancid or unpleasant flavors and acidity due to chemical changes, or it may absorb flavors from surrounding products. High-grade butter can be held in well-regulated cold storage for long periods without appreciable deterioration.

An important substitute for butter is Margarine, sometimes called by the name of an older greasy product, Oleomargarine, now no longer manufactured though the name is retained in old laws. Margarine is made from a mixture of about 80% vegetable oils and 20 milk in the same manner as butter. It has a slightly lower melting point than butter, 22 to 27°C, but the melting point can be regulated by hydrogenation of the oils. The margarine of lower melting points is used in the bakery industry, and the grades with higher melting points are for table use. From 2.5 to 4% salt is used, together with vitamins A and D, lecithin, annatto coloring, and sometimes phos-

phatides to prevent spattering when used for frying. Biacetyl,  $C_4H_8O_2$ , a colorless, pungent sweet liquid which gives the characteristic flavor to butter is also added. The food value is in general higher than that of butter, but because of the competition with butter various Federal and state regulations and taxes restrict its use. Soya butter is made from emulsified soybean and, when fortified with butyric acid, the characteristic acid of butter, is practically indistinguishable from butter. It is, however, subject to restrictive regulations and taxes. Butter flavors are used in confectionery and bakery products. Butta-Van, of the Whitehall Food Mfg. Co., is a butter flavor with vanilla. It contains butyric acid, ethyl butyrate, coumarin, vanillin, and glycerin in water solution. Ghee butter, used in India, is made from buffalo milk, sometimes mixed with cow's milk. It is clarified by melting the butter over a slow fire and separating off the opaque white portion. The Synthetic butter used by the German army was made by esterifying with glycerin straight-chain aliphatic synthetic acids of  $C_{11}$  and  $C_{12}$ , and purifying the resulting esters. Cheese is an important solid food product made from butterfat by the action of cultures of *Lactobacillus*. It contains all the food value of milk, including the proteins of the casein. The biotics used in the manufacture produce n-butyric acid, with also caproic, caprylic, and capric acids in varying amounts which produce the flavor of the various types of cheese.

**Butyl alcohol.** A colorless liquid used as a solvent for paints and varnishes, and in the manufacture of dyes, plastics, and many chemicals. There are four forms of this alcohol, but the normal or primary butyl alcohol is the most important. Normal butyl alcohol,  $CH_3-(CH_2)_2CH_2\cdot OH$ , has a specific gravity of 0.814, and boiling point of  $117^\circ C$ . This form, known as Butanol, has strong solvent power and is valued where a low evaporation rate is desired. It is also used for organic synthesis.

**Cadmium.** A silvery-white crystalline metal, symbol Cd. It has a specific gravity of 8.6, is very ductile, and can be rolled or beaten into thin sheets. It resembles tin and gives the same characteristic cry when bent, but is harder than tin. A small addition of zinc makes it very brittle. It melts at  $608^\circ F$ , and boils at  $1580^\circ F$ . Cadmium is

employed as an alloying element in soft solders and in fusible alloys, for hardening copper, as a white corrosion-resistant plating metal, and in its compounds for pigments and chemicals. The metal is marketed in small round sticks 12 in. long, and in variously shaped anodes for electroplating. Electrolytic cadmium is 99.95% pure. It is obtained chiefly as a by-product of the zinc industry by treating the flue dust and fumes from the roasting of the ores. Flue dust imported from Mexico averages 0.66 ton of cadmium per ton of dust. About half the world production is in the United States. Other important producers are Germany, Belgium, Canada, and Poland. The only commercial ore of the metal is Greenockite,  $\text{CdS}$ , which contains theoretically 77.7% cadmium. This mineral occurs in yellow powdery form in the zinc ores of Missouri. Cadmium occurs in nearly all sphalerite to the extent of 0.1 to 1%.

More than 85% of the consumption of cadmium is for electroplating. For a corrosion-resistant coating for iron or steel a cadmium plate of 0.0003 in. is equal in effect to a zinc coat of 0.001 in. The plated metal has a silvery-white color with a bluish tinge, is denser than zinc and harder than tin. Cadmium plating is not normally used on copper or brass since copper is electronegative to it, but when these metals are employed next to cadmium-plated steel a plate of cadmium may be used on the copper to lessen deterioration. Cadalyte is a trade name of E. I. du Pont de Nemours & Co., Inc., for a cadmium salt and process for cadmium plating, and Udylyte is the name of a salt and process of the Udylyte Corp.

Small amounts of cadmium added to copper give the copper higher strength, hardness, and wear resistance, but decrease the electrical conductivity. Copper containing 0.5 to 1.2% cadmium is called Cadmium copper or Cadmium bronze. Hitenso is a cadmium bronze of the American Brass Co. used for overhead trolley wires. It has 35% greater strength than hard-drawn copper, and 85% the conductivity of copper. The cadmium bronze known in England as Conductivity bronze, used for electric wires, contains 0.8% cadmium and 0.6 tin. The tensile strength, hard-drawn, is 85,000 psi, and the electrical conductivity is 50% that of copper. Cadmium nitrate,  $\text{Cd}(\text{NO}_3)_2$ , is a white powder used for making cadmium yellow and fluorescent pigments, and as a catalyst.



**Caffeine.** An alkaloid which is a white powder when it has the composition  $C_8H_{10}N_4O_2$ , and occurs in crystalline flakes when it has one molecule of water of crystallization. The melting point is  $235^{\circ}C$ . It is soluble in water and in alcohol. Caffeine increases muscular contraction and stimulates to lessen fatigue, but in large amounts is highly toxic. Its prime use is in medicine, but most of the production is used in soft drinks. It is obtained from coffee, tea waste, kola nuts, or guarana by solvent extraction, or as a by-product in the manufacture of such noncaffeine coffees as Sanka, or in the processing of coffee for the production of oil and cellulose. Less than 1% caffeine is obtained from coffee, about 2 from Tea waste, and 1.5 from kola nuts. Cocoa waste contains Theobromine, from which 0.2 to 0.5% caffeine is derived. Theobromine is a more powerful stimulant than caffeine. Guarana contains the highest percentage of caffeine of all the beverage plants, about 3%. It comes from the seeds of the woody climbing plant *Paullinia cupana*, of the Amazon Valley. It is used by the Indians by grinding the seeds with water and mandioca flour and drying the molded paste with smoke. For use it is grated into hot water. The Kola nuts are the seeds of the fruit of the large spreading tree *Kola acuminata* native to West Africa and cultivated also in tropical America, and the *K. nitida* of West Africa. The nuts of the latter tree contain the higher percentages of theobromine and caffeine. The white nuts are preferred to the pink or red varieties. Citrated caffeine, used in pharmaceuticals, is a white powder produced by the action of citric acid on caffeine, and contains about equal quantities by weight of anhydrous caffeine and citric acid. It is very soluble in water. Synthetic caffeine is made from urea and sodium cyanoacetate, and is equal chemically to natural caffeine.

**Cajeput oil.** A greenish essential oil distilled from the leaves of the tree *Melaleuca leucadendron* growing chiefly in the East Indies. It contains the cineole of eucalyptus oil and also the Terpinol which is characteristic of the lilac. It has a camphorlike odor. It is used in medicine as an antiseptic and counterirritant, and in perfumes. Naouli oil is a similar oil from the leaves of the tree *M. viridi* of New Caledonia. Cajeput bark, from the same tree, is used as an insulating material in place of cork. The bark is up to 2 in. in thickness, is soft, light, resistant, and a good insulator.

**Calcite.** One of the most common and widely diffused minerals, occurring in the form of limestones, marbles, chalks, calcareous marls, and calcareous sandstones. It is a calcium carbonate,  $\text{CaCO}_3$ , and the natural color is white or colorless, but it may be tinted to almost any shade with impurities. The specific gravity is about 2.72 and hardness 3. Iceland spar, or Calc spar, is the name for the perfectly crystallized, water-clear, flawless calcite crystals of optical grade used for the manufacture of Nicol prisms for polarizing microscopes, photometers, calorimeters, and polariscopes. It comes from Iceland, Spain, South Africa, and New Mexico, and some crystals have been found as large as 17 lb.

**Calcium.** A metallic element, symbol Ca, belonging to the group of alkaline earths. It is one of the most abundant materials, occurring in combination in limestones and calcareous clays. The metal is obtained 98.6% pure by electrolysis of the fused anhydrous chloride. By further subliming it is obtained 99.5% pure. Calcium metal is yellowish white in color. It oxidizes easily, and when heated in the air burns with a brilliant white light. The specific gravity is 1.55, melting point  $810^\circ\text{C}$ , and boiling point  $1440^\circ\text{C}$ . Its strong affinity for oxygen and sulphur is utilized as a cleanser for nonferrous alloys. As a deoxidizer and desulphurizer it is employed in the form of lumps or sticks of calcium metal or in ferroalloys and calcium-copper. Natural calcium compounds, such as dolomite, are used directly as a flux in melting iron. Calcium is also used to harden lead, and calcium silicide is used in making some special steels to inhibit carbide formation.

Many compounds of calcium are employed industrially, in fertilizers, foodstuffs, and medicine. It is an essential element in the formation of bones, teeth, shells, and plants. Oyster shells form an important commercial source of calcium for animal feeds. The shells are dredged in the Gulf of Mexico where vast quantities of oysters are killed by tidal shifts of fresh water. They are crushed, and the fine flour is marketed for stock feeds and the coarse for poultry feeds. The shell is calcium carbonate. Edible calcium, for adding calcium to food products, is Calcium lactate, a white powder of the composition  $\text{Ca}(\text{C}_3\text{H}_5\text{O}_3)_2 \cdot 5\text{H}_2\text{O}$ , derived from milk. Calcium phosphate, used in the foodstuffs industry and in medicine, is marketed in

several forms. Calcium diphosphate, known as Phosphate of lime, is  $\text{CaHPO}_4 \cdot 2\text{H}_2\text{O}$ , or in anhydrous form. It is soluble in dilute citric acid solutions, and is used to add calcium and phosphorus to foods, and as a polishing agent in tooth pastes. Calcium monophosphate is a stable, white, water-soluble powder,  $\text{CaH}_4\text{P}_2\text{O}_8 \cdot \text{H}_2\text{O}$ , used in baking as a leavening agent. Calcium triphosphate,  $\text{Ca}_3(\text{PO}_4)_2$ , is a white water-insoluble powder used to supply calcium and phosphorus to foods, as a polishing agent in dentifrices, and as an antacid. Calcium sulphite,  $\text{CaSO}_3 \cdot 2\text{H}_2\text{O}$ , is a white powder used in bleaching paper pulp and textiles, and as a disinfectant. It is only slightly soluble in water, but it loses its water of crystallization and melts at  $100^\circ\text{C}$ . Calcium silicate,  $\text{CaO} \cdot \text{SiO}_2$ , is a white powder used as a reinforcing agent in rubber. Silene EF, of the Columbia Chemical Div., is a precipitated calcium silicate for rubber. Calcium acetate,  $\text{Ca}(\text{C}_2\text{H}_3\text{O}_2)_2 \cdot \text{H}_2\text{O}$ , is a white powder used in liming rosin and for making metallic soaps and synthetic resins.

**Calcium carbide.** A hard, crystalline substance of grayish-black color, used chiefly for the production of acetylene gas for welding torches and for lighting. It was discovered in 1892 and was widely employed for theater stage lighting and for early automobile headlights. It is made by reducing lime with coke in the electric furnace. It can also be made by heating crushed limestone to a temperature of about  $1000^\circ\text{C}$ , flowing a high-methane natural gas through it, and then heating to  $1700^\circ\text{C}$ . The composition is  $\text{CaC}_2$ , and specific gravity 2.26. It contains theoretically 37.5% carbon. When water is added to calcium carbide, acetylene gas is formed, leaving a residue of slaked lime. Pure carbide will yield 5.83 cu ft of acetylene per pound of carbide, but the commercial product is usually only 85% pure. Federal specifications require not less than 4.5 cu ft of gas per pound. Calcium carbide is marketed in four size grades from the lump, which is  $3\frac{1}{2}$  to 2 in., to the quarter, which is of a fineness below  $\frac{1}{4}$  in.

**Calcium chloride.** A white, crystalline, lumpy or flaky material of the composition  $\text{CaCl}_2$ . The specific gravity is 2.512, melting point  $722^\circ\text{C}$ , and it is highly hygroscopic and deliquescent with rapid solubility in water. The commercial product contains 75 to 80%  $\text{CaCl}_2$ , with the balance chiefly water of crystallization. Some is marketed in anhydrous form for dehydrating gases. It is also sold in

water solution containing 40% calcium chloride. An important use for calcium chloride is for spreading on gravel or macadam roads to aid in surfacing and absorb dust, and to prevent cracking from freezing. It is also used for accelerating the setting of concrete and to prevent concrete mixtures from freezing in cold weather. More than 4% in concrete decreases the strength of the concrete. It is also employed as an antifreeze in fire tanks. Other uses are as a food preservative and in textile and paper sizes as a gelling agent. Calcium chloride is obtained from natural salt brines, or as a by-product in the Solvay process. Temperite, of the Truscon Laboratories, is calcium chloride for concrete.

**Calcium molybdate.** A salt of molybdenum,  $\text{CaMoO}_4$ , used in place of ferromolybdenum for adding molybdenum to steel. It is made by roasting molybdenite and adding lime. It contains about 60.7%  $\text{MoO}_3$ , with the balance lime. The specific gravity is 4.35. The calcium molybdate and flux mixture marketed by the Molybdenum Corp. under the name of Molyte is heavier and sinks in the molten steel.

**Calcium-silicon.** An alloy of calcium and silicon used as a deoxidizing agent, and for the elimination of sulphur in the production of steels and cast irons. It is marketed as low-iron, containing 22 to 28% calcium, 65 to 70 silicon, and 5 max iron, and as high-iron, containing 18 to 22% calcium, 58 to 60 silicon, and 15 to 20 iron. It comes in crushed form and is added to the molten steel. At the temperature of molten steel all of the calcium passes off and leaves no calcium residue in the steel. Calcium-manganese-silicon is another master alloy containing 17 to 19% calcium, 8 to 10 manganese, 55 to 60 silicon, and 10 iron.

**Cambric.** Originally, a fine, thin, hard-woven linen, but now usually a plain-woven strong cotton fabric of fine weave and hard-twist yarn. It is the standard material for making Varnished cambric and Varnished cloth for electrical insulation and cable winding. The coatings may be of insulating varnish or of synthetic resins. It comes in 36-in. widths in rolls or as tape, usually black or yellow. The thickness, including the varnish, ranges from 0.005 to 0.015 in., and the dielectric strength usually exceeds 1,000 volts per mil when a

synthetic resin varnish is used. The tensile strength also exceeds that of the older Varnished silk which has become obsolete. For still higher strengths, nylon or rayon may be employed. The Varnished rayon of the Irvington Varnish & Insulator Co. is made from high-tenacity rayon, and the finished fabrics are 0.003 to 0.008 in. in thickness, with dielectric strength of 1,000 volts per mil.

**Camel's hair.** The fine, tough, soft hair from the mane and back of the camel, *Camelus bactrianus*, used for artists' brushes and for industrial striping brushes. Most of the hair is produced in central Asia and Persia, and the grades preferred for brushes are from the crossbred Boghdi camel. The hair from the dromedary, also called djemel, or camel, is of poor quality. Much of the camel hair is not cut, but is shed and is picked up along the camel routes. The plucked beard hair and the coarse outerguard hair obtained in combing are the brush fibers. They are tough, silky, and resilient. The length is 5 to 8 in. The fine body hair, or Camel wool, which constitutes about 90% of the total fiber, is 1.5 to 2 in. long, has a fine radiance, a pale tan color, and a downy feel. It is the textile fiber. The beard hair from the Cashmere goat is very similar to camel hair and is used for brushes. Various other hairs are used for making camel's hair brushes, including Ox ear hair and Squirrel tail hair. Control of the camel routes is now in the hands of the Russians, and little is known of the amount of true camel hair.

**Camphor.** The white resin of the *Cinnamomum camphora*, an evergreen tree with laurellike leaves, and reaching a height of 100 ft. The tree occurs naturally in China and southern Japan, and is also grown in Florida. Formosa is the center of the industry. Camphor,  $C_{10}H_{16}O$ , has a specific gravity of 0.986 to 0.996, and melts at 175°C. It is soluble in water and in alcohol. Much of the camphor is used for hardening nitrocellulose plastics, but it is also used in pharmaceuticals, in disinfectants, and in explosives and chemicals. It is contained in all parts of the tree, but is obtained almost entirely from the trunks, roots, and large branches by steam distillation. From 20 to 40 lb of chips produce 1 lb of camphor. The crude camphor is pressed to obtain the Flowers of camphor and Camphor oil. The crude red camphor oil is fractionated into white and brown oils, the first of

which is used in soaps, polishes, varnishes, cleaners, and pharmaceuticals. The brown oil is used in perfumery. The white camphor oil is a colorless liquid with a camphor odor, a specific gravity of 0.870 to 1.040, and soluble in ether or chloroform. Camphor oil may also be distilled from the twigs. Camphor sassafrassy oil is a camphor oil fraction having a specific gravity of 0.97. It has a sassafras tone, and is used for scenting soaps and sprays.

Borneo camphor, or Borneol, is a white, crystalline solid obtained from the tree *Dryobalanops camphora* of Borneo and Sumatra. It is used as a substitute for camphor in cellulose plastics. It has the composition  $C_{10}H_{17}OH$ , a specific gravity of 1.01, is soluble in alcohol, and sublimes at  $212^{\circ}C$ . The wood of this tree, known as Borneo camphorwood, or Kapur, is used for cabinetwork. It weighs 50 lb per cu ft, has an interlocking grain, and a scent of camphor.

Artificial camphor is Bornyl chloride,  $C_{10}H_{17}Cl$ , a derivative of the pinene turpentine. It has a camphor odor, has the same industrial uses as camphor, but is optically inactive and is not used in pharmaceuticals. Synthetic camphor, made from turpentine, in refined form is equal to the natural product for medicinal use, and the technical grade is used in plastics. The camphor substitute Lindol, of the Celanese Corp., is Tricresyl phosphate, or Tolyol phosphate,  $(CH_3-C_6H_4)_3PO_4$ , a colorless, odorless, viscous liquid which solidifies at  $-20^{\circ}C$ , or a solid that melts at  $77^{\circ}C$ . Like camphor, it hardens cellulose nitrate and makes it noninflammable. Dehydranone, of the Carbide & Carbon Chemicals Corp., is Dehydracetic acid,  $C_8H_8O_4$ , a white, odorless solid with some of the properties of camphor, used in nitrocellulose and vinyl resins. Cyclohexyl levulinate,  $CH_3CO-(CH_2)_2COOC_6H_{11}$ , is also used as a substitute for camphor in nitrocellulose, and also in vinyl resins and in chlorinated rubber. It is a liquid of specific gravity 1.025, boiling point  $265^{\circ}C$ , and freezing point  $-70^{\circ}C$ . Adamantine has the odor of camphor and turpentine. It is obtained from the crude petroleum of Moravia as a stable, crystalline solid melting at  $268^{\circ}C$ . It has the empirical formula  $C_{10}H_{16}$ , and the molecule has four trans-cyclohexane rings. Camphorene,  $C_{20}H_{32}$ , is made from turpentine by polymerizing two myrcene molecules. It is a raw material for producing geraniol and linalool.

**Camwood.** The wood of the tree *Baphia nitida*, native to West Africa, used for tool handles and for machine bearings. It will withstand heavy bearing pressures. The wood is exceedingly hard, has a coarse, dense grain, and weighs 65 lb per cu ft. It contains a red coloring matter known as Santalin, and was once valued as a dyewood for textiles. Barwood, from the tree *Pterocarpus santalinus*, of West Africa, is a similar reddish hardwood containing the same dye and used for the same purposes.

**Canada balsam.** Also called Canada turpentine. A yellowish, viscous oleoresin liquid of pleasant odor and bitter taste, obtained from the buds of the balsam fir *Abies balsamea* of the Northeastern states and Canada. The specific gravity is 0.983 to 0.997. It is a class of turpentine, and is used as a solvent in paints and polishes, in leather dressings, adhesives, and perfumes. It is also referred to as Balm of Gilead for medicinal and perfumery use, but the original balm of Gilead, marketed as buds, was from the small evergreen tree *Balsamodendron gileadense* of the Near East.

**Canaigre.** A tanning material extracted from the roots of the low-growing plant *Rumex hymenosepalus* of northern Mexico and the arid Southwest of the United States. The plant is known locally as Sour dock, and the roots contain up to 50% tannin. Canaigre extract contains 30% tannin. It produces a firm, orange-colored leather. Canaigre was the tanning agent of the Aztec Indians.

**Canary seed.** The seeds of the Canary grass, *Phalaris canariensis*, native to the Canary Islands, but now grown on a large scale in Argentina for export, and in Turkey and Morocco for human food and for export. In international trade it is known by the Spanish name Alpiste. It is valued as a bird food because it contains phosphates, iron, and other minerals, and is rich in carbohydrates. It is, however, low in proteins and fats, and is usually employed in mixtures. Birdseed is an extensive item of commerce, but the birdseed that reaches the market in the United States is usually a blend of canary seed and millet, with other seeds to give a balanced food. Canary seed is small, pale-yellow in color, and convex on both sides. The term Spanish canary seed is applied to the choice seed regardless of origin. Niger seed, also valued as a birdseed, is from the plant

*Guizotia abyssinica*, of the thistle, or *Compositae* family, grown in India, Africa, Argentina, and Europe. It is also known as Inga seed, Rantil, Kala til seed, and Black sesame. It is also called Gingelli in India, although this name and Til are more properly applied to sesame. The seed is high in proteins and fats.

**Candelilla wax.** A yellowish amorphous wax obtained by hot water or solvent extraction from the stems of the shrubs *Pedilanthus pavonis* and *Euphorbia antispybilitica* growing in the semiarid regions of Texas and Mexico. The plants grow to a height of 3 to 5 ft and consist of a bundle of stalks without leaves. The stems yield 3.5 to 5% wax that consists of long-chain hydrocarbons with small amounts of esters. The wax has a specific gravity of 0.983, melting point 67 to 70°C, iodine value 37, and saponification value 45 to 65. The refined grade is purified by remelting, and contains not more than about 1% water. It is soluble in turpentine, and is used for varnishes, polishes, leather finishes, as a substitute for carnauba wax, or to blend with carnauba or beeswax. About half the production goes into furniture and shoe polishes.

**Cannel coal.** A variety of coal having some of the characteristics of petroleum, valued chiefly for its quick-firing qualities. It consists of coaly matter intimately mixed with clay and shale, often containing fossil fishes, and probably derived from vegetable matter in lakes. It is close and compact in texture, dull black in color, and breaks along joints, often appearing like black shale. It burns with a long, luminous, smoky flame, from which characteristic it derives its old English name, meaning candle. On distillation, cannel coal yields a high proportion of illuminating gas, up to 16,000 cu ft per ton, leaving a residue consisting mostly of ash. At low temperatures it yields a high percentage of tar oils. The proportion of volatile matter may be as high as 70%. It is found in Great Britain, and in the United States in Kentucky, Ohio, and Indiana. Cannel coal from Scotland was originally called Parrot coal. Boghead coal is a variety of streaky cannel coal of Scotland.

**Carbohydrates.** A group of materials, chiefly of vegetable origin, which are distinguished by the fact that they contain the elements carbon, hydrogen, and oxygen, and no others. Many chemical com-



pounds, such as alcohols and aldehydes, also have these elements only, but the term carbohydrate refers only to the starches, sugars, and cellulose, which are more properly called Saccharides. They are best known for their use as foodstuffs, as carbohydrates compose more than 50% of all American food, but they are also used in many industrial processes. The digestible carbohydrates are the sugars and the starches. The indigestible carbohydrates are cellulose and hemicellulose, which form the chief constituents of wood, stalks, and leaves of plants, the outer covering of seeds, and the walls of plant cells enclosing the water, starches, and other substances of the plants. Much cellulose is eaten as food, especially in the leaves of vegetables and in bran, but it serves as bulk rather than as food, and is beneficial if not consumed in quantity. The digestible carbohydrates are classified as Single sugars, Double sugars, and Complex sugars, chemically known as Monosaccharides, Disaccharides, and Polysaccharides. The single sugars, glucose, fructose, and galactose, require no digestion and are readily absorbed into the blood stream. The double sugars, sucrose, maltose, and lactose, require to be broken down by enzymes in the human intestine. Lactose is only slowly digested. It is produced from cow's milk, and is only one quarter as sweet as sucrose from cane sugar. Galactose is derived from lactose by hydrolysis.

The complex sugars are the starches, dextrines, and glycogen. These require digestion to the single stage before they can be absorbed in the system. The common starches are in corn, wheat, potatoes, rice, tapioca, and sago. Glycogen is animal starch stored in the liver and muscles of animals. The hemicelluloses are agar-agar, algin, and pectin. They differ chemically from cellulose and expand greatly on absorbing water. The hemicelluloses of wood, called Hexosan, consist of the Wood sugars, or Hexose, with six carbon atoms,  $(C_6H_{10}O_5)_n$ . They were used in Germany during the war to produce alcohol, glycerin, and other chemicals. The water-soluble hemicellulose of the Masonite Corp., known as Masonex in water solution and Masonoid as a powder, is a by-product of the steam-exploded wood process. It is used to replace starch as a binder for foundry cores and for briquetting coal, and for emulsions. It contains 70% wood sugars, 20 resins, and 10 lignin. Lichenin, or Moss starch, is a hemicellulose from moss and some seeds.

The Pentosans are gums or resins occurring in nutshells, straw,

and in the cell membranes of plants. They may be classed as hemicellulose and on hydrolysis yield Pentose, or Pentagucose, a sugar containing 5 carbon atoms. Pectin is a yellowish, odorless powder soluble in water and decomposed by alkalis. It is produced by acid extraction from the inner part of the rind of citrous fruits and from apple pomace. In East Africa it is obtained from sisal waste. Sugar beet pulp contains 20 lb of pectin per ton. Pectin has a complex structure, having a lacturonic acid with methanol in glucoside chain combination. It is used for gelling fruit preserves, and the gelling strength depends on the size of the molecule, the molecular weight varying from 150,000 to 300,000. It is also used as a blood coagulant in treating hemorrhage, and for prolonging the effect of some drugs by retarding their escape through the body. Sodium pectate is used for creaming rubber latex, and in cosmetics and printing inks. Hemicellulose and pectin are valuable in the human system because of their ability to absorb and carry away irritants, but they are not foods in the normal sense of the term. Each of the saccharides has distinctive characteristics of value in the system, but each also in excess causes detrimental conditions. The metabolism, or energy-yielding process, of carbohydrates as food is complex and varies greatly in the presence of, or lack of, various minerals, vitamins, nitrogen compounds, absorption of oxygen, and the acids and glycerides of fats. Carbohydrates are used in many industries. The sugars are employed for the manufacture of alcohols, the starches for adhesives and sizing, the celluloses for plastics and explosives, and the hemicelluloses as thickening agents.

**Carbon.** A nonmetallic element, symbol C, existing naturally in several allotropic forms, and in combination as one of the most widely distributed of all the elements. It is quadrivalent, and has the property of forming chain and ring compounds, and there are more varied and useful compounds of carbon than of all other elements. Carbon enters into all organic matter of vegetable and animal life, and the great branch of organic chemistry is the chemistry of carbon compounds. The black amorphous carbon has a specific gravity of 1.88; the black crystalline carbon known as graphite has a specific gravity of 2.25; the transparent crystalline carbon, as in the diamond, has a specific gravity of 3.51. Amorphous carbon is not soluble in any

known solvent. It is infusible, but sublimates at  $3500^{\circ}\text{C}$ , and is stable and chemically inactive at ordinary temperatures. At high temperatures it burns and absorbs oxygen, forming the simple oxides  $\text{CO}$  and  $\text{CO}_2$ , the latter being the stable oxide present in the atmosphere and a natural plant food. Carbon dissolves easily in some molten metals, notably iron, exerting great influence on them. Steel, with small amounts of chemically combined carbon, and cast iron, with both combined carbon and graphitic carbon, are examples of this.

Carbon occurs as hydrocarbons in petroleum, and as carbohydrates in coal and plant life, and from these natural basic groupings an infinite number of carbon compounds can be made synthetically. Carbon, for chemical, metallurgical, or industrial use, is marketed in the form of compounds, or in master alloys containing high percentages of carbon, or as activated carbons, charcoal, graphite, carbon black, coal-tar carbon, petroleum coke, and as pressed and molded bricks or formed parts with or without binders or metallic inclusions. Natural deposits of graphite, coal tar, and petroleum coke are important sources of elemental carbon. Charcoal and activated carbons are obtained by carbonizing vegetable or animal matter. Carbon 13 is a variety of carbon containing an extra neutron in the nucleus of the atom. It is made only in very small quantities by a complicated isotope exchange process. It is used as a tracer in biologic research where its heavy weight makes it easily distinguished from other carbon. Carbon 14, or Radioactive carbon, has a longer life. It exists in the air, formed by the bombardment of nitrogen by cosmic rays at high altitudes, and enters into the growth of plants. The half life is about 6,000 years. It is made from nitrogen in a cyclotron.

Carbon brushes for electrical motors and generators, and Carbon electrodes, are made of carbon in the form of graphite, petroleum coke, lampblack, or other nearly pure carbon, sometimes mixed with copper powder to increase the electrical conductivity, and then pressed into blocks or shapes and sintered. Carbon brick, used as a lining in the chemical processing industries, is carbon compressed with a bituminous binder and then carbonized by sintering. If the binder is capable of being completely carbonized, the bricks are impervious and dense. Graphite brick, made in the same manner from graphite, is more resistant to oxidation than carbon bricks and has a higher

thermal conductivity, but it is softer. The binder may also be a furfural resin polymerized in the pores. Karbate No. 1, of the National Carbon Co., Inc., is a carbon-base brick, and Karbate No. 2 is a graphite brick. Karbate has a crushing strength of 10,500 psi, and a weight of 110 to 120 lb per cu ft. The material is also used for lining chemical pumps, for valves, and for acid-resistant parts. Graphitar, of the U.S. Graphite Co., is a strong, hard carbon molded from amorphous carbon mixed with other forms of carbon. It has high crushing strength and acid resistance, and is used for sealing rings, chemical pump blades, and piston rings. Porous carbon is used for the filtration of corrosive liquids and gases. It consists of uniform particles of carbon pressed into plates, tubes, or disks without a binder, leaving interconnecting pores of about 0.001 to 0.0075 in. in diameter. The porosity of the material is 48%, tensile strength 150 psi, and compressive strength about 500 psi. Porous graphite has graphitic instead of carbon particles, and is more resistant to oxidation but is lower in strength. Carbocell and Graphicell are trade names of the National Carbon Co., Inc., for these materials.

The so-called carbons used for electric-light arc electrodes are pressed from coal-tar carbon, but are usually mixed with other elements to bring the balance of light rays within the visible spectrum. Solid carbons have limited current-carrying capacity and begin hissing about 40 amp per sq cm. But when the carbon has a center of metal compounds such as the fluorides of the rare earths, it will have the current capacity greatly increased. It then forms a deep positive crater in front of which is a flame five times the brilliance of that with the low-current arc. The Sunshine carbon, used in electric-light carbons to give approximately the same spectrum as sunlight, is molded coal-tar carbon with a core of cerium metals to introduce more blue into the light. Arc carbons are also made to give other types of light, and to produce special rays for medicinal and other purposes. B carbon, of the National Carbon Co., Inc., contains iron in the core and gives a strong emission of rays from 2,300 to 3,200 angstrom units, which are the antirachitic radiations. The light seen by the eye is only one-fourth the total radiation since the strong rays are invisible. C carbon contains iron, nickel, and aluminum in the core, and gives powerful lower zone ultraviolet rays. It is used in light therapy and

for industrial applications. E carbon, to produce penetrating infrared radiation, contains strontium. Electrode carbon is molded in various forms for arc furnaces. The carbon is consumed both in the production of light and of furnace heat. For example, from 500 to 600 kg of carbon is consumed in producing a metric ton of aluminum.

**Carbon bisulphide.** Also called Carbon disulphide. A colorless liquid of the composition  $\text{CS}_2$ , made by heating together carbon and sulphur. It is inflammable and poisonous, but is a good solvent for oils, fats, resins, and waxes. The specific gravity is 1.263, boiling point  $46.3^\circ\text{C}$ , and solidifying point  $-111^\circ\text{C}$ . It is a highly refractive liquid with a characteristic odor.

**Carbon black.** An amorphous powdered carbon resulting from the incomplete combustion of a gas, usually deposited by contact of the flame on a metallic surface, but also made by the incomplete combustion of the gas in a chamber. The carbon black made by the first process is called Channel black, taking the name from the channel iron used as the depositing surface. The carbon black made by other processes is called Soft black and is weaker in color strength. It is therefore not as useful as a pigment. Carbon black from clean artificial gas is a glossy product with an intense color, but all the commercial carbon black is from natural gas. To remove  $\text{H}_2\text{S}$  the sour gas is purified and water-scrubbed before burning. Thermotomic black, a grade made by the thermal decomposition of the gas in the absence of oxygen, is preferred as a filler in rubber because it does not retard the vulcanization. Carbon black is used as a paint pigment, in stove polishes, carbon paper, and in printing and drawing inks. Its largest use is in rubber for automobile tires to give added wear resistance to the tire. The blacker blacks have a finer particle size than the grayer blacks, hence have more surface and absorptive capacity in compounding with rubber. Channel black is valued for rubber compounding because of low acidity and low grit content. The high pH of furnace black may cause scorching unless offsetting chemicals are used, but some furnace blacks are made especially for tire compounding. SAF black, of the Phillips Petroleum Co., is such a furnace black.

Carbon black is produced largely in Louisiana, Texas, and Oklahoma. The yield per thousand cubic feet of gas is from 1.1 to 1.8 lb. Acetylene black is a carbon black made from acetylene. It is more

graphitic than ordinary carbon black and is used in dry cells and liquid oxygen explosives. Carbon black grades are often designated by trade names for particular uses. Kosmovar, of the United Carbon Co., is a black with a slight bluish top tone used as a pigment for lacquers. The specific gravity is 1.72, and the mesh is 325. Gastex and Pelletex are carbon blacks of the General Atlas Carbon Co. used for rubber compounding. Statex, of the Columbian Carbon Co., is a colloidal furnace black for synthetic rubber compounding. Kosmos 60, of United Carbon Co., Inc., is a furnace black of high density and structure, while Continex FF of this company is a finely divided furnace black. Both are used in rubber compounding, the first giving easier extrusion of the rubber, and the second giving better abrasion resistance. Aquablak H, of the Binney & Smith Co., is a colloidal water dispersion of channel black to give a jet-black color. Aquablak M is a water dispersion of furnace black to give a blue-gray tone. They are used as pigments in casein paint, inks, and leather finishes.

**Carbon dioxide.** Also called Carbonic acid and Carbonic anhydride, and in its solid state, Dry ice. A colorless, odorless gas of the composition  $\text{CO}_2$ , which liquefies at  $-65^\circ\text{C}$  and solidifies at  $-78.2^\circ\text{C}$ . It is obtained as a by-product of distilleries, from burning lime, and from natural gas. In liquid form it is marketed in cylinders, and is used in fire extinguishers, spray painting, refrigeration, for inert atmospheres, for the manufacture of Carbonated beverages, and in many industrial processes. It is also marketed as Dry ice as a white snowlike solid used for refrigeration in transporting food products. About 1,000 lb of dry ice will refrigerate a car for a trip from California to New York, compared with 10,000 lb of water ice and salt. Cardox is a trade name of the Cardox Corp. for liquid carbon dioxide in storage units at 300 psi pressure for fire-fighting equipment.

Carbon monoxide,  $\text{CO}$ , is a product of incomplete combustion, and is unstable, but is one of the chief desirable products in synthesis gas for making chemicals, the synthesis gas made from coal containing 37% min  $\text{CO}$ . Carbon monoxide is an intense poison when inhaled, as it captures instantly the oxygen of the red blood corpuscles and cannot alone be subsequently replaced by oxygen.

**Carbon paper.** Paper used for duplicating typewriting, pencil, or pen writing. It is made by coating the paper with a mixture of

a pigment and a medium. The pigments include carbon black, Prussian blue, and organic red, or blue and green lakes. The medium is likely to be a blend of waxes and oils to give a composition of the desired consistency and melting point but, to make a good carbon paper that will not be gummy and will not smear, a proper proportion of a high-melting true wax, such as carnauba, must be used. Papers of special texture, usually rag papers, are used.

**Carbon steel.** Any steel owing its distinctive properties to carbon chemically combined with the iron. If other elements in influencing proportions are in the steel, it is designated as an alloy steel, except that up to 1.65% manganese, 0.60 silicon, and 0.60 copper may be included without the steel being considered as alloyed. Likewise, small amounts of sulphur to give free-machining properties may be added without changing the name. When the carbon is below 0.15%, the metal may be called iron; when the carbon exceeds 0.60%, the steel is usually considered to be tool steel. However, there is no fixed dividing line, and carbon steels for general use may be high or low in carbon. The old shop names, Machine steel, or Machinery steel, for open-hearth carbon steel having a low carbon range, are still used to mean any easily worked low-carbon steel up to the tool-steel range that requires only simple heat-treatment. Those of low carbon have tensile strengths from 35,000 to 45,000 psi, and those with 0.40 to 0.60% carbon have strengths up to 60,000 psi, or up to 120,000 psi when hard-drawn. SAE steel 1020, with 0.15 to 0.25% carbon, when cold-rolled or hard-drawn, has a tensile strength from 40,000 to 60,000 psi, with elongation 30 to 40%. These steels do not contain enough carbon to harden fully, but they can be carburized and casehardened. When properly heat-treated, they have a fine grain, good wearing qualities on the outside, and a rough core. They will not withstand repeated shocks or stresses. Those with low carbon are ductile and are useful for deep drawing. The control of microstructure is important in this type of steel. They are used for shafts, forgings, gears, machine parts, and cheap dies and gages for small runs. They forge and machine easily. Up to 0.15% sulphur, or 0.045 phosphorus, makes them free-cutting and keeps the chips from curling, but reduces the strength.

Screw stock, or Free-cutting steel, in rod form, with sulphur or

phosphorus, is produced regularly in the carbon range from 0.08 to 0.25%, designated as SAE 1112 to SAE 1120 steel. The carbon Rail steel, for railway rails, is characterized by an increase of carbon with the weight of the rail. Railway engineering standards call for 0.50 to 0.63% carbon and 0.60 manganese in a 60-lb rail, and 0.69 to 0.82% carbon and 0.70 to 1.0 manganese in a 140-lb rail. Sometimes a machinery steel may be required with a small amount of alloying element to give a particular characteristic and still not be marketed as an alloy steel, although trade names are usually applied to such steels. Crow steel, of the Allegheny Ludlum Steel Corp., is a carbon steel with 0.50% chromium to give greater depth of hardness. When annealed, it machines the same as the straight carbon Corinth steel of this company. Economo steel, of Wheelock, Lovejoy & Co., Inc., is a low-carbon steel containing 0.18% molybdenum to produce a tough core when casehardened. Max-El 1B steel, of the Crucible Steel Co., has 0.20% carbon, high manganese, and a small amount of molybdenum. Carilloy FC steel, of the Carnegie-Illinois Steel Corp., is a free-cutting manganese-chrome-molybdenum steel giving tensile strengths to 175,000 psi without heat treatments. The Rytense AA machinery steel, of Joseph T. Ryerson & Sons, Inc., is a special-analysis steel with a tensile strength up to 115,000 psi, elongation 20%, and Brinell hardness 229.

The so-called Hobbing steels, used for making plastic molds by pressing the hard model into the steel, may be plain carbon steel for casehardening, or they may be low-alloy steels. Press E-Z steel, of the Jessop Steel Co., is a hobbing steel containing 0.40 to 0.50% carbon and 0.15 to 0.20 manganese with no alloying elements. It is marketed annealed to 100 Brinell, and when carburized and hardened has a hardness of 60 Rockwell C. SAE steel 3110 is a hobbing steel containing 0.50% manganese, 0.60 chromium, and 1.25 nickel. It takes deep impressions, and when hardened has high core strength. SAE steel 3312 is a hobbing steel with 3.5% nickel and 1.5 chromium. After air hardening, the core strength is 160,000 psi and core hardness 360 Brinell. Speed Alloy, of W. J. Holliday & Co., is a mold steel that machines easily and gives deep hardening and high core strength when hardened. It is a 0.30% carbon steel with some chromium and molybdenum. Tensile strength, annealed, is 107,000 psi, elongation 26%, and Brinell hardness 207.



**Carbon tetrachloride.** A heavy colorless liquid of the composition  $\text{CCl}_4$ , also known as Tetrachloromethane, which is one of a group of chlorinated hydrocarbons. It is an important solvent for fats, asphalt, rubber, bitumens, and gums. It is more expensive than the aromatic solvents and is toxic, but it is notable as a noninflammable solvent for many materials sold in solution, and is widely used as a degreasing and cleaning agent in the dry-cleaning and textile industries. It is employed in such cleaning compounds as Carbona, and as a chemical in fire extinguishers such as Pyrene. A disadvantage as a fire extinguisher is that when it falls on hot metal it forms the poisonous gas phosgene. It is also used as a disinfectant, and because of its high dielectric strength has been employed in transformers. It was first produced in 1839 and used in Germany as a grease remover under the name of Katharin. Carbon tetrachloride is obtained by the chlorination of carbon bisulphide. The specific gravity is 1.595, boiling point  $76.8^\circ\text{C}$ , and solidifying point  $-23^\circ\text{C}$ . Chlorobromoethane,  $\text{CH}_2\text{ClBr}$ , is used to replace carbon tetrachloride in fire extinguishers as it is less corrosive. It is a heavy liquid boiling at  $155^\circ\text{F}$  and freezing at  $-123^\circ\text{F}$ .

**Carnauba wax.** A hard, high-melting lustrous wax from the fanlike leaves of the palm tree *Copernicia cerifera* of the arid region of northeastern Brazil, sometimes referred to as Brazil wax or Ceara wax. It is composed largely of Ceryl palmitate,  $\text{C}_{25}\text{H}_{51}\text{COOC}_{30}\text{H}_{61}$ . The trees grow up to 60 ft in height with leaves 3 ft in length. The wax forms a protective coating on the leaves, and when the leaves are dried it flakes and is beaten off and melted into cakes. The wax comes in hard, vitreous, yellowish cakes or lumps that melt at about  $85^\circ\text{C}$ , and have a specific gravity of 0.995. It is soluble in alcohol and in alkalis. Olho wax is the wax from young yellow leaves and is whitish gray. Palha wax, from older green leaves, is of a deeper grayish-yellow hue. In melting, water is added to the palha to make the Chalky wax. No. 3 chalky contains up to 10% water. Olho wax without water yields the prime yellow wax. Flora wax is the highest quality and is clear yellow. Fully 70% of the production of carnauba goes into the manufacture of floor waxes and carbon paper. It has the property of being self-polishing in liquid floor waxes. In carbon paper it is nongreasy and nonsmearing. Other uses are in shoe

polishes, leather finishes, phonograph records, and for blending with other waxes for coating compounds. Burnishing wax, in the shoe industry, is carnauba wax blended with other waxes.

A wax quite similar to carnauba is Guaruma, or Cauassu wax, from the leaves of the *Calathea lutea*, a small plant with large leaves like those of the banana, growing in the lower Amazon Valley. Its melting point is 80°C. Another similar wax is from the trunk of the Wax palm, *Ceroxylon andicola*, growing on the Andean slopes. A wax that is very similar to carnauba in properties and is more plentiful, but which contains the green leaf coloring difficult to bleach out, is Ouricury wax. The name is also spelled Urucury (Uru, the Carib name for a shell; O means leaf). The wax is from the leaves of the palm tree *Syagrus coronata*, or *Cocos coronata*, of northeastern Brazil. It is beaten off or boiled off the dried leaves and melted into blocks. The green color results largely from the method of preparation of the wax as it does not flake off the leaves like carnauba. Ouricury wax has a melting point of about 85°C, acid number 10.6, iodine value 16.9, and saponification value 78.8. It has the same uses as carnauba where color is not important, or it is used to blend with carnauba to increase the gloss. The nuts of the tree are called Licurí nuts, and are used to produce Licurí oil employed in soaps. The name Licurí wax is sometimes erroneously given to ouricury. Cotton wax, which occurs in cotton fiber to the extent of about 0.6%, is very similar to carnauba wax. It is a combination of C<sub>28</sub> to C<sub>32</sub> primary alcohols with C<sub>24</sub> to C<sub>32</sub> fatty acids. It has not been produced commercially although some strains of cotton contain 15% wax. Sugar-cane wax is a hard wax similar to carnauba occurring on the outside of the sugar-cane stalk. A ton of cane contains 2 to 3 lb of wax, which concentrates in the filter press cake after clarification of the cane juice. Henequen wax, extracted from the waste pulp of the henequen plant, has a melting point of 185°F, and is similar to carnauba.

**Carnotite.** A mineral found in Utah and Colorado and employed as a source of uranium, radium, and vanadium. It is a vanadate of uranium and potassium,  $V_2O_5 \cdot 2U_2O_3 \cdot K_2O \cdot 3H_2O$ . It is found with other sands and gives them a pale-yellow color. The ore may contain 2 to 5% uranium oxide and up to 6 vanadium oxide, but it usually runs 2%  $V_2O_5$ . The vanadium is produced by roasting the ore, leach-

ing, precipitating the oxide with acids, and sintering. The production of radium from the residue ore is a complex process, and it requires 400 tons of ore to produce a gram of radium. Patronite, mined in Peru as a source of vanadium, is a greenish mineral,  $V_2S_6$ , mixed with pyrites and other materials.

**Caroa.** Pronounced car-o-áh. The fiber from the leaves of the plant *Neoglaziovia variegata* of northeastern Brazil. It is more than twice as strong as jute and is lighter in color and lighter in weight, but is too hard to be used alone for burlap. It is employed as a substitute for jute for burlap when mixed with softer fibers, and also for rope, and in mixtures with cotton for heavy fabrics and suitings. Some suiting is made entirely of the finer caroa fibers. Fibrasil is a trade name in Brazil for fine white caroa fibers.

**Cartridge brass.** One of the standard alloys of the brass mills, containing 70% copper and 30 zinc. Because of the general use of the alloy for making cartridges and for other deep drawing, the highest purity zinc is used and all lead is excluded. It has high ductility and an attractive yellow color, and is used for deep-drawn or spun articles such as lamp bases, horns, and cornets. It brazes well and electroplates easily. Hard-rolled sheet has a tensile strength of 84,000 psi, with elongation 5%, while the annealed sheet has a strength of 49,000 psi, and elongation 55%. The coefficient of expansion is 0.0000103 per deg F, weight 0.308 lb per cu in., and electrical conductivity 27% that of copper. Revere alloy No. 160, of the Revere Copper & Brass, Inc., is this alloy. This composition of brass is also marketed as Brass powder for making parts by molding and sintering, and when used with 1% phosphor-copper powder produces strong and tough parts. A slightly harder alloy, used for wire goods, is Eyelet brass, containing 68% copper and 32 zinc. A grade produced by the American Brass Co. under the name of Spinning brass contains 67% copper and 33 zinc. Lubaloy, of the Western Cartridge Co., contains some tin. A typical composition of the Cartridge brass strip of the Scovill Mfg. Co. is 68.94% copper, 0.01 lead, 0.01 iron, and the balance zinc. Primer brass, for cartridge primers, may be the 70-30 alloy, or it may be cap copper.

**Casehardening materials.** Any material employed for adding carbon to the outside of low-carbon steels or to iron so that upon

quenching a hardened case is obtained, the center of the steel remaining soft and ductile. The material may be plain charcoal, raw bone, or mixtures marketed as Carburizing compounds. A common mixture is about 60% charcoal and 40 barium carbonate. The latter decomposes, giving carbon dioxide which is reduced to carbon monoxide in contact with the hot charcoal. If charcoal is used alone, the action is slow and spotty. Coal or coke can be used, but the action is slow, and the sulphur in these materials is detrimental. Salt is sometimes added to aid the carburizing action. By proper selection of the carburizing material the carbon content may be varied in the steel from 0.80 to 1.20%. The carburizing temperature for carbon steels is 1600°F, and for alloy steels about 1525°F. The articles to be carburized for casehardening are packed in metallic boxes for heating in a furnace, and the process is called pack hardening as distinct from the older method of burying the red-hot metal in charcoal.

The principal liquid carburizing material is sodium cyanide, which is melted in a pot and the articles dipped in, or the cyanide rubbed on the hot steel. Cyanide hardening gives an extremely hard but superficial case. Nitrogen as well as carbon is added to the steel by this process. Gases rich in carbon, such as methane, may also be used for carburizing, by passing the gas through the box in the furnace. When ammonia gas is used to impart nitrogen to the steel, the process is not called carburizing but is referred to as nitriding. Carbonitriding is a casehardening process of Armour & Co. which consists in heating the steel in an atmosphere of nitrogen and carbon. The source of the nitrogen is anhydrous ammonia, and the source of the carbon is natural gas, propane, or benzol. Since nitrogen lowers the critical range, the steel can be carbonized at lower temperatures than ordinarily applied. No special steels are needed. Malcomized steel, of the Chapman Valve Mfg. Co., is stainless steel surface-hardened to a Rockwell hardness of 92 by heat-treating with nitrogen. The chromium of the steel is the hardening element, and no aluminum is needed in the steel as in nitriding.

Casehardening compounds are marketed under a wide variety of trade names. These may have a base of hardwood charcoal or of charred bone, with sodium carbonate, barium carbonate, or calcium carbonate. Char, of the Char Products Co., is a carburizing material in which the particles of coal-tar carbon are surrounded by an activator

and covered with a carbon coating. Accelerated Salt WS, of E. I. du Pont de Nemours & Co., Inc., for heat-treating baths, has a content of 66% sodium cyanide, with graphite to minimize fuming and radiation losses. For selective casehardening on steel parts a stiff paste of carburizing material may be applied to the surfaces where a carbon impregnation is desired. Carburit, of the Denfis Chemical Laboratories, is a carburizing paste of this kind. Aerocarb and Aero-case, of the American Cyanamid Co., are mixtures of sodium and potassium nitrates and nitrides for use in carburizing baths over a temperature range up to 1850°F.

**Casein.** A whitish to yellowish granular or lumpy protein precipitated from skim milk by the action of a dilute acid, or coagulated by rennet, or simply inoculated with whey from a previous batch. The precipitated material is then filtered and dried. Cow's milk contains about 3% casein. It is insoluble in water or in alcohol, but is attacked by alkalis. Most of the production is by acid precipitation, and this material has a moisture content of not more than 10%, has not more than 2.25% fat, and not over 4 ash. The casein made with rennet has higher ash content, up to 7.5%, less than 1% fat, and is less soluble in alkalis. It is the type used for making plastics. Rennet is an extract of an enzyme derived from the stomachs of calves and lambs and is closely related to pepsin. Argentina and the United States are the most important producers of casein, but production drops in the United States at times when milk products are in greater demand for food. France, Norway, and Holland are also large producers. Casein is employed for making plastics, adhesives, sizing for paper and textiles, washable interior paints, leather dressings, and as a diabetic food. Casein glue is a cold-work, water-resistant paste made from casein by dispersion with a mild base such as ammonia. With a lime base it is more resistant but has a tendency to stain. It is marketed wet or dry, the dry powder being simply mixed with water for application. It is used largely for low-cost plywoods and in water paints, but is not waterproof.

**Casein plastics.** A group of thermoplastic molding materials made usually by the action of formaldehyde on rennet casein. The process was invented in 1885, and the first commercial casein plastic was called Galalith, meaning Milkstone. Casein plastics are easily molded,

machine easily, are noninflammable, will withstand temperatures up to 300°F, and are easily dyed to light shades. But they are soft, have high water absorption, 7 to 14%, and soften when exposed to alkalis. They are thus not suitable for many mechanical parts or for electrical parts. They are used for ornamental parts, buttons, and for such articles as fountain-pen holders. The specific gravity of the material is 1.34, and the tensile strength is 8,000 psi. They are usually marketed under trade names. Some of these are Aladdinite, of the Aladdin Co., Inc.; Inda, of the American Machine & Foundry Co.; Erinoid, of the Erinoid Co.; Lactoid, of the British Xylonite Co., Ltd.; Lactonite, of the British Lactonite Co.; Ameroid, of the American Plastics Corp.; and Karolith, of the Karolith Corp. Sicalite is a French casein plastic. Casein fiber is made by treating casein with chemicals to extract the albumen and salts and forcing it through spinnerets, and again treating it to make it soft and silklike. The fiber is superior to wool in silkiness and resistance to moth attack, but is inferior in general properties. It is blended with wool in fabrics and in hat felts. Lanitol was an early Italian casein fiber. Aralac fiber, of Aralac, Inc., is a translucent, white, silky casein fiber. Caslen, of the Rubberset Co., is a resilient curled casein fiber used as a substitute for horsehair.

**Cashew-nut shell oil.** An amber-colored, poisonous, viscous oil obtained by extraction from the by-product shells of the cashew-nut industry of India and Brazil. For every pound of shelled nuts there are 3.55 lb of by-product shells. The cashew nut grows on the distal end of the fruit of the tree *Anacardium occidentale*. The thin-skinned, yellow, pear-shaped fruit may be eaten or used in preserves. The kernel of the seed nut, known as the Cashew nut, is roasted and widely used as an edible nut or in confections. The kernel is crescent-shaped, and the nuts are graded by sizes from 200 per lb to 400-450 per lb. On crushing, the nuts produce 45% of an edible oil, but the nuts are more valuable as a confection than for oil, and there is no commercial production of cashew-nut oil. One pound of shells yields 0.335 lb of cashew-nut shell oil which contains largely Anacardic acid, a high phenol, very blistering to the skin. It is used for the production of plastics, drying oils, and insulating compounds. The oil reacts with formaldehyde to give a drying oil. With furfural it produces a mold-

ing plastic. Reacted with other chemicals it forms rubberlike masses used as rubber extenders and in electrical insulating compounds. On distillation, cashew-nut shell oil yields Cardanol, a light oily liquid of the composition  $C_8H_4 \cdot OH(CH_2)_8CH:CH(CH_2)_8CH_3$ , with boiling point at  $360^\circ C$  and freezing point of about  $-20^\circ C$ . Cardanol polymerizes with formaldehyde to form a heat-resistant, chemical-resistant, flexible resin of high dielectric strength valued for wire insulation. Small amounts of this resin also improve the chemical and electrical properties of the phenol resins.

**Cashmere.** A fine, soft, silky fabric made from the hair of the Cashmere goat raised on the slopes of the Himalayas of Asia. The hair is obtained by combing the animals, not by shearing, and the production is small. The hair is straight and silky, but not lustrous, and is difficult to dye. The fabrics are noted for warmth, and the production now goes mostly into the making of shawls and fine ornamental garments. Cotton cashmere is a soft, loose-woven cotton fabric made to imitate cashmere, or it may be a cotton and wool mixture, but it lacks the fineness of true cashmere.

**Cassiterite.** Also called Tin stone. It is the only commercial Tin ore, and is a Tin dioxide,  $SnO_2$ , containing theoretically 78.6% tin. It is a widely distributed mineral, but is found on a commercial scale in only a few localities, notably in Malaya, East Indies, Bolivia, Cornwall, England, Nevada, Isle of Pines, and in Australia. The mineral occurs granular massive with a specific gravity of 6.8 to 7.1, and a hardness of 6 to 7, with a brown to black color. It is present in the ore usually in amounts of from 1 to 5%, and is found in veins, called Lode tin, or in placer deposits. The concentrated ore averages 65 to 70% tin oxide. It is roasted to eliminate sulphur and arsenic, and then smelted in reverberatory furnaces.

**Cast iron.** A combination of iron with from 2 to 6% carbon, receiving its name from the fact that it is readily cast into almost any desired shape in an ordinary sand mold. The ASTM definition is an iron containing so much carbon that it is not malleable at any temperature. The low limit is about 1.7%. Cast iron is of two kinds: White cast iron and Gray iron. The first is a chemical compound of most of the carbon with the iron; the second contains most of the carbon in the form of graphite mechanically mixed with the iron. Ordinary cast

iron is brittle and not malleable. It is low in cost, easy to machine, and has a higher proportional fatigue than steel. It is used for the massive bodies of machines and for intricate castings that do not require high strength. White iron is made by chilling gray iron, and may be converted into gray iron by heating to 1850°F for several hours. Cast iron is made by melting pig iron and scrap in a cupola in contact with the fuel, which is usually coke. The pouring temperature is about 2460°F. With an electric furnace, scrap iron may be employed alone with carbon without pig iron, and the furnace may be operated continuously. The product is called Synthetic cast iron.

The specific gravity of gray iron is 7.10, and that for white iron is 7.50. The coefficient of expansion is 0.0000056. Tensile strengths of plain gray irons vary from 18,000 to 25,000 psi, and compressive strength from 60,000 to well over 100,000 psi. Ordinary cast iron contains 3.25 to 3.75% carbon, about 2.5 silicon, 0.60 manganese, 0.06 sulphur, and 0.40 to 0.80 phosphorus. The chemically combined carbon governs the melting point. An iron with 4.2% combined carbon and 0.2 graphite melts at 1990°F, while one with 0.17% combined carbon and 3.57 graphite melts at 2260°F. If the combined carbon is above 0.75%, machining is difficult. At 1.50% machining is impossible with ordinary tools. At 1.75% the hardness may be as high as 477 Brinell, whereas soft iron is as low as 88 Brinell. Pure iron can take up to 4.6% carbon in a chemically combined state. Manganese and chromium increase this saturation point, but silicon reduces it.

The combined carbon structure of cast iron is known as Austenite, and the structure with the iron-carbon compound  $\text{Fe}_3\text{C}$ , which forms when the austenite changes on cooling, is called Cementite. The term Ferrite is used for the iron crystals having no carbon. Pearlite, the most desirable structure of cast iron, consists of alternate layers of ferrite and cementite. The tensile strength of such a structure, if it could be obtained throughout, would be 100,000 psi, but a good average for plain gray iron is 22,000 psi, with a compressive strength of 100,000 psi. Gun iron, formerly used for casting cannon, was a fine-grained iron of uniform texture, low in sulphur and in total carbon, made with charcoal in an air furnace, and had tensile strengths equal to some modern high-test cast irons. Graphite is a weakening element in cast iron, and the high graphitic irons are



desired only because of their ease of casting and machining. The lower the carbon, the stronger the cast iron. To obtain this result, steel scrap is used in the mix. Low-carbon steel of known chemical content, such as plate and rod ends and rail croppings, is used. The amount of steel varies from 15 to 60%, and the product resulting from the larger additions is called Semisteel. Tensile strengths as high as 40,000 psi can be obtained without great reduction in the casting and machining qualities of the cast iron. Semisteel castings can be softened and made more ductile by annealing at a temperature of about 800°F, but they then lose 25 to 35% of the tensile strength. In cast iron the graphite occupies 11 to 17% of the volume, and by control of its distribution and the size of the flake it is possible to vary the tensile strength from 10,000 to 60,000 psi. An important factor in the control is the rate at which the molten iron cools down to about 1000°F.

Nodular cast iron is iron in which the graphite has a nodular shape distributed through a ferritic matrix instead of the usual flat flakes in a matrix of pearlite and ferrite. Nodular iron is produced by treating the molten iron with magnesium, usually in the form of a magnesium-copper-ferrosilicon or other master alloy, leaving about 0.08% residual magnesium in the iron. A high-strength nodular iron will have a tensile strength of 100,000 psi, elongation 1.5%, and Brinell hardness 255, while a high-ductility nodular iron has a tensile strength of 60,000 psi, elongation 16%, and Brinell hardness 160. A Nodulizing alloy of the Union Carbide & Carbon Corp. for adding magnesium to cast iron contains 7 to 10% magnesium, 43 silicon, and the balance iron. Cecolloy, of the Chambersburg Engineering Co., is a nodular cast iron having a tensile strength of 80,000 psi and elongation 15%.

Phosphorus in cast iron increases fluidity, but more than 0.6% makes the iron hard. Sulphur is an undesirable impurity. Silicon goes into solid solution in iron to form iron silicides and precipitates graphite. Small amounts make the iron soft, but large amounts make it glassy hard. Copper is also used as a graphitizer and to increase the heat conductivity. Engine cylinder blocks of high heat conductivity and good strength contain about 0.75% copper. Lithium-treated cast irons make sound, dense, and hard castings. The lithium cleans the iron and disperses the carbon. Nickel, chromium, and

other elements are added to cast irons while molten to give additional strength, toughness, or hardness, but the iron is then generally known as Alloy cast iron. Manganese decreases the magnetic properties of cast iron. Nomag, an English nonmagnetic cast iron, contains 6% manganese. Adding nickel makes this manganese iron machinable without changing its nonmagnetic quality. Small amounts of tungsten increase the tensile and transverse strength of cast iron, but reduce its hardness. A Tungsten cast iron, with 1.2% tungsten, has a tensile strength of about 40,000 psi. Casehardening of cast iron is done by using powdered ferromanganese on the mold surface. Nitrided cast iron, hardened by nitrogen treatment to give great wear resistance, usually has a special composition. A typical composition for the Nitricastiron, as given by the Electro Metallurgical Co., is 2.9% total carbon, 0.6 combined carbon, 2.7 silicon, 0.75 manganese, 1.3 chromium, 1 aluminum, 0.16 vanadium, 0.25 molybdenum, with sulphur and phosphorus below 0.07. It can be hardened to 800 to 1,000 Brinell to a depth of 0.004 to 0.006 in. Cast iron deteriorates rapidly when subjected to temperatures above 800°F, and the Heat-resistant cast irons for firebox castings and stove grates contain some chromium to stabilize the pearlite and cementite. A cast iron containing 1.25% chromium will withstand temperatures up to 1400°F. Trade names are used to designate cast iron made by special processes. Pomoloy, of the Pomona Pump Co., is an unalloyed cast iron with a tensile strength of 40,000 psi, and hardness 215 Brinell. DeLavaud metal, of the U.S. Cast Iron Pipe & Foundry Co., is made by a centrifugal process in rotating steel molds. After annealing, the pipe has an outer layer of malleable iron, a center layer resembling steel, and an inner surface of gray iron. Hi-Tem iron, of the Bethlehem Foundry & Machine Co., is a corrosion-resistant cast iron used for processing vessels. Hi-Tem S is a high-manganese iron used for retorts.

High-test cast iron was originally cast iron that was superheated in the melting for pouring, poured in chilling molds, and then heat-treated, the only change in composition being to keep the silicon and manganese high. The term now means high-strength irons that are processed to give a careful balance of ferrite, pearlite, cementite, and carbon by the treatment, by additions of steel scrap, and by additions of nickel, chromium, and other elements that give strength to the

metal by balancing the structure, but are not in sufficient quantities to classify the iron as an alloy cast iron. Tensile strengths above 50,000 psi are obtained, and all of the high-test irons are fine-grained, and are not spongy like gray iron. Steel scrap gives a stronger and finer structure; nickel gives ease of machining and aids in the chilling; chromium gives hardness and resistance to growth; molybdenum raises the combined carbon and adds strength and hardness. Oxygenized iron is high-test cast iron made by blowing air through a part of the metal and then returning the blown metal to the cupola. There is no sharp dividing line between some of these processed irons and steel, and when the combined carbon is high and the graphitic carbon is well distributed in even flakes the metal is called Graphitic steel. High-test cast irons are used for brake drums, cams, rolls, and high-strength parts. In many cases they are substitutes for malleable iron. They are marketed under many trade names. Ermal is a pearlitic cast iron of the Erie Malleable Iron Co. with a tensile strength up to 70,000 psi. Perlit, of the Durson Corp., is another pearlitic cast iron. Aremite is a synthetic cast iron of Robbins & Myers, Inc. Jewell alloy, of the Jewell Steel & Malleable Co., is the name of a group of high-strength and heat-resistant irons. Ermalite, of the Erie Malleable Iron Co., and Wearloy, of the Frank Foundries Corp., are high-strength, wear-resistant cast irons. Gunitite, of the Gunitite Corp., is a graphitic steel which, when quenched to a hardness of 477 Brinell, has a compressive strength of 200,000 psi. Arma steel, of the Saginaw Malleable Iron Div., General Motors Corp., is a graphitic steel, or arrested malleabilized iron of high strength and shock resistance, used for connecting rods, gears, and camshafts where both high strength and bearing properties are required. Meehanite metal, produced under license of the Meehanite Research Institute of America, is made in a wide range of high-strength, wear-resisting, corrosion-resisting, and heat-resisting castings for dies, hydraulic cylinders, brake drums, pump parts, and gears. The normal strengths range from 35,000 to 55,000 psi, compressive strengths from 135,000 to 175,000 psi, and hardnesses from 193 to 223 Brinell.

**Castor oil.** A light-yellow to brownish viscous oil obtained from the seed beans of the castor plant, *Ricinus communis*. In the tropics the plant grows to the proportions of a sturdy tree, but in temperate

climates it is a small plant with a poor yield. Besides its original use as a purgative in medicine, castor oil is one of the most widely used industrial vegetable oils. When pure and fresh, the oil is nearly colorless and transparent. The hot-pressed oil is brownish. It has a characteristic acid, unpleasant taste. The specific gravity is 0.960 to 0.970, iodine value 82 to 90, saponification value 147, and solidifying point  $-10^{\circ}\text{C}$ . Castor seeds have the appearance of mottled colored beans, and are enclosed in hard husks which are removed before crushing. Fully 40% of the world production is in Brazil, and two classes are grown in that country. The large Zanzibar type has seeds 16 mm long containing 30 to 35% oil, and the Sanguineus type has seeds 10 mm long containing up to 60% oil. They are usually mixed in shipments, and the average yield is calculated as 0.45 lb of oil from 1 lb of beans. The oil obtained from the first cold pressing is used in medicine and in lubricants. The second and third grades of hot-pressed oil are the ones for general industrial use. Castor beans are also grown in India, Russia, Argentina, Haiti, Cuba, Japan, and China. Castor oil is used in paints and varnishes usually in dehydrated form, as a hydraulic brake-cylinder oil, as a lubricating oil, for treating leather, in soaps, and for treating textiles. It increases the lathering power of soaps and their solubility in cold water. In lubricating oils and in cutting oils it has excellent keeping qualities and does not dry or gum on exposure.

When castor oil is chemically dehydrated by removing the hydroxyl groups in the form of water by means of a catalyst, a double bond is formed giving an oil of heavy viscosity, light color, and with iodine value 116, acid value 3.5, and saponification value 191. Dehydrated castor oil gives a better gloss in varnishes than tung oil with a softer and less brittle film, but it has less alkali resistance than tung oil unless mixed with synthetic resin. Sulphonated castor oil, known as Turkey red oil in the textile industry, is made by treating crude hot-pressed castor oil with sulphuric acid and neutralizing with sodium sulphate. It is miscible with water and lathers like a solution of soap. It is used for the preparation of cotton fibers to be dyed, and gives clearer and brighter colors. It is also employed in soaps and in cutting compounds. Sulphonated dehydrated castor oil is used in nonalkaline water-washable skin ointments. It has a softening point of  $30^{\circ}\text{C}$  and an  $\text{SO}_2$  content of 10%. Synthenol, of Spencer Kel-

logg & Sons, Inc., is a dehydrated castor oil for paints and varnishes. Castung, of the Baker Castor Oil Co., and Isoline, of the Woburn Degreasing Co., are dehydrated castor oils. Mannitan drying oil, of the Atlas Powder Co., is an ester of dehydrated castor oil that dries faster than linseed oil and has better resistance in paints.

Hydrogenated castor oil is a hard, nongreasy, white solid melting at 82°C, used as an extender for waxes in coating compositions, and as a hard grease for making resistant lithium-type lubricating greases. It contains about 85% hydrogenated ricinoleic acid and the remainder chiefly stearic acid. It is odorless and tasteless. Emery S-751-R, of Emery Industries, Inc., is this material. The hydrogenated ricinoleic acid, known as Hydroxy stearic acid, may also be separated and used for making waxy esters for pharmaceutical ointments, or for reacting with amines to make white, waxy solids useful as water repellents.

A substitute for castor oil in medicine is Croton oil, a yellow-brown oil obtained from the dried ripe seeds of the small tree *Croton tiglium* of India and Ceylon. It has a burning taste and unpleasant odor, and is a more violent purgative than castor oil. The leaves and flowers of the tree are used like derris to kill fish. Curcas oil is a yellowish oil from the kernels of the seeds of the *Jatropha curcas* which grows in Central America. The kernels yield 50% oil with a specific gravity 0.920, iodine value 98 to 104, and saponification value 192. It has 10 times the purgative effect of castor oil, and is also a good soap oil but has an unpleasant odor.

**Cast steel.** Steel that has been cast into sand molds to form finished or semifinished machine parts or other articles. Steel castings are used to replace forgings where only small quantities are required that would not justify the cost of forging dies, and for large parts that could not be forged easily, but the most general use of Steel castings is for intricate parts that would usually require much machining by other methods of production. The electric furnace is most commonly used in the melting process because of the ease of change-over for the production of a variety of grades of steel in small or large tonnages. The open-hearth process is used by foundries that have large runs or very large castings. The induction furnace is used for melting small quantities of special steels.

There are five general classes of commercial steel castings: Low-carbon steels, with carbon content below 0.20% ; Medium-carbon steels, with carbon between 0.20 and 0.50% ; High-carbon steels, with carbon above 0.50% ; Low-alloy steels, with alloy content totaling less than 8% ; High-alloy steels, with alloy content totaling more than 8% . Federal specifications for cast steel call for 0.35% carbon in the soft grade, 0.45 in the medium grade, and 0.50 in the hard grade. The tensile strength of the soft is 60,000 psi, and of the hard 80,000 psi. The yield point is taken as 45% of the tensile strength. The shrinkage allowed for cast steel is  $\frac{1}{4}$  in. per ft. British engineering standard specifications call for cast steel for general purposes to have 0.30% carbon, and a tensile strength of 26 tons per sq in., with elongation 15 to 20% . Most carbon-steel castings produced in the United States are of medium-carbon steel, and these range from 65,000 to 100,000 psi depending on the carbon and the heat-treatment. High-carbon steels, with tensile strengths from 100,000 to 125,000 psi, are produced for parts requiring hardness and wear resistance, such as metalworking dies and rolls. Cast steel, if not produced under controlled conditions, has the disadvantage in comparison with forged steel that it may contain blow holes, slag, sand holes, shrinkage cavities, or cold shuts, the last from pouring at too low a temperature. Thus, companies producing steel castings usually feature careful metallurgical control rather than merely chemical content of the steel, and the cast steels are generally sold under trade names, especially the alloy steels.

Aluminum, titanium, or other elements in the form of master alloys, are used to deoxidize and degasify alloy steels to produce homogeneous castings. Alloy steels for heavy-duty castings may be chromium steel, with 0.80 to 1.10% chromium; vanadium, with 0.15 to 0.20 vanadium; chrome-vanadium; 1.50 to 3.50 nickel; nickel-chromium; or manganese, with either high or medium manganese content. One of the simplest alloy cast steels for parts subject to shock and fatigue stresses is the standard low-carbon and medium-carbon steel with 2% nickel. It is used for mining and other heavy machinery parts, locomotive frames, and ship castings. The tensile strength is up to 85,000 psi, with yield point up to 55,000 psi, and elongation 25 to 32% . The nickel, with manganese up to 0.90% , gives the steel greater shock resistance at low temperatures, as ordinary

steel is brittle in cold climates or when used on refrigerating equipment. A 3 to 3.50% nickel steel used for cast gears for rolling mills has a tensile strength of 110,000 psi, elongation 20%, and hardness 200 Brinell as cast. A nickel-chromium-molybdenum cast steel for heavy gears contains 1.5% nickel, 0.75 chromium, 0.35 molybdenum, 0.70 manganese, and 0.35 carbon. The tensile strength is 145,000 to 160,000 psi.

**Catalyst.** A material used to cause or accelerate chemical action without entering into the chemical combination. Various metals, especially platinum and nickel, are used to catalyze or promote chemical action in the manufacture of synthetics. Acids may be used to aid in the polymerization of synthetic resins. Mineral soaps are used to speed up the oxidation of vegetable oils. Cobalt oxide is used for the oxidation of ammonia. Cobalt and thorium are used for synthesizing gasoline from coal. All of these are classed as Inorganic catalysts. Sometimes more complex chemicals are employed, silicate of soda being used as a catalyst for high-octane gasoline. In the use of Potassium persulphate,  $K_2S_2O_8$ , as a catalyst in the manufacture of some synthetic rubbers, the material releases 5.8% active oxygen, and it is the nascent oxygen that is the catalyst. Aluminum chloride,  $AlCl_3$ , in granular crystals, is used as a catalyst for high-octane gasoline and synthetic rubber, and in the synthesis of dyes and pharmaceuticals. Aluminosilicates are used in fluid catalyst cracking of gasoline. They bear a negative charge even at high temperatures. Bead catalysts of activated alumina have the alumina contained in 3-mm beads of silica gel. Catasil is alumina adsorbed on silica gel, used for polymerization reactions. Sunlight or ultraviolet rays are also used as catalysts in some reactions. For example, chlorine and hydrogen combine very slowly in the dark, but combine with great violence when a ray of sunlight is turned on. Biologic catalysts are the Enzymes, which are Organic catalysts that are a form of life. They are sensitive to heat and light and are destroyed at  $100^\circ C$ . Enzymes are soluble in water, glycerin, or dilute saline solutions, and water must always be present for enzyme action. Their action may be stimulated or checked by other substances. Enzymes have various actions. Diastase, found in the seeds of barley and other grains, converts starch to maltose and dextrin. Cytase, found in seeds and fruits, decomposes cellulose to

galactose and mannose. Zymose, found in yeast, hydrolyzes glucose to alcohol. M-ten, of the Petajan Co., used for tenderizing meats, is an enzyme in powder form which breaks down the tough connective tissues of the meat. Rhozyme LA, of the Rohm & Haas Co., is a diastatic enzyme concentrate in liquid form for desizing textiles.

**Catechu.** An extract obtained from the heartwood and from the seed pods of the tree *Acacia catechu* of southern Asia. It is used in tanning leather, and also as a dyestuff, giving brown, drab, and khaki colors. It is also used in medicine as an astringent for diarrhea and hemorrhage. The name is also sometimes applied to gambier, which also contains catechu tannin,  $C_{15}H_8(OH)_5$ . Catechu, or Cutch, comes either as a liquid which is a water solution, or as brownish, brittle, glossy cakes. The liquid contains 25% tannin, and the solid 50%. A ton of heartwood yields, by hot-water extraction, 250 to 300 lb of solid cutch extract. It is a powerful astringent. When used alone as a tanning agent, the leather is not of high quality, being of a dark color, spongy, and water-absorbent. It is normally employed in mixtures. Burma cutch is from the *A. catechuoides*. Indian cutch is from the *A. sundra*. The latter is frequently adulterated with starch, sand, and other materials. Wattle is an extract from Australian and East African acacia, *A. dealbata*, and other species. The wattle tree is called Mimosa in Kenya. Wattle bark contains 40 to 50% tannin. It gives a firm pinkish leather and is employed for sole leathers. The solid extract contains 65% tannin. Golden wattle, used for tanning in New Zealand, is the tree *A. pycnantha*. Much wattle extract is produced in Rio Grande do Sul, Brazil, from the Black wattle. Turwar bark, or Avarem, used in India for tanning cattle hides, is from the tree *Cassia auricula*, and is similar to wattle.

**Catgut.** String made from the intestines of sheep, used for violin strings, and for tough, durable cords for rackets and other articles. After cleansing and soaking in an alkali solution, the intestines are split, drawn through holes in a plate, cured in sulphur or other material, and graded according to size. Sheep intestines are also used for making surgical sutures, but for this purpose they are not called catgut, but simply Gut. In the meat-packing industry the intestines of sheep and goats are referred to as Casings and are employed as the covering of sausage and other meat products. They are exported from



Australia, New Zealand, Argentina, Chile, and some other countries in vast quantities, and are graded by diameter, freedom from holes, strength, color, and odor. Intestines of hogs and beef cattle are also used as sausage casings, but they are not as tender and edible as those from sheep.

**Cedar.** A general name that includes a great variety of woods. The true cedars comprise trees of the natural order of *Coniferae*, genus *Cedrus*, of which there are three species: Lebanon cedar, *Cedrus libani*; Himalayan cedar, *C. deodora*; and Atlas cedar, *C. atlantica*. The differences are slight, and all of the species are sometimes classed as *C. libani*. The Himalayan cedar is also known as Deodar. All are mountain trees, and are native to southern Europe, Asia, and northern Africa. The true cedar is yellow in color, fragrant in odor, takes a beautiful polish, and is very durable. It is used in construction work, and timbers in temples in India more than 400 years old are still in perfect preservation. The wood weighs about 36 lb per cu ft. Numerous species of *Cedrela* occur in tropical America, Asia, and Africa, and are also commonly called cedar, but the wood has greater resemblance to mahogany. In the United States and Canada the name cedar is applied to woods of species of *Thuja*, *Juniperus*, and *Cupressus*, more properly classified as thuya, juniper, and cypress.

Spanish cedar, or Central American cedar, used in the United States as a substitute for mahogany in patternmaking, and for cigar boxes, furniture, carving, cabinetwork, and interior trim, is a soft wood from numerous species of *Cedrela*, called in Spanish America by the name of Cedro. It is a light-red color sometimes beautifully figured with wavy grain, has an agreeable odor, is easily worked, seasons well, and takes a fine polish. The weight is 28 to 33 lb per cu ft. The trees grow to a large size, logs being available 40 in. square. The imports come chiefly from Central America and the West Indies, but the trees grow as far south as northern Argentina. Paraguayan cedar is the wood of the tree *C. braziliensis*, of Paraguay, Brazil, and northern Argentina, employed locally for cabinetwork, car building, and interior building work. It is similar in appearance to Spanish cedar but is denser, harder, and redder in color. The wood known as Southern white cedar, and called juniper in the Carolinas, is from the tree *Chamaecyparis thyoides*, growing in the coastal

belt from Maine to Florida. The heartwood is light brown tinged with pink, and the thin sapwood is lighter in color. The wood is light in weight, straight-grained, durable, and fragrant. The more plentiful White cedar of the West Coast, known also as Port Orford cedar, Oregon cedar, Ginger pine, and in England as Lawson cypress, is from the tree *C. lawsoniana* of California and Oregon, mostly from a narrow coastal strip in Oregon to an altitude of about 5,000 ft. Mature trees reach a height of 160 ft and a diameter of 6 ft. The wood is white with a yellow tinge and trace of red. It is rather hard, tough, with a fine straight grain, and is very durable. It has an agreeable aromatic odor, and is free from pitch. The wood is used for doors, sash, boats, matches, patterns, and where a light, strong, straight-grained wood is required.

**Cellulose.** The main constituent of the structure of plants, which, when extracted, is employed for making paper, plastics, and in many combinations. Cellulose is made up of long-chain molecules in which the complex unit  $C_6H_{10}O_5$  is repeated as many as 2,000 times. It consists of glucose molecules with three hydroxy groups for each glucose unit. Cellulose itself is a white amorphous powder insoluble in water, sodium hydroxide, or in alcohol, but dissolved by sulphuric acid. The highly refined insoluble cellulose with all the sugars, pectin, and other soluble matter removed is called Alpha cellulose. The simplest form of cellulose used industrially is Regenerated cellulose, in which the chemical composition of the finished product is similar to that of the original cellulose. It is made from wood or cotton pulp digested in a caustic solution to which carbon bisulphide or other chemical is added to digest the fibers. The viscous liquid is forced through a slit into an acid bath to form a thin sheet, which is then purified and bleached. Cellophane, of E. I. du Pont de Nemours & Co., Inc., is a regenerated cellulose used in the form of thin sheets for wrapping. It is used transparent, or is dyed in colors or embossed. The thinnest sheets, 0.00088 in. in thickness, have 21,500 sq in. per lb. The waterproofed material is coated with a thin film of cellulose nitrate lacquer.

Purocell, of the Eastern Corp., is a highly purified and bleached cellulose produced from wood pulp and used for making high-grade writing papers. Barcote, of the Foote Mineral Co., is a nearly pure

cellulose used in plastics or for carbonizing. It is a buff-colored, odorless powder or granular material with residual ash content of 1.6%. Some cellulose is obtained from potatoes as a by-product in the production of starch. It is pure white and is used in plastics. Water-soluble cellulose, or Cellulose gum, used as a substitute for gum arabic and carob-bean flour as a stabilizer, thickener, or emulsifier, is Sodium cellulose glycollate in powder form. It is made by the action of monochloroacetic acid on alkali cellulose. It is also used to increase the effectiveness of detergents. Collocel S, of the Dow Chemical Co., and CMC, or Carboxy methyl cellulose, of the Hercules Powder Co., are similar materials. Collocel A is aluminum cellulose glycollate, a water-insoluble brownish powder used for water-proofing paper. Ceglin, of the Sylvania Corp., is an alkali-soluble Cellulose ether, marketed as a white fibrous powder. When dissolved in a water solution of caustic soda, it forms a viscous liquid used for sizing textiles. Sodium cellulose sulphate is a water-soluble granular powder used as a thickener in emulsion paints, foods, and cosmetics, and for sizing paper and textiles. It produces a clear, tough, grease-proof coating. It is the sodium salt of cellulose acid sulphate produced by sulphuric acid treatment of cellulose fibers, with the sulphate groups in ester-type linkages on the cellulose chain.

Ethyl cellulose is a colorless, odorless ester of cellulose resulting from the reaction of ethyl chloride and cellulose. The specific gravity is 1.07 to 1.18. It is noninflammable, very flexible, stable to light, and forms durable alkali-resistant coatings. It is used as a thin wrapping material, for protective coatings, as a hardening agent in resins and waxes, and for molding plastics. Ethyl cellulose plastics are thermoplastic and are noted for their ease of molding, light weight, and good dielectric strength, 400 to 520 volts per mil. But they are softer and lower in strength than cellulose-acetate plastics. Lumarith EC, of the Celanese Corp., is ethyl cellulose in the form of sheets, films, and molding powder. Celcon is a name applied by this company to ethyl cellulose plastics.

Ethocel is ethyl cellulose of the Dow Chemical Co., and Stripcoat is a solution of ethyl cellulose used for dipping automotive and aircraft replacement parts or other metal products to form a thin, water-proof protective coating to prevent corrosion. The coating strips off easily when the part is to be used. The same material is marketed by

a number of other companies for the same purpose under a variety of trade names. Methyl cellulose is a white, granular, flaky material, which is a strong emulsifying agent, and is used in soaps, floor waxes, shoe cleaners, in emulsions of starches, glues, waxes, and fats, and as a substitute for gum arabic in pharmaceuticals. It gives colorless, odorless solutions resistant to fermentation. It dissolves in cold water, but is stable to alkalis and dilute acids. In soaps it lowers the surface tension of the water and aids lathering. It is also used for tree-wound dressings, and as a moisture-conserving soil conditioner. Methocel, of the Dow Chemical Co., is this material. Colloresin, of the General Drug Co., is methyl cellulose used to replace natural gums in pharmaceuticals.

**Cellulose acetate.** An amber-colored, transparent material made by the reaction of cellulose with acetic acid or acetic anhydride in the presence of sulphuric acid. In Germany it was made by treating beechwood pulp with acetic acid in the presence of an excess of zinc chloride. It is employed for lacquers and coatings, molding plastics, rayon, and photographic film. Cellulose acetate may be the triacetate,  $C_6H_7O_2(OOCCH_3)_3$ , but may be the tetracetate or the pentacetate, or mixtures. It is made in different degrees of acetylation with varying properties. Unlike nitrocellulose, it is not flammable, and it has better light and heat stability. It has a refractive index of 1.47 to 1.50, and a sheet  $\frac{1}{8}$  in. thick will transmit 90% of the light. The specific gravity is 1.27 to 1.37, hardness 8 to 15 Brinell, tensile strength 3,500 to 8,000 psi, compressive strength up to 20,000 psi, elongation 15 to 80%, dielectric strength 300 to 600 volts per mil, and softening point 122 to 205°F. It is thermoplastic, and is easily molded. The molded parts or sheets are tough, easily machined, and resistant to oils and to many chemicals. In coatings and lacquers the material is adhesive, tough, and resilient, and does not discolor easily. In fiber form for rayons it can be made in fine filaments that are strong and flexible, nonflammable, mildewproof, and easily dyed. Standard cellulose acetate for molding is marketed in flake form. The high acetyl type of the Hercules Powder Co. contains 56 to 58.5% combined acetic acid, and it makes plastics of high dimensional stability. Cellulose triacetate, with 60 to 61.5% combined acetic acid, is more insoluble, has higher dielectric strength, and is

more resistant to heat and light than other types. It is cast into sheets, and is also used for resistant coatings.

Lumarith is a cellulose acetate of the Celanese Corp. in the form of rods, sheets, tubes, and molding powder. Lumarith X is a high acetyl cellulose acetate for molding. The tensile strength is up to 8,000 psi, and Brinell hardness up to 12.5. Vuelite, of the Monsanto Chemical Co., is transparent cellulose acetate for fluorescent light fixtures and for shatterproof glass. A heavily pigmented cellulose-acetate sheet is used in England for aircraft covering under the name of Rhodoid. Cellomold is a cellulose-acetate molding powder of F. A. Hughes & Co., Ltd., and Celastoid is an extrusion acetate of the British Celanese, Ltd. Tenite is a cellulose-acetate molding material of the Tennessee Eastman Corp. Estron is a name adopted by this company to designate cellulose ester yarns and staple fiber. Protectoid is Lumarith in the form of noninflammable motion-picture film. Masuron, of John W. Masury & Son, Nixonite, of the Nixon Nitration Works, and Plastacele, of E. I. du Pont de Nemours & Co., Inc., are cellulose-acetate materials. Acele, of the latter company, is a name for acetate yarns. Kodapak, of the Eastman Kodak Co., is a transparent cellulose-acetate sheet material for packaging. Celanese is the name of cellulose-acetate yarns and fabrics of the Celanese Corp. of America. Celairese, of this company, is a fluffy acetate fiber used for interlinings. Lanese is a fine fluffy acetate fiber used to blend with wool for blankets and rugs. Fortisan, of the same company, is a specially processed strong acetate fiber of extreme fineness, 0.0001 in. diameter, originally developed for parachutes but now also used for fine fabrics. Forticel, of this company, is a cellulose propionate plastic for injection molding. It has a flow point at 161°C, has high impact resistance, and requires less plasticizer than cellulose acetate.

Cellulose-acetate lacquers are sold under many trade names. They are solutions of acetate in alcohols with plasticizers and pigments. Vimlite, of the Celanese Corp., is a Saran screen filled with a cellulose-acetate film. It transmits the ultraviolet rays of sunshine, and is used for glazing greenhouses and farm buildings. Miramesh, of the National Research Corp., is this material with one side coated with a thin film of aluminum. It is used for light diffusers and radiant heat reflectors. Cellulose-acetate butyrate is made by the esterification of cellulose with acetic acid and butyric acid in the presence of a catalyst.

It has the same appearance and approximately the same range of properties as cellulose acetate, but can be used with less plasticizers, has less water absorption, and is more stable to heat and light. It is particularly valued for coatings, insulating tapes, varnishes and lacquers, and electrical parts. Tenite II is this material. Tenite III is Cellulose-acetate propionate for extrusion moldings of high impact strength. Hercose C, of the Hercules Powder Co., is cellulose-acetate butyrate used for cable coverings and airplane coatings. It is more soluble than cellulose acetate and more miscible with gums. It forms durable and flexible films.

**Cellulose nitrate plastics.** Materials made by treating cellulose with a mixture of nitric and sulphuric acids, washing free of acid, bleaching, stabilizing, and dehydrating. For sheets, rods, and tubes, it is mixed with plasticizers and pigments and rolled or drawn to the shape desired. The cellulose molecule will unite with from 1 to 6 molecules of nitric acid. The lower nitrates are very inflammable, but they do not explode like the high nitrates, and they are the ones used for plastics, rayons, and lacquers. The names Cellulose nitrate and Pyroxylin are used for the compounds of lower nitration, and the term Nitrocellulose is used for the explosives. Collodion is a name given to the original solution of cellulose nitrate in a mixture of 60% ether and 40 alcohol for making fibers and film, and the name is still retained in pharmacy. The name Soluble cotton is used to designate batches of cellulose nitrate wet with alcohol for storing for the production of lacquers.

Cellulose nitrate was first used as a plastic in England in 1855 under the name Parkesine. It consisted of nitrocellulose mixed with camphor and castor oil for hardening and making it nonexplosive. Later, in 1868, an improved cellulose nitrate and camphor plastic was called Celluloid, now the trade name of the Celanese Corp. of America for cellulose nitrate plastics. Xylonite was the name used in England for the nitrocellulose hardened with camphor made by Daniel Spill in 1868. The name is still used by the British Xylonite Co. for cellulose nitrate plastics. Cellulose nitrate is the toughest of the thermoplastics. It has a specific gravity of 1.35 to 1.45, tensile strength of 6,000 to 7,500 psi, elongation 30 to 50%, compressive strength 20,000 to 30,000 psi, Brinell hardness 8 to 11,

and dielectric strength 250 to 550 volts per mil. The softening point is 160°F, and it is easy to mold and easy to machine. It also is readily dyed to any color. It is not as light-stable as cellulose acetate, and is therefore no longer used for laminated glass. It is resistant to many chemicals, but has the disadvantage that it is inflammable. The molding is limited to pressing from flat shapes. It burns with a smoky flame, and the fumes are poisonous. Methyl or amyl alcohols are the usual solvents for the material, and various plasticizers are used, some of which aid in reducing the flammability. Camphor is the usual hardener and plasticizer, from 24 to 30% being the usual amount. Cellulose nitrate plastics in rod, sheet, and tube forms are marketed under trade names. Some of these are Pyralin and Viscoloid of E. I. du Pont de Nemours & Co., Inc.; Nitron, of the Monsanto Chemical Co.; Nixonoid, of the Nixon Nitration Works; Amarith, of the Celanese Corp. of America; and Fiberloid, of the Fiberloid Corp. Cellulose nitrate lacquers, which are solutions with pigments and plasticizers, are quick drying on evaporation of the solvent, and they give good adhesive films that are tough, flexible, and resistant. They are sold under many trade names such as Duco, Zapon, and Arcozon.

**Cement.** A material generally in powder form, that can be made into a paste usually by the addition of water and, when molded or poured, will set into a solid mass. Numerous organic compounds used for adhering, or fastening materials, are called cements, but these are classified as adhesives, and the term cement alone means a construction material. The most widely used of the construction cements is Portland cement. It is a bluish-gray powder obtained by finely grinding the clinker made by heating strongly an intimate mixture of calcareous and argillaceous minerals. The chief raw material is a mixture of high-calcium limestone, known as Cement rock, and clay or shale. Blast-furnace slag may also be used in some cements. American specifications call for five types of portland cement. Type I, for general concrete construction, has a typical analysis of 63.2% CaO, 21.3 SiO<sub>2</sub>, 6 Al<sub>2</sub>O<sub>3</sub>, 2.7 Fe<sub>2</sub>O<sub>3</sub>, 2.9 MgO, 1.8 SO<sub>3</sub>. Type III, for use where high early strength is required, has 64.3% CaO, 20.4 SiO<sub>2</sub>, 5.9 Al<sub>2</sub>O<sub>3</sub>, 3.1 Fe<sub>2</sub>O<sub>3</sub>, 2 MgO, 2.3 SO<sub>3</sub>. The color of the cement is due chiefly to iron oxide. In the absence of impurities the color

would be white, but neither the color nor the specific gravity is a test of quality. The specific gravity is at least 3.10. Good cement is always ground fine, with 98.5% passing a 200-mesh screen. Non-staining cements are those free from perceptible amounts of iron oxide.

White cement is from pure calcite limestone, such as that found in eastern Pennsylvania. It is ground finer and used for a better class of work, but the physical properties are similar to those of ordinary cement. A typical analysis of white cement is: 65%  $\text{CaO}$ , 25.5  $\text{SiO}_2$ , 5.9  $\text{Al}_2\text{O}_3$ , 0.6  $\text{Fe}_2\text{O}_3$ , 1.1  $\text{MgO}$ , 0.1  $\text{SO}_3$ . The White cements of France and England are made from the chalky limestones, and have superior working qualities, as they are usually ground finer. Aluminous cement, or Aluminate cement, sometimes referred to as High-speed cement, will set to high strength in 24 hr, and is thus valued for laying roads or bank walls. It is made with bauxite, and contains a high percentage of alumina. A typical analysis is: 39.8%  $\text{Al}_2\text{O}_3$ , 33.5  $\text{CaO}$ , 14.6  $\text{Fe}_2\text{O}_3$ , 5.3  $\text{SiO}_2$ , 1.3  $\text{MgO}$ , 0.1  $\text{SO}_3$ . Lumnite cement, of the Universal-Atlas Cement Co., is a cement of this type. Accelerated cements are intermediate cements that will set hard in about 3 days. The raw mixture for making portland cement is controlled to give exact proportions in the final product, and some quartz or iron ore may be added to balance the mix. The temperature of the rotary kiln is raised gradually to about 2650°F. The burned clinker is then ground with a small amount of gypsum which controls the set. Cement is marketed in paper bags of 94 lb, and in barrels of 376 lb.

The amount of portland cement used in the United States exceeds 200 million tons annually. But a number of other construction cements not classed as portland cement are also used. Natural cement is made by heating to complete decarbonation, but not fusion, a highly argillaceous soft limestone. This is the most ancient of the manufactured cements, and is still called Roman cement. It is low in cost and will set more quickly than portland cement, but is softer and weaker. It is sometimes called Hydraulic lime. When used for laying brick and stone it is called Masonry cement, but ordinary Mortar for laying brick is not this product, but is slaked lime and sand. Cement mortar is made with portland cement, sand, and water, with sometimes lime to aid spreading.

Oxychloride cement, or Sorel cement, is composed of Magnesium



chloride,  $\text{MgCl}_2$ , and calcined magnesia. It is strong and hard, and, with various fillers it is used for floors and stucco. Magnesia cement is Magnesium oxide,  $\text{MgO}$ , prepared by heating the chloride or carbonate to redness. When mixed with water it sets to a friable mass but of sufficient strength for covering steam pipes or furnaces. It is usually mixed with asbestos fibers to give strength and added heat resistance. The term 85% magnesia means 85% magnesia cement and 15 asbestos fibers. The cement will withstand temperatures up to  $600^\circ\text{F}$ .

Keene's cement, also known as Flooring cement and Tiling plaster, is a Gypsum cement. It is made by burning gypsum at about  $1100^\circ\text{F}$ , to drive off the chemically combined water, grinding to a fine powder, and adding alum to accelerate the set. It will keep better than ordinary gypsum cement, has high strength, is white in color, and takes a good polish. Parian cement is similar, except that borax is used instead of alum. Martin's cement is made with potassium carbonate instead of alum. These cements are also called Hard-finish plaster, and they will set very hard and white. They are used for flooring and to imitate tiling. An ancient natural cement is Pozzuolana cement. It is a volcanic material found near Pozzuoli, Italy, and in several other places in Europe. It is a volcanic lava modified by steam or gases so that it is powdery and has acquired hydraulic properties. The chief components are silica and alumina, and the color varies greatly, being white, yellow, brown, or black. It has been employed as a construction cement since ancient times. Trass is a similar material found in the Rhine district of Germany. Santorin is a light-gray volcanic ash with somewhat similar characteristics from the Greek island of Santorin. Artificial pozzuolana cements and trass cements are made in the United States by intergrinding pumicite, tufa, or shale with portland cement. Slag cement is made by grinding blast-furnace slag with portland cement.

**Ceramic clays.** Clays used for making pottery, tiles, brick, and pipes, but more particularly the better grade of clays for pottery and molded articles not including the fireclays and fine porcelain clays. Clay is a general name for all earths that form a paste with water and harden when heated. The U.S. Department of Agriculture distinguishes clay as having small grains, less than  $0.002\text{ mm}$  in diam-

eter, as distinct from Silt with grains from 0.002 to 0.05 mm. Most clays are composed chiefly of silica and alumina. Kaolins are the purest forms of clay. The clayey mineral in all clays is kaolinite, or minerals closely allied, as Anauxite,  $\text{Al}_2\text{O}_3 \cdot 3\text{SiO}_2 \cdot 2\text{H}_2\text{O}$ , and Montmorillonite,  $\text{Al}_2\text{O}_3 \cdot 4\text{SiO}_2 \cdot 2\text{H}_2\text{O}$ , the latter serving to increase the bond strength of ceramic clays. When the aluminum silicates are in colloidal form, the material is theoretically true clay, or Clayite. Some clays, however, derive much of their plasticity from colloids of organic material, and since all clays are of secondary origin from the weathering or decomposition of rocks, they may vary greatly in composition. Hardness of the clay depends upon the texture as well as on the cohesion of the particles. Plasticity involves the ability of the clay to be molded when wet, to retain its shape when dry, and to have the strength to withstand handling in the green or unfired condition. The degrees of plasticity are called fat, rich, rubbery, and waxy, or the clays may be termed very plastic, which is waxy, sticky plastic, medium plastic, and lean, which is nonplastic. Clays that require a large amount of water for plasticity tend to warp when dried. Those that are not easily worked may be made plastic by Ceramic binders such as alkaline starch solutions, ammonium alginate, or lignin. For making pressed or cast whiteware methyl cellulose is used as a binder for the clay. It gives good binding strength, and it fires out of the ceramic with an ash residue of only 0.5%.

Clays with as much as 1% iron burn red, and titanium increases this color. Yellow ochres contain iron as a free hydrate. Most clays contain quartz sand and sometimes powdered mica. Calcareous clays are known as Marls. Pyrites burn to holes in the brick bordered by a ring of magnetic iron oxide, and a clay should be free of this mineral. Limestone grains in the clay burn to free lime which later slakes and splits the ceramic. Most of the common brick clays are complex mixed earths likely to have much undesirable matter that makes them unsuitable for good tile, pipe, or pottery. The Kingsley clay of Georgia, used for art ware, wall tile, dishes, and refractories, has only 0.4% iron oxide, 0.15  $\text{Na}_2\text{O}$ , 0.1  $\text{K}_2\text{O}$ , and 0.05  $\text{CaO}$ . It contains about 45% silica, 40 alumina, and 1.15 titanium oxide. The famous Seito ware of Japan is made with the Gaerome clay found near Nagoya. It is a granite with quartz particles, and when used with a high percentage of zirconium oxide produces ceramics of

close density and brilliant whiteness. The Alumina clay of western Idaho contains on a dry basis 28.7% alumina, 5.6 iron oxide, and a high percentage of titania.

In firing clays, the moisture is driven off when the temperature is raised from 100 to 150°C, and the chemically combined water is lost at 400 to 700°C. Incipient fusion ranges from 900 to 1200°C, at which point the fluxes begin to be viscous. Common brick is usually finished at this point. Above this temperature the pores are filled with vitreous semimolten material, and the ware will cool to a vitreous luster. Stoneware and paving brick are fired to this condition. At higher temperatures the clay body fuses. Chemical stoneware may range from 30 to 70% clay, 5 to 25 feldspar, and 30 to 60 silica. The vitrified and glazed product will have a tensile strength up to 2,500 psi and a compressive strength up to 80,000 psi. Clinker brick is fired to the fusion point. Bright and true colors are obtained when the wares are muffled during the firing to prevent oxidation of the impurities. Industrial stoneware is made from specially selected or blended clays to give desired properties, and these may be marketed under trade names. Ceratherm, of the United States Stoneware Co., is an acid-resistant and heat-shock-resistant ceramic produced from high-alumina clay. It is strong and nonporous and is used for pump and chemical equipment linings. The chemical stoneware of the General Ceramics & Steatite Corp., made with a mullite-zircon body, are very white, dense, strong, and thermal-shock-resistant. The ceramic marketed under the name of Prestite by the Westinghouse Electric Corp. for insulators and molded electrical parts is blended of flint, feldspar, kaolin, and ball clay. It is nonporous and moisture-proof without a glaze, has high dielectric strength, a tensile strength of 5,000 psi, and a compressive strength of 48,000 psi. The ceramic produced by the Rostone Corp. under the name of Rosite, for molded electrical parts and panels, is a calcium-aluminum-silicate mixed with asbestos. It will withstand temperatures to 900°F, is resistant to alkalis, and has a compressive strength up to 15,000 psi.

**Cerargyrite.** An ore of the metal silver, found in the upper zone of silver veins in Nevada, Colorado, Idaho, Peru, Chile, and Mexico. It is sometimes called Horn silver, owing to its hornlike appearance. It is a Silver chloride,  $\text{AgCl}$ , containing theoretically 75.3% silver,

with sometimes some mercury. The hardness is 2.3 and specific gravity 5.8. It is usually massive, resembling wax, with a pearl-gray color.

**Cerium metals.** A group of metallic elements that occur together and have been called Rare-earth metals, or Rare earths, because of the great difficulty of extracting them rather than because of their rarity. They include cerium, thorium, lanthanum, ytterbium, yttrium, praseodymium, and neodymium. Thorium is separated out by a relatively easy process, and the others remain grouped as the cerium metals, except as some are separated out in compounds for special uses. Cerium, symbol Ce, has an iron-gray color, is only slightly harder than lead, is malleable, has a specific gravity of 6.92, and melts at 623°C. The chief source of cerium is monazite sand. After extraction of the thorium oxide from the monazite the residual matter is reduced by converting the oxides to chlorides and then removing the metals by electrolysis. The product obtained is an alloy containing about 50% cerium together with lanthanum, didymium, and the other rare metals. It is usually called Misch metal, the German name for mixed metal, and its original use was for making pyrophoric alloys. Cerium standard alloy of the Cerium Metals Corp. is a misch metal containing 50 to 55% cerium, 22 to 25 lanthanum, 15 to 17 neodymium, and the balance a mixture of yttrium, terbium, illinium, praseodymium, and samarium, with 0.5 to 0.8% iron. Cerium metal in lump form has 91% min cerium. Misch metal is used in making aluminum alloys, and in some steels and irons. In cast iron it opposes graphitization, and produces a malleableized iron. It removes the sulphur and the oxides, and completely degasifies steel. In stainless steel it is used as a precipitation hardening agent.

Ceria, or Ceric oxide,  $\text{CeO}_2$ , is a pale-yellow heavy powder of specific gravity 7.65, used in coloring ceramics and glass. Cerious oxide,  $\text{Ce}_2\text{O}_3$ , is a greenish powder of specific gravity 7.0, and refractive index 2.19. About 3% of the oxide in glass makes the glass completely absorbent to ultraviolet rays. It is also an excellent opacifier for ceramics. Cerium fluoride is used in arc carbons to increase brilliance. Cerious nitrate,  $\text{Ce}(\text{NO}_3)_3 \cdot 6\text{H}_2\text{O}$ , is a red crystalline powder used in gas-mantle manufacture. Cerium salts are used for coloring glass. Ceric titanate gives a golden-yellow color,

and Ceric molybdate gives a blue color. Neodymium is used in some glasses to reduce glare. Praseodymium, together with neodymium, is used under the name of Didymium. The mixture gives glass a neutral gray color. Lanthanum, symbol La, is a white metal, malleable and ductile, with a specific gravity of 6.15 and a melting point of  $810^{\circ}\text{C}$ . Like the other rare-earth metals, it oxidizes easily in the air and is easily soluble in acids. It can be separated out by electrolysis, but has no separate uses as a metal. Lanthanum oxide,  $\text{La}_2\text{O}_3$ , is a white powder used in gas mantles and for absorbing gases in vacuum tubes. Ytterbium, symbol Yb, is obtained only in the form of its salts. Yttrium, symbol Yt, is obtained as a metal only with great difficulty. It is a dark-gray powder with a specific gravity of 3.8, melting at  $1250^{\circ}\text{C}$ . It decomposes water. These two metals were discovered first in the mineral Gadolinite with other earth metals, but this mineral is too rare for commercial production, or for separation of the metals Gadolinium, Terbium, and Europium which occur in it. Europium salts are used in phosphors for making infra-red rays visible. Yttrium also occurs in the scarce mineral Nuevite found in California. The mineral also carries titanium, tantalum, iron, and quartz, and is similar to the Keilhauite found in Norway. Fergusonite, a brown mineral with a vitreous fracture, found sparsely in the Appalachian hills from New England to South Carolina, is a columbate and tantalate of yttrium with cerium, erbium, and uranium. In Europe it is known as Bragite and Tyrite. The mineral known as Bastnasite in California is a fluorocarbonate of cerium and lanthanum.

**Cesium.** Also spelled Caesium. A rare metal, symbol Cs, obtained from the mineral Pollucite,  $2\text{Cs}_2\text{O} \cdot 2\text{Al}_2\text{O}_3 \cdot 9\text{SiO}_2 \cdot \text{H}_2\text{O}$ . The metal resembles rubidium and potassium, is silvery white and very soft. It oxidizes easily in the air and ignites at ordinary temperatures. It decomposes water with explosive violence. It can be kept only in a vacuum. The specific gravity is 1.903, melting point  $28.5^{\circ}\text{C}$ , and boiling point  $670^{\circ}\text{C}$ . It is used in low-voltage tubes to scavenge the last traces of air. In the form of Cesium chloride,  $\text{CsCl}$ , it is used on the filament of radio tubes to increase sensitivity. It interacts with the thorium of the filament to produce positive ions. In photoelectric cells cesium chloride is used for a photosensitive deposit on the cathode, since cesium releases electrons under the action of ordinary

visible light, and its color sensitivity is higher than that of other alkali metals. The high-voltage rectifying vacuum tube of the General Electric Co. for changing alternating current to direct current has cesium metal coated on the nickel cathode, and has cesium vapor for current carrying. The cesium metal gives off a copious flow of electrons and is continuously renewed from the vapor. Cesium vapor is also used in the infrared signaling lamp, or photophone, as it gives infrared waves without visible light.

**Chalk.** A fine-grained limestone, or a soft, earthy form of Calcium carbonate,  $\text{CaCO}_3$ , composed of finely pulverized marine shells. The natural chalk comes largely from the southern coast of England and the north of France, but high-calcium marbles and limestones are the sources of most of the American chalk and precipitated calcium carbonate. Chalk is employed in putty, crayons, paints, rubber goods, linoleum, calcimine, and as a mild abrasive in polishes. Whiting and Paris white are names given to grades of chalk that have been ground and washed for use in paints, inks, and putty. French chalk is a high grade of massive talc cut to shape and used for marking. The color of chalk should be white, but it may be colored gray or yellowish by impurities. The commercial grades depend on the purity, color, and fineness of the grains. The specific gravity may be as low as 1.8. Finely ground calcium carbonate is marketed under trade names. Luneolith is precipitated calcium carbonate of the Kansas City Limeolith Co., used for paints, rubber, glass, and cosmetics. Suspenso, of the Diamond Alkali Co., is a very white, grit-free precipitated calcium carbonate for paints. Calcene, of the Columbia Chemical Div., Pittsburgh Plate Glass Co., is a precipitated calcium carbonate of fine particle size used as a pigment and to add strength and tear resistance to rubber. Kalvan, of R. T. Vanderbilt Co., Inc., is a similar material.

**Chamois.** A soft, pliable leather originally made from the skins of the chamois, *Antilopa rupicapra*, a small deer inhabiting the mountains of Europe but now nearly extinct. The leather was of a light-tan color, with a soft nap. All commercial chamois is now made from the skins of lamb, sheep, goat, or from the thin portion of split hides. The Federal Trade Commission limited the use of the term chamois to oil-dressed sheepskins mechanically suèded, but there are

no technical precedents for such limitation. The original Artificial chamois was made by tanning sheepskins with formaldehyde or alum, impregnating with oils, and subjecting to mechanical suèding, but chamois is also made by various special tannages with or without suèding. Those treated with fish oils have a distinctive feel. Chamois leather will withstand soaking in hot water and will not harden on drying. It is used for polishing glass and plated metals. Buckskin, a similar pliable leather, but heavier and harder, was originally soft-tanned, oil-treated deerskin, but is now more frequently made from goatskins.

**Charcoal.** An amorphous form of carbon, made by enclosing billets in a retort and exposing them to a red heat for 4 or 5 hr. It is also made by covering large heaps of wood with earth, and permitting them to burn slowly for about a month. Much charcoal is now produced as a by-product in the distillation of wood, a retort charge of 10 cords of wood yielding an average of 2,650 gal of pyroligneous liquor, 11,000 lb of gas, and 6 tons of charcoal. Wood charcoal is used as a fuel, for making black gunpowder, for carbonizing steel, and for making activated charcoal for filtering and absorbent purposes. Gunpowder charcoal is made from alder, willow, or hazel wood. Commercial wood charcoal is usually about 25% of the original weight of the wood, and is not pure carbon. The average composition is 95% carbon and 3 ash. It is an excellent fuel, burning with a glow at low temperatures, and with a pale-blue flame at high temperatures. In the early days it was much used in blast furnaces for melting iron, and it produces a superior iron with less sulphur and phosphorus than when coke is used. Red charcoal is an impure charcoal made at a low temperature, and retaining much oxygen and hydrogen. Charklets is a name for briquettes of charcoal made with a binder and used as a fuel.

**Charcoal iron.** Originally, all iron was made with charcoal, but because of the relative scarcity of wood and the greater expense charcoal is now used in the blast furnace instead of coke to produce iron only for special purposes. It has less phosphorus and sulphur than ordinary pig iron. Cast iron made from charcoal iron has a dense structure and has a tendency to chill. It is used for such purposes as car wheels and magnet cores. Charcoal pig iron is also used for

making high-grade steel for boiler tubes. Charcoal iron is marketed in various grades from 3.25% graphitic carbon and 0.37 combined carbon, to 3.5% combined carbon. Elverite, of the Fuller Lehigh Co., is a charcoal type of cast iron which gives a hard chill, leaving a soft, gray-iron core. Stora is the trade name of Swedish charcoal iron in small notched pigs, used for making malleable iron.

**Chaulmoogra oil.** A brownish semisolid oil from the seeds of the fruit of the tree *Taraktogenos kurzii* and other species of Siam, Assam, and the East Indies. It is used chiefly for skin diseases and for leprosy. A similar oil is also obtained from other genera of bushes and trees of the family *Flacourtiaceae*, and that obtained from some species of *Hydnocarpus* is superior to the true chaulmoogra oil. The tree *H. anthelminthica*, native to Siam, is cultivated in Hawaii. This oil consists mainly of chaulmoogric and hydnocarpic acids. Sapucainha oil, from the seeds of the tree *Carpotroche brasiliensis*, of the Amazon Valley, contains chaulmoogric, hydnocarpic, and gorlic acids, and is a superior oil. Gorlised oil, from the seeds of the tree *Onchoba echinata* of tropical Africa, and cultivated in Costa Rica and Puerto Rico, contains about 80% chaulmoogric acid and 10 gorlic acid. Dilo oil is from the kernels of the nuts of the tree *Calophyllum inophyllum* of the South Sea Islands. In Tahiti it is called Tamanu.

**Cheesecloth.** A thin, coarse-woven cotton fabric of plain weave, 40 to 32 count, and of coarse yarns. It was originally used for wrapping cheese, but is now employed for wrapping, lining, interlining, filtering, as a polishing cloth, and as a backing for lining and wrapping papers. The cloth is not sized, and may be either bleached or unbleached. It comes usually 36 in. in width. The grade known as Beef cloth, originally used for wrapping meats, is also the preferred grade for polishing enameled parts. It is made of No. 22 yarn or finer. For covering meats the packing plants now use a heavily napped knitted fabric known as Stockinett. It is made either as a flat fabric or in seamless tube form, and is also used for covering inking and oiling rolls in machinery. Lighter grades of cheesecloth, with very open weave, known as Gauze, are used for surgical dressings, and for backings for paper and maps. Baling paper is made by coating cheesecloth with asphalt and pasting to one side of heavy kraft or Manila paper. Cable paper, for wrapping cables, is sometimes



made in the same manner but with insulating varnish instead of asphalt.

**Chemical indicators.** Dyestuffs that have one color in acid solutions and a different color in basic or alkaline solutions. They are used to indicate the relative acidity of chemical solutions, as the different materials have different ranges of action on the acidity scale. The materials are mostly weak acids, but some are weak bases. Some are natural dyestuffs, but most are coal-tar derivatives. The best known is litmus, which is red below a pH of 4.5, and blue above a pH of 8.3. It is used to test strong acids or alkalis. Alkanet is another natural dyestuff indicator. Some of the coal-tar indicators are: Malachite green, which is yellow below a pH of 0.5 and green above 1.5; Phenolphthalein, which is colorless below a pH of 8.3 and magenta above 10.0; and Methyl red, which is red below 4.4 and yellow above 6.0. A Universal indicator is a mixture of a number of indicators that gives the whole range of color changes, thereby indicating the entire pH range. But such indicators must be compared with a standard to determine the pH value.

The change in color is caused by just a slight rearrangement of the atoms of the molecule. Some of the indicators, such as Thymol blue, exhibit two color changes at different acidity ranges because of the presence of more than one chromophore arrangement of atoms. These can thus be used to indicate two separate ranges on the pH scale. Test papers are strips of absorbent paper that have been saturated with an indicator and dried. They are used for testing for acidic or basic solutions, and not for accurate determination of acidity range or hydrogen-ion concentration such as is possible with direct use of the indicators. Common test papers are litmus, congo red, sulphide, and starch-iodide.

**Cherry.** The wood of several species of cherry trees native to Europe and the United States. It is brownish to light red in color, darkening on exposure, and has a close, even grain. The weight is about 40 lb per cu ft. It retains its shape well, and takes a fine polish. The annual cut of commercial cherry wood is small, but it is valued for instrument cases, patterns, electrotpe blocks, paneling, and cabinetwork. The American cherry is mostly from the tree *Prunus serotina*, known as the Black cherry, although some is from the tree

*P. emarginata*. The black cherry wood formerly used for airplane propellers has a specific gravity of 0.53 when oven-dried, compressive strength perpendicular to the grain 1,170 psi, and shearing strength parallel to the grain 1,180 psi. This tree is found only thinly scattered through the eastern part of the United States. The wood is light to dark reddish with a beautiful luster and silky sheen, but has less figure than mahogany. English cherry is from the trees *P. cerasus* and *P. avium*.

**Chestnut.** The wood of the tree *Castanea dentata*, once growing plentifully along the Appalachian Range from New Hampshire to Georgia, but now very scarce. The trees grow to a large size, but the wood is inferior to oak in strength though similar in appearance. It is more brittle than oak, has a coarse, open grain often of spiral growth, and splits easily in nailing. The color is light brown or yellowish. It is used for posts, crossties, veneers, and some mill products. Chestnut wood contains from 6 to 20% tannin, which is obtained by soaking the chipped wood in water and evaporating. Chestnut extract is valued for tanning leather, giving a light-colored strong leather. The seed nuts of all varieties of chestnut are used for food and are eaten fresh, boiled, or roasted. The European chestnut, *C. sativa* and *C. vesca*, also called the Spanish chestnut and the Italian chestnut, has large nuts of inferior flavor. The wood is also inferior. The Horse chestnut is a smaller tree, *Aesculus hippocastanum*, grown as a shade tree in Europe and the United States. The nut is round and larger than the chestnut. It is bitter in taste, but is rich in fats and starch and, when the saponin is removed, it produces an edible meal with an almondlike flavor used in confections in Europe. The nuts of the American horse chestnut, Buckeye, or Ohio buckeye, *A. glabra*, and the Yellow buckeye, *A. octandra*, are poisonous. The trees grow in the Central states, and the dense, white wood is used for furniture and artificial limbs.

**Chia-seed oil.** A clear amber-colored oil extracted from the seeds of the plant *Salvia hispanica* of Mexico, and used as a drying oil for paints and varnishes. It has a higher drying value than linseed oil. The seeds yield about 30% oil, which contains 39% linolenic acid, 45 linoleic, 5 palmitic, 2.7 stearic, with some arachidic, oleic, and myristic acids. The specific gravity is 0.936, iodine value 192, and

acid value 1.4. The seeds scatter easily from the pods and are difficult to collect.

**Chicle.** The coagulated latex obtained from incisions in the trunk of the evergreen tree *Acbras zapota* and some other species of southern Mexico, Guatemala, and Honduras. The crude chicle is in reddish-brown pieces, and may have up to 40% impurities. The purified and neutralized gum is an amorphous white to pinkish powder insoluble in water, which forms a sticky mass when heated. The commercial purified gum is molded into blocks of 10 to 12 kilos for shipment. It contains about 40% resin, 17 rubber, and about 17 of sugars and starches. Under the name of Txixtle the coagulated latex was mixed with asphalt and used as a chewing gum by the Aztec Indians, and this custom of chewing gum was widely adopted in the United States. Chicle is used chiefly as a base for chewing gum, sometimes mixed with jelutong.

**Chloride of lime.** A white powder, a Calcium chloride hypochlorite, of the composition  $\text{CaCl}(\text{OCl})$ , having a strong chlorine odor. It decomposes easily in water, and is used as a source of chlorine for cleaning and bleaching. It is produced by passing chlorine gas through slaked lime. Chloride of lime, or Chlorinated lime, is also known as Bleaching powder, although commercial bleaching powder may also be a mixture of calcium chloride and calcium hypochlorite. Perchlaron, of the Pennsylvania Salt Mfg. Co., is Calcium hypochlorite.

**Chlorinated hydrocarbons.** A large group of materials used as solvents for oils and fats, for metal degreasing, dry cleaning of textiles, as refrigerants, in insecticides, and in fire extinguishers. They are hydrocarbons in which hydrogen atoms were replaced by chlorine atoms. They range from the gaseous methyl chloride to the solid Hexachloro ethane,  $\text{CCl}_3\text{CCl}_3$ , with most of them liquid. The increase in the number of chlorine atoms increases the specific gravity, boiling point, and some other properties. They may be divided into four groups: the methane group, including methyl chloride, chloroform, and carbon tetrachloride; the ethylene group, including dichloroethylene; the ethane group, including ethyl chloride and dichloroethane; and the propane group. All of these are toxic, and the fumes

are injurious when breathed or absorbed through the skin. Some decompose in light and heat to form more toxic compounds. Some are very inflammable, while others do not support combustion. In general, they are corrosive to metals, and in their use as refrigerants or in solvent baths the metal equipment must be of corrosion-resistant alloys.

Chloroform, or Trichloromethane, is a liquid of the composition  $\text{CHCl}_3$ , boiling point  $61.2^\circ\text{C}$ , and specific gravity 1.489, used industrially as a solvent for greases and resins, and in medicine as an anesthetic. It decomposes easily in the presence of light to form phosgene, and a small amount of ethyl alcohol is added to prevent decomposition. Ethyl chloride, also known as Monochlorethane, Kelene, and Chelene, is a gas of the composition  $\text{CH}_3\text{CH}_2\text{Cl}$ , used in making ethyl fluid for gasoline, as a local anesthetic in dentistry, as a catalyst in rubber and plastics processing, and as a refrigerant in household refrigerators. It is marketed compressed into cylinders as a colorless liquid. The specific gravity is 0.921, freezing point  $-140.8^\circ\text{C}$ , and boiling point  $12.5^\circ\text{C}$ . The condensing pressure in refrigerators is 12.4 lb at  $6^\circ\text{F}$ , and the pressure of vaporization is 10.1 lb at  $5^\circ\text{F}$ . Its disadvantage as a refrigerant is that it is highly inflammable, and there is no simple test for leaks. Methyl chloride is a gas of the composition  $\text{CH}_3\text{Cl}$ , which is compressed into cylinders as a colorless liquid of boiling point  $-10.65^\circ\text{F}$ , and freezing point  $-144^\circ\text{F}$ . Methyl chloride is one of the simplest and cheapest chemicals for methylation. In water solution it is a good solvent. It is also used as a catalyst in rubber processing, as a restraining gas in high-heat thermometers, and as a refrigerant. Monochloro benzene,  $\text{C}_6\text{H}_5\text{Cl}$ , is a colorless liquid boiling at  $132^\circ\text{C}$ , not soluble in water. It is used as a solvent for lacquers and resins, as a heat-transfer medium, and for making other chemicals. Trichlor cumene, or Isopropyl trichlorobenzene, is valued as a hydraulic fluid and dielectric fluid because of its high dielectric strength, low solubility in water, and resistance to oxidation. It is a colorless liquid,  $(\text{CH}_3)_2\text{CHC}_6\text{H}_2\text{Cl}_3$ , boiling at  $260^\circ\text{C}$ , and freezing at  $-40^\circ\text{C}$ .

**Chlorinated rubber.** An ivory-colored or white powder produced by the reaction of chlorine and rubber. It contains about 65% by weight of rubber, and is represented by the empirical formula

( $C_{10}H_{13}Cl_7$ )<sub>2</sub>. Rubber was first chlorinated in 1846 to improve its aging qualities, but was not marketed until about 75 years later. The first commercial chlorinated rubber was the Duroprene of the United States Alkali Co. Chlorinated rubber is used in acid-resistant and corrosion-resistant paints, in adhesives, and in plastics. The uncompounded film is brittle, and for paints the material is plasticized with gums and synthetics to produce a hard, tough, adhesive coating, resistant to oils, acids, and alkalis. The specific gravity of chlorinated rubber is 1.64, and bulking value 0.0735 gal per lb. The tensile strength of the film is 4,500 psi. It is soluble in hydrocarbons, carbon tetrachloride, and in esters, but insoluble in water. The unplasticized material has a high dielectric strength, up to 2,300 volts per mil. Tornesit and Parlon are chlorinated rubbers of the Hercules Powder Co. Paratex, of the Truscon Laboratories, and Roxaprene, of the Roxalin Flexible Lacquer Co., Inc., are chlorinated-rubber coating materials. Pliofilm, of the Goodyear Tire & Rubber Co., is a rubber hydrochloride made by saturating the rubber molecule with hydrochloric acid. It is made into transparent sheet wrapping material which heat-seals at 105 to 130°C, or is used as a coating material for fabrics and paper. It gives a tough, flexible, water-resistant film. Pliolite, of this company, is a cyclized rubber made by highly chlorinating the rubber. It is used in insulating compounds, adhesives, protective paints, and as a waterproofing agent. It is soluble in hydrocarbons, but is resistant to acids and alkalis. Pliowax is this material compounded with paraffin or ceresin wax. Pliolite S-1 is this material made from synthetic rubber, and makes a highly resistant coating material. Tensolite, of the Tensolite Corp., used to make filaments for filter cloth and braided goods, is a chlorinated natural rubber. Dartex and Alloprene are German chlorinated rubbers. Rulahyde is a Dutch chlorinated rubber made by treating latex with hydrochloric acid. Cyclized rubber is normally made by heating rubber with sulphonyl chloride or with Chlorostannic acid,  $H_2SnCl_6 \cdot 6H_2O$ . It contains a minimum of 92% rubber hydrocarbons, and the rubber molecule is more saturated than in natural rubber. The material is thermoplastic, somewhat similar to gutta percha or balata, and makes an excellent adhesive. Cyclized rubber has a specific gravity of 1.06, softening point 80 to 100°C, molding temperature 125 to 155°C, tensile strength 4,000 to 4,500 psi, flexural strength up to 9,000 psi,

and very low water absorption. It is used in adhesives for bonding rubber to metals, as a stiffening agent for rubber in wire insulation, and for waterproofing paper.

**Chlorine.** An elementary material, symbol Cl, which at ordinary temperatures is a gas,  $\text{Cl}_2$ , but which is marketed in pressure cylinders as a liquid. Its name comes from its greenish-yellow color. It occurs in nature in great abundance in combinations, in such compounds as common salt. It has a powerful suffocating odor, and is strongly corrosive to organic tissues and to metals. During the First World War it was used as a poison gas under the name of Bertholite. An important use for liquid chlorine is for bleaching textiles and paper pulp, but it is also used for the manufacture of many chemicals. For bleaching, it is also widely employed in the form of compounds easily broken up. Chlorine dioxide,  $\text{ClO}_2$ , for example, is a reddish-yellow gas which is more than twice as effective as a bleach than chlorine, but it is unstable and must be made just before use from chlorine and sodium chlorite. Dry chlorine may be used for detinning steel, and the recovered product, Tin tetrachloride, is used for weighting silk. Chlorine may be made by the electrolysis of common salt. The specific gravity of the gas is 3.214, or 2.486 times heavier than air. The boiling point is  $-33.6^\circ\text{C}$ , and the gas becomes liquid at atmospheric pressure at a temperature of  $-24.48^\circ\text{F}$ . The liquid chlorine is shipped in steel cylinders of 10- to 150-lb capacity. The vapor pressure ranges from 39.4 lb at  $0^\circ\text{C}$  to 602.4 lb at  $100^\circ\text{C}$ . The gas is an irritant and not a cumulative poison, but breathing large amounts destroys the tissues.

**Chrome-molybdenum steel.** Any alloy steel containing chromium and molybdenum as the predominating alloying elements. Chromium gives hardness and toughness to the steel, while molybdenum improves the forging and machining properties and increases the strength. Chrome-molybdenum steels are noted for high strength and toughness. Only small amounts of alloying elements are used in the standard steels. A chrome-molybdenum steel used in the form of airplane tubing, Army-Navy steel AN-T-69, contains 0.80 to 1.10% chromium, 0.15 to 0.25 molybdenum, 0.40 to 0.60 manganese, and 0.25 to 0.35 carbon. It has a tensile strength of 95,000 psi min, with elongation 10%, and is slightly air-hardening. It draws well, and

tubes with a wall thickness of only 0.035 in. are made. Molybdenum adds red hardness to steel to a greater degree than tungsten, and the amounts used in these steels is sufficient to make them slightly red-hard and air-hardening. SAE steel 4140, which has the same composition as the airplane tubing but with 0.40% carbon, has a tensile strength up to 260,000 psi, elongation 8%, and Brinell hardness 490 when oil-quenched and drawn. This type of steel, with 0.30% carbon, AISI steel 4130, is used for structural parts where welding is to be done. The chrome-molybdenum steels marketed by the Crucible Steel Co. under the name of Almo steel for airplane, automotive, and ordnance work, have tensile strengths up to 167,000 psi, with elongation 18%. A steel used for superheater tubes at 900 lb pressure and 925°F, contains 5% chromium and 0.50 molybdenum. Chrome-molybdenum steels, with high carbon, have great resistance to wear at high heat, and are used for die blocks for forging. Cromo steel, of the Michigan Steel Casting Co., is a cast steel with a tensile strength of 100,000 psi and elongation 15 to 25%, used for large die blocks. Albor die steel, of Wm. Jessop & Sons, Inc., used for dies for stamping hard metals, contains 0.90% chromium, 0.30 molybdenum, and 0.90 carbon. It is tough and deep hardening. Atlas No. 93, of the Allegheny Ludlum Steel Co., is a shock-resistant steel with 0.65% chromium, 0.35 molybdenum, and 0.55 carbon. Chrome-molybdenum steels with carbon to 1% are used for castings for bucket lips, crusher parts, and other heavy-duty parts. They have tensile strengths up to 150,000 psi, with elongation 12 to 14%.

**Chrome oxide green.** A pigment marketed in the forms of dry powder or ground in oil, used in paints and lacquers and for coloring rubber. It is a bright-green, crystalline powder of the composition  $\text{Cr}_2\text{O}_3$ , with specific gravity 5.20 and melting point 1990°C, insoluble in water. The dry powder has a  $\text{Cr}_2\text{O}_3$  content of 97% min, and is 325 mesh. The paste contains 85% pigment and 15 linseed oil. Chrome oxide green is not as bright in color as Chrome green but is more permanent. Chrome green is a mixture of Prussian blue and chrome yellow.

**Chrome-vanadium steel.** A chromium alloy steel containing a small amount of vanadium which has the effect of intensifying the

action of the chromium and the manganese in the steel. It also aids in the formation of carbides, hardening the alloy, and also increasing the ductility by the deoxidizing effect. The amount of vanadium is usually 0.15 to 0.25%. These steels are valued where a combination of strength and ductility is desired. They resemble those with chromium alone, with the advantage of the homogenizing influence of the vanadium. A chrome-vanadium steel having 0.92% chromium, 0.20 vanadium, and 0.25 carbon has a tensile strength of 100,000 psi, and when heat-treated has a strength up to 150,000 psi and elongation 16%. Chrome-vanadium steels are used for such parts as crankshafts, propeller shafts, and locomotive frames. High-carbon chrome-vanadium steels are the mild-alloy tool steels of high strength, toughness, and fatigue resistance. The chromium content is usually about 0.80%, with 0.20 vanadium, and with carbon up to 1%. Arrow steel, of the Latrobe Electric Steel Co., contains 0.90 to 1% chromium, 0.16 to 0.20 vanadium, 0.50 to 0.60 manganese, and 0.20 to 0.30 carbon. It is used for shafts, gears, and stressed parts. Crown steel, of the same company, has higher manganese and up to 0.50 carbon, both elements making it more deep-hardening. It is used for automotive springs, gears, crankpins, and tools. The tensile strength is 185,000 psi, and elongation 15%. Milwaloy, of the Milwaukee Steel Foundry Co., is a casting steel. Grade 7 contains 1.5 to 1.75% chromium, 0.60 to 0.70 vanadium, and 0.30 to 0.50 carbon. It is used for high-strength parts. Many high-alloy steels also contain some vanadium, but where the vanadium is used as a cleansing and toughening element and not to give the chief characteristics to the steel these alloys are not classed as chrome-vanadium steel. H.Y.C.C. steel of the Crucible Steel Co., for example, is an oil-hardening steel of high wear resistance containing 12% chromium and 2.25 carbon with 0.25 vanadium. It is a hard, deep-hardening steel for dies.

**Chromic acid.** A name given to the red, crystalline, strongly acid material of the composition  $\text{CrO}_3$  known also as Chromium trioxide or as Chromic anhydride. It is in reality not the acid until dissolved in water, forming a true chromic acid of the composition  $\text{H}_2\text{CrO}_4$ . It is marketed in the form of porous lumps. The specific gravity is 2.70, melting point  $196^\circ\text{C}$ . It is produced by treating sodium or potassium dichromate with sulphuric acid. The dust is irritating, and



the fumes of the solutions are injurious to the nose and throat as the acid is a powerful oxidizing agent. Chromic trioxide is used in chromium-plating baths, for etching copper, in electric batteries, and in tanning leather.

**Chromite.** An ore of the metal chromium, called Chrome ore when used as a refractory. It is found in the United States, chiefly in California and Oregon, but most of the world production is in South Africa, Rhodesia, Cuba, Turkey, the Philippines, Greece, and New Caledonia. The theoretical composition is  $\text{FeO} \cdot \text{Cr}_2\text{O}_3$ , with 68% chromic oxide, but pure Iron chromate is rare. Part of the iron may be replaced by magnesium, and part of the chromium by aluminum. The silica present in the ore, however, is not a part of the molecule. Chromite is commonly massive granular, and the commercial ores contain only from 35 to 60% chromic oxide. The hardness is 5.5 and the specific gravity 4.6. The color is iron black to brownish black, with a metallic luster. The melting point is about  $3900^\circ\text{F}$ , but when mixed with binders as a refractory the fusion point is lowered. New Caledonia ore has 50% chromic oxide, Turkish ore averages 48 to 53%, Brazilian ore runs 46 to 48%, and Cuban ore averages only 35%. The high-grade Guleman ore of Turkey contains 52%  $\text{Cr}_2\text{O}_3$ , 14  $\text{Al}_2\text{O}_3$ , 10.4  $\text{FeO}$ , 4.4  $\text{Fe}_2\text{O}_3$ , 16 magnesia, and 2.5 silica. Most of the domestic ore in the United States is low grade.

Cuban ore is rich in Spinel,  $\text{MgO} \cdot \text{Al}_2\text{O}_3$ , and deficient in magnetite, and this type is adapted for refractory use even when the chromic oxide is low. The Indian ore from Baluchistan is also valued for refractory use, as are other hard lumpy ores high in  $\text{Al}_2\text{O}_3$  and low in iron. For chemical use the ores should have more than 45% chromic oxide, not more than 8 silica, and be low in sulphur. Metallurgical ore should have not less than 48% chromic oxide, and the ratio of chromium to iron should not be less than 3:1. Chromite is used for the production of chromium, ferro-chromium, in making Chromite bricks and refractory linings for furnaces, and for the production of chromium salts and chemicals. For bricks the ground chromite is mixed with lime and clay and burned. Chromite refractories are neutral and are resistant to slag attack. A chrome-ore high-temperature cement marketed by the General Refractories Co. under the name of Grefco has a fusion point of  $3400^\circ\text{F}$ .

**Chromium.** An elementary metal, symbol Cr, used in stainless steels, heat-resistant alloys, high-strength alloy steels, for wear-resistant electroplating, and in its compounds for pigments, chemicals, and refractories. The specific gravity is 6.92, melting point 2750°F, and boiling point 3992°F. The color is silvery white with a bluish tinge. It is an extremely hard metal, the electrodeposited plates having a hardness of 9 Moh. It is resistant to oxidation, is inert to nitric acid, but dissolves in hydrochloric acid and slowly in sulphuric acid. Chromium occurs in nature only in combination. Its chief ore is chromite, from which it is obtained by reduction and electrolysis. It is marketed for use principally in the form of master alloys with iron or copper. The term Chromium metal usually indicates a pure grade of chromium containing 97 to 98% chromium and not more than 1 iron and 0.50 carbon. Chromium metal is used for making special alloys, particularly resistance metals, or for chemical use in which case it is marketed as a powder of 250 and 300 mesh. Chromium plating is widely used where extreme hardness or resistance to corrosion is required. When plated on a highly polished metal, it gives a smooth surface that has no capillary attraction to water or oil, and chromium-plated bearing surfaces can be run without oil. Chromium plating is sometimes given trade names such as Aranium, of Manning, Bowman & Co. For decorative purposes chromium plates as thin as 0.0002 in. may be used; for wear resistance, plates up to 0.50 in. are used.

**Chromium cast iron.** Cast iron containing chromium as the chief alloying element. It is used where hardness and high strength are required. Chromium in cast iron is a carbide-forming element. The free carbides begin to form in the iron at about 0.60% chromium. Small amounts of chromium refine the graphite structure but, at about 1% chromium content, the cementite builds up rapidly. At about 3% chromium, the graphite disappears and the matrix consists of oriented cementite. At 5% chromium, there is much massive carbide in the structure. Chromium also prevents the decomposition of iron silicide, and unless modified with other alloying elements the iron may reach a hardness of 700 Brinell. Usually, nickel is used in combination with chromium to balance the chromium by acting as a graphitizer and preventing the formation of hard carbide spots. The

proportion of nickel to chromium is generally about 3 to 1. Ni-Hard, of the International Nickel Co., is a chromium-nickel white iron containing 4 to 6% nickel and 1 to 1.25 chromium. It is tough, and when chilled has a surface hardness up to 700 Brinell. For greater wear resistance it may contain manganese up to 1.5%. Sometimes very high carbon is used in these irons for wear resistance. Flint-metal, of the Taylor-Wharton Iron & Steel Co., contains 4 to 4.5% nickel, 1.25 to 1.75 chromium, and 3 to 3.5 carbon. It has a Brinell hardness of 600. Chromium cast irons are used for automotive body dies, rolls, and various wear-resistant castings, but most of them are high in nickel and are classified with the nickel-chromium irons.

**Chromium copper.** A name applied to master alloys of copper with chromium used in the foundry for introducing chromium into nonferrous alloys, or to Copper-chromium alloys, or Chrome copper, which are high-copper alloys containing a small amount of chromium with or without other alloying elements. When they also contain tin, silicon, or iron, they may be referred to as Chromium bronze. A chromium-copper master alloy marketed under the name of Electromet chromium copper by the Electro Metallurgical Sales Corp. contains 8 to 11% chromium, 88 to 90 copper, and a maximum of 1 iron and 0.50 silicon. Chrome copper in wrought form has high impact strength, and the electrical conductivity is higher than when the copper is hardened with silicon. Chrome copper with 0.50% chromium has a thermal conductivity about 85% that of high-conductivity copper, which is about twice that of aluminum alloy, or seven times that of cast iron. Such alloys are used for cylinder heads. A wrought chrome copper of the American Brass Co. contains 0.85% chromium and 0.10 silicon, and has a tensile strength of 92,000 psi with elongation 3%. Chromium bronze, used for bearings, is a cast metal containing 1% chromium, 1 iron, and from 2 to 10 tin. It has high strength and good wearing qualities. Kumium, of the Imperial Chemical Industries, Ltd., is a copper-chromium alloy containing a high percentage of chromium, used for electrodes for spot-welding machines. It retains its hardness and conductivity at 400°C.

**Chromium-nickel steel.** This name usually applies to a group of corrosion-resistant alloys, or Austenitic steels, containing about 18% chromium and 8 nickel, as distinct from the high-strength, nickel-

chromium steels with only small amounts of chromium, and from the heat-resistant, nickel-chromium-iron alloys containing high percentages of chromium. The patents for the 18-8 steels, commonly known as Eighteen-eight steels, are held by the Chemical Foundation, and the steels are usually marketed under trade names. Chromium-nickel steels are ductile and malleable. With low carbon they can be drawn and cupped, although they harden rapidly with cold work and must be annealed after each draw or the steel tends to crack. About three times the power is required to draw an 18-8 steel as is needed for an ordinary steel of the same carbon content. The steels are corrosion-resistant and also resistant to most acids. The strengths range from 75,000 to 140,000 psi, with elongations 30 to 65%. The weight is 0.279 to 0.287 lb per cu in. When polished, they have a brilliant luster which does not dull on exposure, and they are referred to as stainless steels. Those with low carbon are more corrosion-resistant than those with higher carbon, and they are used for chemical and food equipment. Defstain, of the Rustless Iron Corp., is an 18-8 steel with low carbon. Enduro 18-8, of the Republic Steel Co., has 0.08 to 0.20% carbon. The tensile strength is 85,000 psi and elongation 55%. Carpenter stainless No. 8, of the Carpenter Steel Co., is an 18-8 type of steel with 0.10 carbon and having 0.25% selenium to make it free-machining. Super stainless steel is a name given in England by Hadfield to the 18-8 steels to distinguish them from the standard 13% chromium stainless steels. The original Krupp austenitic, or KA steel, had 20% chromium and 7 nickel, which was later balanced at 18-8.

A Chromium-manganese steel containing 18% chromium, 5 to 6 manganese, 4 to 5 nickel, and 0.12 carbon, gives high resistance to corrosion, is comparable to the 18-8 steels, but has better drawing and working characteristics. Sharonsteel 302, of the Sharon Steel Corp., is an 18-8 type with 2% manganese and 1 silicon. When annealed, it has a tensile strength up to 95,000 psi, with elongation 50 to 60%, and when cold-worked the tensile strength may be as high as 275,000 psi with elongation 2%. The 18-8 steels are subject to grain growth, but small amounts of nitrogen may be used to inhibit grain growth, and the nickel may be lowered in the nitrogen-bearing steels. Small amounts of molybdenum and copper may be included to increase the corrosion resistance and to improve the

working qualities. Stainless U, of the Colonial Steel Co., is an 18-8 type of steel with the addition of 1.5% molybdenum and 1.25 copper, and having 0.15 carbon. As rolled, it has a tensile strength of 100,000 psi and elongation 40%. Maxilvry steel, of Edgar Allen & Co., Ltd., is a chromium-nickel steel containing copper, intended for deep drawing. The tensile strength, annealed, is 40 tons per sq in., elongation 68%, and hardness 149. Bethalon steel, of the Bethlehem Steel Co., is an 18-8 steel having a tensile strength of 90,000 psi, which, when fully heat-treated, has a tensile strength of 174,000 psi and Brinell hardness 352. Sta-Gloss, Hi-Gloss, and Duro gloss are stainless steels of the Jessop Steel Co. Allegheny metal, of the Allegheny Ludlum Steel Co., is an 18-8 steel in various grades of carbon and varied with molybdenum or other elements. Allegheny 18-8-M contains 16 to 18% chromium, 10 to 14 nickel, 0.10 carbon, and 2 to 3 molybdenum. Carpenter stainless No. 10 contains 18% nickel, 16 chromium, and 0.08 carbon. It does not work-harden easily, and is used for parts to be cold-headed or coined. Armco stainless 17-7 PH, of the Armco Steel Corp., is a precipitation-hardening steel with spring steel qualities, used for springs and diaphragms. It has 17% chromium, 7 nickel, 1 aluminum, and 0.07 carbon. When heat-treated, the steel has tensile strengths up to 205,000 psi with hardness 40 to 45 Rockwell C. Mill-treated wire has a tensile strength up to 345,000 psi. Carpenter stainless 303 is a free-cutting 18-8 steel for screw-machine parts. It contains 0.08% carbon and 0.07 selenium.

Most of the makers of the 18-8 wrought steels offer a wide range of grades some of which are stabilized with titanium or columbium to prevent intergranular corrosion. U.S.S. steel Type 347 has columbium equal to 10 times the minimum carbon, and U.S.S. steel Type 321 has titanium equal to 5 times the carbon. Stainless W steel, of the U.S. Steel Corp., is an 18-8 type but has a ferritic structure and is magnetic. The annealed steel is easily machined or formed, and can be hardened by a low-temperature heat-treatment. It contains 17% chromium, 7 nickel, 0.70 titanium, 0.20 aluminum, 0.50 silicon, 0.50 manganese, and 0.70 carbon. The tensile strength of the annealed steel is 120,000 to 150,000 psi. When hardened to Rockwell C-47 the tensile strength is 225,000 psi and elongation 10%. Intergranular corrosion can be eliminated in the 18-8 steels without

additions of other elements by keeping the carbon content below 0.03%. Armco 430 ELC is a stainless steel of this type with a ferritic structure needing no stabilizing elements.

Circle L22, of the Lebanon Steel Foundry, is a cast steel for pump, valve, and chemical equipment parts. It contains 19.5% chromium, 9 nickel, 1.25 silicon, and 0.75 manganese, and is produced in an induction furnace with a maximum of 0.07% carbon. The low carbon permits welding without the formation of carbides on large structures that cannot be heat-treated. This steel has a tensile strength of 75,000 psi, elongation 50%, and hardness 135 Brinell. With a small amount of selenium to improve machining, it is called Circle L22M, and with about 3% molybdenum to increase chemical resistance and to prevent intergranular corrosion at high temperatures it is called Circle L22XM. This latter steel also has higher strength and hardness. Circle L23 is this type of steel with 0.20% carbon. Durco KA2S steel, of the Duriron Co., is an 18-8 cast steel with 0.07% carbon. Durco KA2SMo is a similar steel with 3% molybdenum. When cast, it has a tensile strength up to 95,000 psi, elongation 40 to 45%, and hardness 140. Stainless CF-8M, of the Alloy Casting Institute, is an 18-8 steel with 2 to 3% molybdenum and 0.08 carbon. The tensile strength is 90,000 psi, and it retains a strength of 40,000 psi at 1200°F. Evansteel, of the Chicago Steel Foundry Co., is chromium-nickel cast steel in various grades which may contain vanadium or molybdenum. It includes the stainless types for chemical-resistant parts, and the high-chromium types for wear-resistant parts.

**Chromium steel.** Any steel containing chromium as the predominating alloying element may be termed chromium steel, but the name alone usually means the hard, wear-resisting steels that derive the property chiefly from the chromium content. Chromium combines with the carbon of steel to form a chromium carbide, but when other carbide-forming elements are present double or complex carbides are formed. Chromium refines the structure, gives deep-hardening, increases the elastic limit, and gives a slight red hardness so that the steels retain their hardness at more elevated temperatures. Chromium steels have great resistance to wear. They also withstand quenching in oil or water without much deformation. Up to about 2% chromium may be included in tool steels to add hardness, wear resistance,

and nondeforming qualities. When the chromium is high, the carbon may be much higher than in ordinary steels without making the steel brittle. Steels with 12 to 17% chromium and about 2.5 carbon have remarkable wear-resisting qualities and are used for cold-forming dies for hard metals, for broaches, and for rolls. However, chromium narrows the hardening range of steels unless balanced with nickel. They also work-harden rapidly unless modified with other elements. The high-chromium steels are corrosion-resistant and heat-resistant, but are not to be confused with the high-chromium stainless steels which are low in carbon. Chromium steels with about 1% chromium are used for gears and shafts. Uma steel No. 1, of the Republic Steel Corp., has 0.55 to 0.75% chromium, 0.35 to 0.65 manganese, and 0.15 carbon. It is a casehardening gear steel. Uma No. 5 has 0.85 to 1.10% chromium, 0.70 to 0.90 manganese, and 0.50 carbon. It is deep-hardening, with a tensile strength up to 135,000 psi, and is used for transmission gears. This type of steel with higher carbon is deep-hardening and has high compression strength and is used for ball and roller bearings. However, Ball-bearing steel derives much of its characteristics from the heat-treatment. A good ball-bearing steel is one that has uniform undissolved carbides in a matrix of martensite and a Rockwell C hardness of 60 to 64 when quenched in oil and stress-relieved. Teton steel, of the Allegheny Ludlum Steel Corp., has 1.25% chromium and 1 carbon, and is employed for ball bearings, spindles, and for hard wear-resistant parts.

Chromium steels with 3 to 4.5% chromium and 0.80 to 1 carbon are used for dies for hot pressing and forging. EB alloy, of the Allegheny Ludlum Steel Corp., has 3.75% chromium, 0.55 vanadium, 0.70 molybdenum, and 0.65 carbon. Another hot-work steel of this company is Potomac steel with 5% chromium, 1.75 molybdenum, 1.25 tungsten, and 0.32 carbon. Uniloy chrome steel, of the Cyclops Steel Co., contains 4 to 6% chromium, 0.1 to 0.25 carbon, up to 0.60 manganese, with either molybdenum 0.40 to 0.60%, or tungsten 1 to 1.25%. A small amount of tungsten, or smaller amount of molybdenum, refines the grain, increases the elastic limit, and makes the steel more resistant to corrosion at elevated temperatures. The Chromium-tungsten steels are employed where resistance to hot chemicals or petroleum is required, but the steels with high tungsten are usually classed as tungsten steel regardless of the amount

of chromium. A steel used for high-strength resistant castings is Circle L-10 of the Lebanon Steel Foundry. It contains 5.5% chromium, 0.50 molybdenum, 0.65 manganese, 0.40 silicon, and 0.20 carbon. When heat-treated it has a tensile strength of 100,000 psi and elongation 20%. Nicroman is an all-purpose tool steel of Henry Disston & Sons, Inc., with 1% chromium, 1.65 nickel, 0.35 copper, and 0.70 carbon.

A wear-resistant die steel, marketed by the Carpenter Steel Co. under the name of Hampden steel, contains 12.5% chromium, 0.25 nickel, 0.25 manganese, and 2.1 carbon. It is deep-hardening, has high compressive strength, and is valued for forming rolls and spinning tools. A similar-purpose tool steel with air-hardening properties is Carpenter No. 610. It has 12% chromium, 1.5 carbon, 0.80 molybdenum, 0.20 vanadium, and 0.30 manganese. Huron steel, of the Allegheny Ludlum Steel Corp., is a wear-resistant steel having 12.5% chromium, 1 vanadium, and 2 carbon. It is used for dies. O-Hi-O, of the Vanadium Alloys Steel Co., is an air-hardening die steel having 12% chromium, 1.55 carbon, 0.85 vanadium, 0.40 cobalt, and 0.80 manganese. Crocar, of this company, is a wear-resistant die steel with similar composition but with 2.2% carbon. Croloy, of Henry Disston & Sons, Inc., used for punches, dies, gages, and shear blades, has 12% chromium, 1.5 carbon, 1 vanadium, and 0.80 molybdenum. Mix 812 steel of this company has 12% chromium and 1.8 carbon. It is a fine-grained oil-hardening steel used for wearing surfaces and cutting edges, but it work-hardens and is difficult to machine. G.S.N. steel, of this company, is a high-chromium, high-carbon die steel.

**Cinchona.** The hard, thick, grayish bark of a number of species of evergreen trees of the genus *Cinchona*, native to the Andes from Mexico to Peru but now grown in many tropical countries chiefly as a source of quinine. The small tree *Remijia pendunculata* also contains 3% quinine in the bark, and quinine occurs in small quantities in other plants and fruits, notably the grapefruit. Cinchona bark was originally used by the Quechua Indians of Peru in powdered form and was called Loxa bark. It derives its present name from the fact that in 1630 the Countess of Cinchon was cured of the fever by its use. In Europe it became known as Peruvian bark and Jesuits'



bark. Quinine is one of the most important drugs as a specific for malaria and as a tonic. It is also used as a denaturant for alcohol as it has an extremely bitter taste. Metallic salts of quinine are used in plastics to give fluorescence and glow under ultraviolet light. Quinine is a colorless crystalline alkaloid of the composition  $C_{20}H_{24}O_2 \cdot N_2 \cdot 3H_2O$ . It is difficultly soluble in water, and is marketed in the form of the more soluble Quinine sulphate, a white powder of the composition  $(C_{20}H_{24}O_2N_2)H_2SO_4 \cdot 2H_2O$ . Quinine bisulphate has the same composition but with 7 molecules of water. During the Second World War Quinine hydrochloride was preferred by the Navy. It contains 81.7% quinine compared with 74% in the sulphate and is more soluble in water but has a more bitter taste. Synthetic quinine can be made, but is more expensive. The substitute called Atabrine, of I. G. Farbenindustrie, is Quinacrine hydrochloride. It is not a complete substitute, is toxic, and is a dye that colors the skin when taken internally.

The bark of the tree *C. ledgeriana* yields above 7% of quinine but is not a robust tree and in cultivation is grafted on the tree *C. succirubra* which is hardy but yields only 2 to 3% quinine. *Ledgeriana* trees on plantations in Mindanao and in Peru yield as high as 13% total alkaloids from the bark. Most of the world production is from the *C. officinalis* and *C. calisaya*, which are variations of *C. ledgeriana*, or yellow bark. The Red bark, *C. succirubra*, is grown in India. The trees are grown from seeds which are small, 75,000 to the ounce. The peak gathering of bark is 10 years after planting of the 2-year seedlings, and the trees are uprooted to obtain bark from both trunk and root. An 8-year-old tree yields 4 kilos of bark, and a 25-year tree yields 20 kilos but of inferior quality. The bark is dried and ground to powder for the solvent extraction of the alkaloids. Besides quinine the bark contains about 30 other alkaloids chief of which are Cinchonidine, Quinidine, and Cinchonine. To-taquina is the drug containing all the alkaloids. It is cheaper than extracted quinine and is effective against malaria and is a better tonic. Quinidine has the same formula as quinine but is of right polarization instead of left. It is used for heart ailments. Cinchonine,  $C_{18}H_{22}ON_2$ , has right polarization and is 13 times more soluble in water than quinine sulphate. Cinchonidine has the same formula, but is left polarization. Australian quinine, or *Alstonia*, is not true quinine. It

is from Dita bark, the bark of the tree *Alstonia scholaris* of Australia, and is used as a febrifuge. It contains the water-soluble alkaloid Ditiane,  $C_{22}H_{28}O_4N_2$ , and the water-insoluble alkaloid Ditamine,  $C_{16}H_{19}O_2N$ . Fagarine, used as a substitute for quinidine for heart flutter, is extracted from the leaves of the tree *Fagara coco* of northern Argentina.

**Cinnabar.** The chief ore of the metal mercury. As a pigment it was originally called Minium, a name now applied to red lead. It is a Mercuric sulphide,  $HgS$ , which when pure contains 86.2% mercury. The ores, however, are usually poor, the best ones containing only about 7% mercury, and the average American ore having only 0.5%. The chief production is in Italy, Spain, Mexico, and the United States. Cinnabar has a massive granular structure with a hardness of 2 to 2.5, a specific gravity of about 8, and usually a dull earthy luster. It is brownish red in color, from which it derives the name Liver ore. Chinese cinnabar is ground as a fine scarlet pigment for inks. Cinnabar is not smelted, the extraction process being one of distillation, made possible by the low boiling point of the metal. Another ore of mercury found in Mexico is Livingstonite,  $2Sb_2S_3 \cdot HgS$ . It is a massive, red-streaked mineral of specific gravity 4.81 and hardness 2. Calomel, a minor ore in Spain, is a white to gray crystalline mineral of the composition  $Hg_2Cl_2$  with a specific gravity of 6.5. It is also called Horn mercury. It is used in medicine as a purgative, but is poisonous if retained in the system. The ore found in Colorado and known as Coloradoite is a Mercuric telluride,  $HgTe$ . It has an iron-black color and a specific gravity of 8. Tiemanite, found in California and Utah, is a Mercuric selenide,  $HgSe$ , having a lead-gray color and a specific gravity of 8.2. There are more than 20 minerals classed as Mercury ores.

**Cinnamon.** The thin, yellowish-brown highly aromatic bark of the tropical evergreen laurel tree *Cinnamomum zeylanicum*, of Ceylon, China, and the East Indies. It is used as a spice, as a flavor in confectionery, perfumery, and medicine. The bark is marketed in rolls or sticks packed in bales of 112 lb. Cassia is the bark from the *C. cassia* of South China. Saigon cinnamon, *C. loureirii*, is cinnamon, but is not as thin or as smooth a bark, and it does not have as fine an aroma and flavor. Cassia buds are small dried flowers of the

*C. cassia*, used ground as a spice, or for the production of oil. They resemble cloves in appearance, and have an agreeable spicy odor and sweet warm taste. Cinnamon oil, Cinnamon leaf oil, and Cassia oil are essential oils distilled, respectively, from the bark, leaf, and bud. They are used in flavoring, medicine, and perfumery. Cinnamon oil contains about 70% Cinnamic aldehyde, 8 to 10% eugenol, and also pinene and linalol. The specific gravity is 1.03, and the refractive index 1.565 to 1.582. The pale-yellow color darkens with age. Cinnamic aldehyde is also made synthetically. Flasolee, of the J. Hilary Herchelroth Co., is Amyl cinnamic aldehyde, redistilled to remove the unpleasant odor of heptyl aldehyde, for use in perfumes. The leaf oil is used as a substitute for clove oil. About 1.9% oil is obtained from cassia buds, but it lacks the delicate fragrance of cinnamon oil. Nikkel oil, a bright-yellow liquid with an odor of lemon and cinnamon, is distilled from the leaves and twigs of the tree *C. laureirii* of Japan. It contains citral and cineol, and is used in perfumery. Some of the cinnamon marketed in the United States is Padang cassia, from the tree *C. burmannii* of the East Indies. It does not have the delicate aroma of true cinnamon.

**Cloves.** The dried flower buds of the evergreen tree *Caryophyllus aromaticus*, grown chiefly in Zanzibar, but also in Madagascar, East Africa, and the East Indies. The buds yield 15 to 19% of a pungent yellowish essential oil, Clove oil, also called Caryophil oil. It contains 85% Eugenol, and also the terpene Clovene,  $C_{15}H_{24}$ . Clove oil is used in medicine as an antiseptic, in tooth pastes, in flavoring, and for the production of artificial vanilla. Eugenol is a viscous phenol-type liquid. It is also the basis for carnation-type perfumes. Clove buds are chiefly valued as a highly aromatic spice. The clove tree attains a height up to 40 ft, bearing in 7 or 8 years, and continuing to bear for a century, yielding 8 to 10 lb of dried cloves annually. Clove stems are also aromatic, but contain only 5 to 6% oil of inferior value.

**Coal.** A general name for a black mineral formed of ancient vegetable matter, and employed as a fuel and for destructive distillation to obtain gas, coke, oils, and coal-tar chemicals. Coal is composed largely of carbon with smaller amounts of hydrogen, nitrogen, oxygen, and sulphur. It was formed in various geological ages and

under varying conditions, and occurs in several distinct forms. Peat is the first stage, followed by lignite, bituminous coal, and anthracite, with various intermediate grades. The mineral is widely distributed in many parts of the world. The value of coal for combustion purposes is judged by its fixed carbon content, volatile matter, and lack of ash. It is also graded by the size and percentage of lumps. The percentage of volatile matter declines from peat to anthracite, and the fixed carbon increases. A good grade of coal for industrial power-plant use should contain 55 to 60% fixed carbon and not exceed 8% ash. The Btu value should be 13,500 to 14,000 per lb. Finely ground, or Powdered coal, is used for burning in an air blast like oil, or may be mixed with oil. Low-grade coals are pulverized, and used to make Synthesis gas for producing gasoline and chemicals. The pulverized coal is fed into a high-temperature reactor with oxygen and steam, where the combination forms carbon monoxide and hydrogen. This type of gas is also made from natural gas. Coal in its natural state absorbs large amounts of water and also, because of impurities and irregular sizes, is not so efficient as a fuel as the Reconstructed coal made by crushing and briquetting lignite or coal and water-proofing with a coating of pitch.

**Coated fabrics.** The first coated fabric was a rubberized fabric produced in Scotland by Charles Macintosh in 1823 and known as Mackintosh cloth for Rainwear use. Since no method of vulcanization was then known, the cloth was made by coating two layers of fabric with rubber dissolved in naphtha and pressing them together, making a double fabric impervious to water. Rubberized fabrics are now made by coating cotton or silk with compounded rubber and passing between rollers under pressure. The final vulcanized coating is usually 0.002 to 0.003 in. thick, and the resultant fabric is flexible and waterproof. Synthetic rubbers are also used for coating fabrics, especially those that require resistance to oils or chemicals. The bulk of coated fabrics is now made by impregnating or coating with synthetic resin compositions. Nitrocellulose plasticized with oil-modified alkyd resins give flexible coatings of great durability and water resistance. This type of coating was used for military fabrics to resist temperatures as low as  $-20^{\circ}\text{F}$  and as high as  $240^{\circ}\text{F}$ . They are also used for coating book covers. Pliosheen, of the Goodyear Tire &

Rubber Co., is silk or rayon fabric treated with Chemigum type of synthetic rubber. It is waterproof, odorless, flame-resistant, and easily cleaned. Cavalite, of E. I. du Pont de Nemours & Co., Inc., is silk coated with synthetic rubber. Terson voile, of the Athol Mfg. Co., is a sheer-weight rayon coated with vinylite resin. It is strong, crack-resistant, waterproof, and weighs 2 oz per sq yd. It is used for umbrellas, rainwear, industrial linings, and book covers. Geon latex, of the B. F. Goodrich Co., used for coating fabrics, is a water dispersion of polyvinyl chloride plastic. Kalistron, of the U.S. Plywood Corp., used for upholstery and wall covering, is a transparent vinyl plastic sheet colored on the rear side with an adhered flock over the color to give a resilient backing. Rhoplex WN-80, of the Rohm & Haas Co., is a water dispersion of an acrylic resin polymer for coating fabrics or greaseproofing paper. Rhoplex WN-75 is an acrylic dispersion capable of forming very thin continuous coatings. The vinyl coatings are usually tough and elastic. Exylin is a trade name of McCoy, Jones & Co., Inc., for rainwear and bag fabrics coated with vinylite resin.

Leather fabrics, used as substitutes for upholstery leather for furniture and automobile-seat covers, are usually cotton fabrics coated with plastics and embossed with designs to imitate leather. The base cloth may be of various weights from light sheetings to heavy ducks and may be napped on the back. Leather fabrics are more durable, more easily cleaned, and lower in cost than split leathers. Fabrikoid, of E. I. du Pont de Nemours & Co., Inc., is cellulose-plastic-coated upholstery material marketed in various weights, colors, and designs. It is used for automobile covering, book covers, and waterproof articles. Armalon is twill or sateen fabric coated with ethylene plastic for upholstery use. It is strong and pliable. Tontine, of this company, is a plastic-impregnated cloth used for window shades, and Pontan is a rubberized fabric made to imitate colored leathers. The Fairprene fabrics of this company are cotton fabrics coated with chloroprene synthetic rubber. but the same name is also applied to chloroprene rubber sheet, without fabric, in thicknesses  $\frac{1}{32}$  to  $\frac{1}{8}$  in plain or embossed colors for upholstery. Plastavon fabric of the Avondale Mills is not woven, but is made with a web of cotton fibers laid in one direction and bonded with a plastic film. Coated fabrics are also made from yarns treated with synthetic resin, usually vinyl

butyral, to give an extremely thin surface coating that is scarcely detectible but makes the fabric water-resistant, immune to insect attack, and easily cleaned.

Impregnated fabrics are fabrics that have been treated with fungicides or with flame-resistant chemicals, and may also be coated with a waterproofing resin. Stabilized fabrics, however, are not waterproofed or coated, but are fabrics of cotton, linen, or rayon that have been treated with a water solution of urea-formaldehyde resin to give them greater resiliency, resistance to creasing, and resistance to shrinkage in washing. Shrinkproof fabrics are fabrics of cotton or wool that have been given an impregnation of about 2% resin by dipping in a water solution of alkylated melamine-formaldehyde resin, then washing so that the resin remains only in the core of the fibers. The fabric retains its original softness, texture, and appearance, and is not waterproofed, but the fibers have increased stability and can shrink but slightly in washing. Resloom M-75 of the Monsanto Chemical Co. and Lanaset of the American Cyanamid Co. are liquid resins for shrinkproofing fabrics. The latter is a Methylol-melamine resin made by alkylating melamine-formaldehyde resin with methyl alcohol. Synthrez D, of Synthron, Inc., is a Methylol-urea resin in a white paste form that dissolves completely in water for use as a bath for making cotton and rayon fabrics crease-resistant and shrinkproof.

**Cobalt.** An elementary metal, symbol Co. Cobalt is a white metal resembling nickel, but it has a blue tinge. Although allied to nickel, it has distinctive differences. It is not as corrosion-resistant as nickel, and its power of whitening copper alloys is inferior to that of nickel. It is diamagnetic like nickel, but has nearly 3 times the saturation value and 20 times the maximum permeability. Like tungsten, it has the property of adding red-hardness to cutting alloys. It also hardens alloys to a greater extent than nickel, especially in the presence of carbon. Cobalt has a specific gravity of 8.756, melting point 1480°C, and electrical conductivity 16.7% that of silver. The hardness is 86 Brinell. The tensile strength of pure cast cobalt is 34,500 psi, but with 0.25% carbon this is increased to 62,000 psi. Cobalt is not used in bronzes like nickel, but some cobalt may be used to neutralize the yellow of nickel to produce white alloys. It is also employed in cut-

ting alloys and tool steels, in magnet steels, in high-permeability electrical alloys, as a catalyst, and its compounds are employed as pigments and for coloring ceramics.

Cobalt metal is marketed in rondelles, or cast slugs about 1 in. in diameter and  $\frac{3}{4}$  in. thick, and in shot and anodes. Some cobalt powder is also marketed, and cobalt oxide is sold in kegs of 534 lb. The metal is obtained by smelting the ores in a blast furnace and then treating the arsenides in acids from which the cobalt hydroxide is precipitated. This is changed to the oxide by heating, and the oxides are reduced electrolytically. The chief ores are cobaltite and smaltite. Cobaltite, or Cobalt glance, found in Ontario, is a sulpharsenide of the metal,  $\text{CoAsS}$ , and occurs with Gersdorffite,  $\text{NiAsS}$ . Another sulphide is Linnaeite,  $\text{Co}_3\text{S}_4$ , containing theoretically 58% cobalt, but usually containing nickel and iron. Smaltite is also an ore of cobalt as it contains theoretically 28.1% cobalt. Erythrite is a hydrous cobalt arsenate which occurs near the surface of the smaltite deposits in French Morocco. Cobalt is also produced from the copper ores of the Belgian Congo and northern Rhodesia, and these ores form the chief source of the commercial cobalt. The Rhokana copper ore carries about 0.5% cobalt, which is extracted as a cobalt-copper-iron alloy with 40% cobalt.

**Cobalt oxide.** A steel-gray to blue-black powder employed as a base pigment for ceramic glazes on metal, as a colorant for glass, and as a chemical catalyst. It gives excellent adhesion to metals and is valued as an undercoat for vitreous enamels. It is the most stable blue, as it is not changed by ordinary oxidizing or reducing conditions. It is also one of the most powerful colorants for glass, 1 part in 20,000 parts of a batch giving a distinct blue color. Cobalt oxide is produced from treatment of cobalt-nickel ores, and has the composition  $\text{Co}_3\text{O}_4$ , but the oxide commercially known as Black cobalt oxide may be a mixture with  $\text{Co}_2\text{O}_3$ , and is cobaltous-cobaltic oxide. It is marketed on the basis of 70 to 71% cobalt. The two classes are called RKO and SKO grades, with specific gravities ranging from 5.8 to 6.3. Gray cobalt oxide has the composition  $\text{CoO}$ , but this form and  $\text{Co}_2\text{O}_3$  are unstable and change to the blue  $\text{Co}_3\text{O}_4$  on heating. It is marketed on the basis of 75% cobalt. The pigment known as Smalt, and as Royal blue and Saxon blue, is a deep-blue powder made by fusing cobalt

oxide with silica and potassium carbonate. It contains 65 to 71% silica, 16 to 21 potash, 6 to 7 cobalt oxide, and a little alumina. It is used for coloring glass and for vitreous enameled signs, but does not give good covering power as a paint pigment. Thénard's blue is made by heating together cobalt oxide and aluminum oxide. Rinnmann's green is made by heating together cobalt oxide and zinc oxide.

**Cobalt steels.** Cobalt is a much rarer and more expensive metal than nickel, but it has powerful influencing properties in steel and iron alloys, and is used in tool steels, cutting alloys, and magnet steels. Small amounts of cobalt are used in special tool steels to give hardness, but large amounts decrease the impact resistance. The cobalt steels retain hard carbides at high temperatures, and the high-speed steels containing cobalt are harder than the regular tungsten steels and can be operated at higher temperatures. The quality is developed to a greater extent when chromium is present in the steel. Considerable amounts of cobalt are thus employed in the super high-speed steels, but they are more difficult to forge and require greater care in heat-treatment than the plain high-speed steels. Cobalt increases residual magnetism in steel and increases the coercive magnetic force. High percentages of cobalt are therefore sometimes used in magnet steels and in high-permeability electrical alloys.

**Cochineal.** A dyestuff of animal origin, which before the advent of coal-tar dyes was one of the most important coloring materials. Cochineal is the female of the *Coccus cacti*, an insect that feeds on various species of cactus of Mexico. The insects have no wings, and at the egg-laying season are brushed off the plants, killed by boiling, and dried. They are dark reddish brown in color. Cochineal contains 10 to 20% pure coloring matter, carminic acid, mostly in the eggs, from which the Carmine red,  $C_{11}H_{12}O_7$ , is obtained by boiling with mineral acid. Carmine red produces brilliant lake colors of various hues with different metals. Commercial cochineal may be adulterated with starch, kaolin, red lead, or chrome lead. The brilliant red pigment known as Carmine lake is made by precipitating a mixture of cochineal and alum.

**Cocoa beans.** The seed beans from the large fruit pods of the cacao tree, *Theobroma cacao*, native to Mexico, and *T. leiocarpum*,



native to Brazil. The tree was cultivated in Mexico from ancient times, and the beans were used by the Aztecs to produce a beverage called *Chocolatl* which contained the whole substance of the fermented and roasted bean flavored with vanilla. Cocoa beans are now produced in many countries, and the United States imports from about 40 countries, although 75% of the prewar imports were from the Gold Coast, Nigeria, and Brazil. The tree grows only in the tropics, cannot withstand temperatures below 60°F, but grows best in the highlands. It begins to bear in 4 or 5 years and continues to bear for as long as 50 years, having fruits and flowers throughout the year. The fruits are melonlike pods 6 to 9 in. long with a pulp and from 40 to 60 seed beans. The pulp and seeds are scooped out, fermented, and dried in the sun. During the curing the beans lose their bitter taste, and become reddish brown in color. They are then washed, dried, and polished. Numerous varieties are cultivated. The flavor and aroma also vary with soil and climate, and differences in curing methods also produce differences in the beans, so that types and grades are best known by the shipping ports and districts in which they are grown. *Mico cocoa* is wild cocoa of Central America. The beans are smaller than the cultivated ones and are noted for fine flavor. Cocoa beans are shipped dried but not roasted. They are roasted just before use to develop the flavor, to increase the fat content, and to decrease the tannin content. The hard shells are removed, and the roasted seeds are ground and pressed to produce Bitter chocolate. Sweet chocolate is made by adding sugar and flavoring, usually vanilla. Cocoa, for beverage purposes, is made by removing about 60% of the fatty oil from chocolate by hydraulic pressing and powdering the residue to which is usually added ground cocoa shells. The removed fatty oil is *Cocoa butter*, used for bakery products, cosmetics, and pharmaceuticals. A hundred pounds of cocoa beans yield 48 lb of Chocolate powder, 32 lb of cocoa butter, and 20 lb of waste. Besides fat the chocolate contains much starch and protein and has high food value, but is not as stimulating as the cocoa since the alkaloid is largely contained in the waste and shells. These contain 1 to 1.5% theobromine and are used for the synthetic production of caffeine. The chocolate is used in the manufacture of confectionery, chocolate bars, bakery products, and flavoring sirups. *Microfine cocoa*, of the Cook Chocolate Co., used for bakery products, is ground to

325-mesh, and contains from 9 to 16% cocoa butter. Postonal is a German substitute for cocoa butter for pharmaceuticals. It is a polymerized ethylene oxide containing chemically combined castor oil.

**Cocobola.** The wood of the hardwood tree *Dalbergia retusa*, of Central America, also known as Honduras rosewood. It is a beautiful wood, extremely hard, and very heavy with a weight of 75 to 85 lb per cu ft. It has orange and red bands with dark streaks and takes a fine polish. The thick sapwood is hewn off before shipment, and the heartwood logs are usually not more than 18 in. in diameter. The commercial wood comes from Panama and Costa Rica, and is used for canes, turnery, inlaying, scientific instrument cases, and knife handles. Cocos wood, also called Cocoaewood and West Indian ebony, used chiefly for inlaying, is from the tree *Brya ebenus* of tropical America. The sapwood is light yellow, and the heartwood is brown streaked with yellow. The grain is dense and even, and the wood is hard.

**Coconut oil.** The oil obtained from the thick kernel or meat adhering to the inside of the shell of the large nuts of the palm tree *Cocos nucifera* growing along the coasts of tropical countries. The tree requires salt air, and inland trees do not bear fruit unless supplied with salt. The name coco is the Carib word for palm. Copra is the dried meat of the coconut from which the oil is pressed. The dried copra contains 60 to 65% oil. It is an excellent food oil, and is valued as a shortening for crackers, but its use for margarine has declined. It is also valued for soaps because of its high lathering qualities due to the large percentage of lauric and myristic acids, though these acids are irritating to some skins. It is also employed as a source of lauric acid, but lauryl alcohol is now made synthetically. Coconut oil was once the chief illuminating oil in India, and the oil for burning was exported under the name of Cochin oil. This oil was cold-pressed and filtered and was water-clear. Coconut oil has a melting point of 27 to 32°C, specific gravity 0.926, saponification value 251 to 263, and iodine value 8 to 9.6. It contains 45 to 48% lauric acid, 17 to 20 myristic, 10 capric, 5 to 7 palmitic, up to 5 stearic, and some oleic, caprylic, and caproic acids.

In sun-drying coconut meat to make copra there is a loss of some of the oil, sugars and other carbohydrates, and some proteins. The oil from copra contains more free fatty acid than that from fresh

dried coconut and is rancid, requiring neutralization, decolorization, and deodorization. The meal and cake are also dirty and rancid but are useful for animal feed or fertilizer. Dehydrated coconut meat gives a better yield of oil and is not rancid. The copra cake of India is called Poonac. The chief production of copra and coconut oil is in southern Asia, the East Indies, the Philippines, and in the South Sea Islands. About 5,000 coconuts are required to produce a metric ton of copra, and the average yield of crude oil is 63%. The stearine separated from crude coconut oil by the process of wintering is known as Coconut butter and is used in confectionery. It has a melting point of 27 to 32°C. Hydrogenated coconut oil is a soft solid with a melting point of 45°C. Desiccated coconut, produced by oven drying or dehydration of the fresh coconut meat, is used shredded as a food and also powdered in many bakery products as a food and stabilizer. It has high food value, containing not less than 60% oil, 15 carbohydrates, 14 cellulose, 6 to 7 protein, and various mineral salts and considerable vitamin B. It is easily digested and has antitubercular value, but its characteristic coconut flavor is not universally liked.

**Coffee.** The seed berries, or beans, of the Arabian coffee tree, *Coffea arabica*, the Liberian coffee, *C. liberica*, and the Congo coffee, *C. robusta*, of which the first species furnishes most of the commercial product. The coffee bean contains the alkaloid caffeine used in medicine as a stimulant and in soft drinks, but most of the commercial coffee beans are used for the preparation of the beverage coffee, with small quantities for flavoring. The alkaloid is stimulating and is harmless in small amounts as it does not break down in the system and is easily soluble in water and thus carried off rapidly, but in large quantities at one time it is highly toxic. In the beverage it is partly neutralized by the sugar used. Coffee contains niacin, and also rubidium and other metallic salts useful in small quantities in the human system. The normal effect of coffee, due to the caffeine, is contraction of the muscles which relieves tiredness, but causes irritation as the muscles again relax.

The Arabian coffee plant is a small evergreen tree first introduced to Europe through Arabia. The first plants were brought to America in 1723, and the trees are now grown in most tropical countries. It requires a hot, moist climate, but develops best at higher altitudes.

There are numerous varieties, and the coffee beans also vary in aroma and taste with differences in climate and cultivation. The Liberian and Congo species, grown on the west coast of Africa, are more hardy plants, but the coffee is different in aroma and is used only for blending. Mocha coffee and Java coffee are fragrant varieties of the Arabian coffee. The fruits are small fleshy berries containing two greenish seeds. They are dried in the sun, or are pulped by machine and cleaned in fermenting baths and oven-dried. After removal of the skin from the dried beans they are graded and shipped as green beans. The general grades are by shipping ports or regions with numbered grades or qualities. Coffee is always roasted for use. This consists in a dry distillation with the formation of new compounds which produce the flavor and aroma. The aroma is from a combination of aldehydes, alcohols, and phenols. Coffee-Captan, of Cargille Scientific, Inc., is alpha-furfural mercaptan, one of the ingredients of coffee. It is a water-white liquid used in masking agents, and is a good vulcanization agent for rubber.

Brazil produces about half of all coffee. In blending, Brazilian coffee is the base for most blends, Medellin coffee from Colombia is used for rich flavor, Mexican Coatepec for winey flavor, San Salvador for full body, Costa Rican for fragrance, and Arabian mocha for distinctive flavor. Chicory, which is used extensively in Europe for blending with coffee, is the dried, roasted, and ground root of the perennial plant *Cichorium intybus*, native to Europe and growing wild in the United States. It is cultivated in the Central states. From 5 to 40% chicory may be used in some blends of coffee. It gives a taste preferred by some.

**Coir.** A fiber by-product of the coconut industry. The fiber is retted from the outer husks, hammered with wooden mallets, and then combed and bleached. The coarse and long fibers are used for brushmaking, the finer and curly fibers are spun into coir yarn used for mats, cordage, and coarse cloths. In the West Indies it is mixed with sisal and jute to make coffee-bag cloth. In the Pacific islands it has been used with cement to make a hard-setting, lightweight board for siding. In India Coir fiberboard is made by bonding with shellac, pressing, and baking. The boards are hard and have a good finish. Coir is easily dyed. The Ceylon coir yarn is sold in two

quality grades, Kogalla and Colombo, with subdivisions according to the thickness and texture. The yarn is properly called coir, and the harsh brush fiber is best known as Coconut fiber. Coir yarn averages 330 meters per kilogram. The Indian yarn is in 450-yd lengths tied into bundles. A hundred nuts yield 17 or 18 lb of fiber. Coconut shell, a by-product of the copra industry, is used for making activated charcoal and for Coconut shell flour used as a filler in molded plastics. It has a composition similar to walnut shell, being chiefly cellulose with about 30% lignin, 17 pentosan, and 5 methoxyl.

**Coke.** The porous, gray, infusible residue left after the volatile matter is driven off of bituminous coal. The coal is heated to a temperature of 1200 to 1400°C, without allowing air to burn it, and the volatile matter expelled. The residue, which is mainly fixed carbon and ash, is a cellular mass of greater strength than the original coal. Its nature and structure make it a valuable fuel for blast furnaces, burning rapidly and supporting a heavy charge of metal without packing. Soft, or bituminous, coals are designated as coking or noncoking, according to their capacity for being converted into coke. Coal low in carbon and high in ash will produce a coke that is friable and not strong enough for furnace use, or the ash may have low-melting constituents that leave glassy slag in the coke. Coke is produced in the beehive and by-product ovens, or is a by-product of gas plants. One ton of coal will yield an average of 0.7 ton coke, 11,500 cu ft gas, 12 gal tar, 27 lb ammonium sulphate, 50 gal benzol, 0.9 gal toluol and naphtha, and 0.5 lb naphthalene. The fixed carbon of good coke should be at least 86%, ash less than 12%, and sulphur not more than 1%. The porosity may vary from 40 to 60%, and the apparent specific gravity should not be less than 0.8. A Foundry coke should have an ignition point of about 1000°F, with sulphur below 0.7%, and the pieces, screened to above 2½ in., should be strong enough to carry the burden of ore and limestone. Semicoke and Smokeless fuel are coals carbonized at low temperatures and briquetted for household use. Coalite is an English name for fuel of this type, and Carbolux is a French household coke. The smokeless coalite of Japan is made by distilling at not over 700°C. The gas yield is less, but the gas has higher calorific value. The by-product liquids obtained are three times greater than in coke making, and the

tar contains more lighter fractions. The coalite is a better fuel than coke. Carbonite is a natural coke found in England and in Virginia, used as a fuel. It is a cokelike mineral formed by the baking action of igneous rocks on seams of bituminous coal. Petroleum coke is the final residue in the distillation of petroleum, and forms about 5% of the weight of the crude oil. The chipped coke has the sand and impurities removed, and is about 99% pure carbon. It is used for making arc carbons and carbon-molded products.

**Cold-molded plastics.** Materials used for molding mechanical and electrical parts under simple pressure. No chemical transformation takes place as with the synthetic molding resins. They are usually mineral resins or bituminous materials such as gilsonite, with fillers, and with drying oils or driers, and the color is normally black. The fillers may be silica, talc, kaolin, or asbestos fibers, to add strength and heat resistance, and they may be as high as 80% of the total. The plastics may withstand temperatures up to as high as 600°F, although the melting point of the original bituminous binder may be little above 200°F. The plastics are insoluble in water, good electrical insulators, acid-resistant, heat-resistant, but usually much weaker in strength than synthetic molded plastics. Synthetic resins that cure with catalysts may be molded cold, but are not ordinarily classed with these. Plastics of the cold-molded type are Aicc, of the American Insulator Co.; Ebrok, of the Richardson Co.; Okon, of the American Hard Rubber Co.; and Thermoplax, of Cutler-Hammer, Inc.

**Cold-rolled steel.** Low-carbon, open-hearth steel that has been worked into strips, sheets, or bars by cold rolling. The carbon content is usually from 0.08 to 0.12%, with manganese from 0.30 to 0.80%. After the regular hot rolling has been completed, the steel is annealed and pickled, and then passed cold through finishing rolls which smooth and polish the surfaces and increase the hardness and tensile strength. Only a slight reduction is made by cold-rolling sheet steel. For the making of cold-rolled strip steel the slabs after hot rolling are sheared to length, then hot-rolled into strip which is wound on a coil. The coils are recoiled to loosen the scale, pickled, rolled in breakdown mills, and annealed. The cold rolling is then accomplished until the desired hardness is obtained. It is usually in four tempers, but sometimes in six, from No. 1, hard, to No. 6, dead soft.

Dead-soft steel is for severe drawing and cupping work. It has a minimum tensile strength of 37,500 psi and an elongation 40%. Medium soft, or quarter soft, is for forming or light drawing. The minimum tensile strength is 42,500 psi, with elongation 20%. Medium-hard, or half-hard, is for bending at sharp right angles across the grain. The tensile strength is 50,000 psi. Hard-rolled is for flat work and easy punching. The tensile strength is 55,000 psi, and elongation 5%. Specifications for cold-rolled sheet steel for automobile bodies call for less than 0.14% carbon, under 0.60 manganese, and under 0.045 each of sulphur and phosphorus. The average tensile strength of the normalized sheet is 50,000 psi. Thinsteel is the trade name of the Cold Metal Products Co. for cold-rolled strip steel in thin gages made to very close accuracy. It comes in various tempers from dead soft to full hard in gages down to 0.001 in. Stain-stripe, of the Acme Steel Co., is cold-rolled steel with decorative designs rolled on. Cold-drawn steel is bar or rod steel that has been finished by cold drawing through dies. Cold drawing doubles the yield point of hot-rolled bars, and imparts a high finish. The tensile strength of commercial, low-carbon, cold-drawn steel is 70,000 psi and elongation 15%. Rycase is the name of a low-carbon, high-manganese, cold-drawn steel of Joseph T. Ryerson & Son, Inc., used for spindles to be casehardened. The tensile strength is 75,000 psi.

**Columbite.** An ore of the metal columbium. Its composition varies and may be  $\text{FeO} \cdot \text{Cb}_2\text{O}_5$  or  $(\text{FeMn})\text{Cb}_2\text{O}_5$ , or it may also contain tungsten and other metals. It is produced chiefly in Nigeria and marketed on the basis of the  $\text{Cb}_2\text{O}_5$  content. But columbium occurs more usually in combination with tantalum. The combined mineral known as Colombo-tantalite, mined in South Dakota and in the Belgian Congo, is marketed on the basis of the total  $\text{Ta}_2\text{O}_5 \cdot \text{Cb}_2\text{O}_5$  content, and as the tantalum increases and the specific gravity increases the mineral is called tantalite. Columbite concentrates containing about 60% columbium pentoxide,  $\text{Cb}_2\text{O}_5$ , are shipped in 100-kilo bags.

**Columbium.** An elementary metal, symbol Cb. It was called Niobium in Germany, with the symbol Nb. It occurs in the minerals columbite and tantalite and, as it closely resembles tantalum, is difficult to separate from it. Columbium has a fine yellowish-white color,

a specific gravity of 8.57, a melting point of  $2415^{\circ}\text{C}$ , tensile strength of 48,000 to 59,000 psi, annealed, and up to 130,000 psi in drawn wire. The electrical conductivity is one-eighth that of copper. It is ductile and malleable when pure, but slight amounts of impurities make the metal hard and unworkable. It can be machined readily with carbon tetrachloride as a cutting lubricant, but cold working makes it tough and springy. It is insoluble in most acids and not easily attacked by alkalis. The metal oxidizes in the air at about  $200^{\circ}\text{C}$ , but the adherent film of oxide prevents further oxidation. At high temperature it has the property of absorbing gases, which makes it useful as plate and grid metal in high-vacuum tubes, and its gas-absorbent properties are stronger than those of tantalum. The color of the metal is more attractive than that of tantalum, and it is used for watch cases and jewelry. It is also used in stainless steels in small amounts for inhibiting intergranular corrosion. In chromium steels it reduces air hardening, gives high impact strength, reduces creep, shortens the annealing time, and improves oxidation resistance. Small amounts, up to 1.5%, added to brass or copper alloys, make the alloys capable of retaining their temper hardness when exposed to high temperatures. Columbium metal is marketed in sheet, wire, rod, and powder. It also comes as Columbium oxide,  $\text{Cb}_2\text{O}_5$ , a white powder that melts at  $1520^{\circ}\text{C}$ , and as Potassium columbate,  $4\text{K}_2\text{O} \cdot 3\text{Cb}_2\text{O}_5 \cdot 16\text{H}_2\text{O}$ . Ferrocolumbium, for adding columbium to steel, is marketed as an alloy containing 50 to 60% columbium and 7 silicon. Columbium carbide,  $\text{CbC}$ , used for cutting tools in the same way as tantalum carbide, is an extremely hard crystalline material with a melting point of about  $3800^{\circ}\text{C}$ . It is made by sintering powdered columbium and carbon in a hydrogen furnace.

**Composite metals.** Sheet or plate metal having a face of special resistant metal welded to a base plate of lower cost metal. The term usually refers to steels, since the other composite metals are known as duplex metal or by other terms. The composite sheet metals are also called Armored metals. The term Composite tool steel usually refers to steel in bar form machined along the entire length and having an insert of alloy tool steel welded to the backing of mild steel. This type of steel is used for shear blades, die parts, and forming tools. Composite steel sheets are made by rolling together the two metals



to obtain the bond of adhesion, or by resistance welding to obtain cohesion. The sheets and plates are employed for making tanks, boilers, and chemical processing equipment where it is desired to have an acid-resistant or heat-resistant facing with the more easy working and lower cost of the plain steel plate. The normal thickness of the armor metal is 20% of the total thickness of the plate, thus saving in high-cost metals. A single-armor plate having an 18-8 stainless steel to a depth of 20% on one side saves 144 lb of chromium and 64 lb of nickel per 1,000 lb of total plate. A double-armor plate, with both sides to a depth of 20%, saves 108 lb of chromium and 48 lb of nickel per 1,000 lb of plate.

Pluramelt, of the Allegheny Ludlum Steel Corp., is composite steel with various types of stainless steels integrally bonded to a depth of 20% by a process of intermelting. Croloy, of the Babcock & Wilcox Co., is a bonded plate consisting of a thin sheet of stainless steel welded to a base plate of carbon-molybdenum steel, with a sheet of nickel welded between the two to prevent migration of the carbon. Ingaclad, of the Ingersoll Steel & Disc Co., consists of stainless steel bonded to carbon steel plate. Silver-Ply is a Stainless-clad steel of the Jessop Steel Co., made with a stainless coating either 10 or 20% of the thickness of the plate combined with the mild steel backing by hot rolling. Permaclad, of the Alan Wood Steel Co., has stainless steel bonded to one side of carbon steel. SuVeneer steel, of the Superior Steel Corp., used for automobile bumpers, has a veneer of stainless steel bonded to spring steel. Bronze-clad steel, of Ampco Metal, Inc., is sheet steel with high-tensile, corrosion-resistant bronze rolled on one or both sides. The cladding is from 0.031 in. up to 40% of the thickness of the sheet. It is used for tanks and chemical equipment. Copper-clad steel wire, marketed by the Copperweld Steel Co., for line wires, screens, and staples, has an electrical conductivity 40% that of an equal section of pure copper, and a tensile strength 250% higher than that of copper.

**Composition metal.** Also called Composition brass, although it does not have the characteristics of a true brass. A general name for casting alloys that are in a mid-position between the brasses and the bronzes. The most widely used standard composition metal is Ounce metal, containing 85% copper, 5 zinc, 5 tin, and 5 lead, which de-

rived its name from the fact that originally 1 oz each of the white metals was added to 1 lb of copper. It makes a good average bearing metal and, as it gives a dense casting that will withstand liquid pressures, is also used for valves, pump and carburetor parts. It casts well and machines easily, and takes a good polish, so that it is widely employed for general mechanical castings. It has about the same coefficient of expansion as copper, and can thus be used for pipe fittings. ASTM alloy No. 2 is this metal. It contains 84 to 86% copper, 4 to 6 zinc, 4 to 6 tin, and 4 to 6 lead, and may also contain up to 0.75% nickel and small amounts of iron, either as intentional additions to increase strength or as impurities. The minimum tensile strength is 26,000 psi, yield point 12,000 psi, and elongation 15%. Well-cast alloys may have strengths as high as 32,000 psi, with elongation 20% or higher, and Brinell hardness 50 to 59. The weight is 0.31 lb per cu in. This alloy is also called Red casting brass, Hydraulic bronze, and Steam brass, and has also been used for forgings, producing parts with a tensile strength of 33,000 psi and elongation 25%.

In the high-copper red casting-brass series, for any given content of copper and zinc, the higher the ratio of tin to lead the stronger but less ductile the alloy. The higher the content of zinc, the more ductile the alloy. For cast pipe fittings, the American Brass Co. advocates 80 to 86% copper, 4 to 15 zinc, 2 to 6 lead, and 3 to 6 tin. This type of alloy is called Valve bronze, and when the copper content is higher it is called Valve copper. It should cast readily without cracks, checks, or porous spots. The M bronze of the U.S. Navy, for valves, contains 86 to 91% copper, 6.25 to 7.25 tin, 1.5 to 5 zinc, 1 to 2 lead, and not over 0.25 iron. It has a tensile strength of 34,000 psi and elongation 17%. It will withstand continuous temperatures up to 500°F, while the 85-5-5-5 bronze can be used for temperatures only to 400°F. ASTM alloy No. 1, designated as high-grade red casting brass for general castings, contains 85% copper, 1.5 lead, 6.5 tin, and 4 zinc. It has a tensile strength of 36,000 psi, elongation 25%, and Brinell hardness 50 to 60.

Nickel is added to composition metals for hydraulic and steam castings to densify the alloy and make the lead more soluble in the copper. One company uses an alloy containing 84.5% copper, 5 lead, 7 zinc, 2.5 tin, and 1 nickel for casting injectors and lubricator parts.

The nickel is added to the melt in the form of nickel shot which contains 5 to 7% silicon to deoxidize the metal and increase the hardness. For heavy high-pressure hydraulic castings as much as 5% silicon may be added to alloys containing nickel, giving strengths above 40,000 psi. The alloys for machinery bearings usually contain higher proportions of tin or lead, or both, and are classified as high-lead bronze, but Johnson bronze No. 44, for bearings, contains 88% copper, 4 tin, 4 lead, and 4 zinc. The Hardware bronze used for casting hardware and automobile fittings to be highly polished and plated is likely to be a true copper-zinc brass or a leaded brass with only a small amount of lead. Oreide bronze, a term still used in the hardware industry, was the metal employed for carriage and harness hardware. It contains 87% copper and 13 zinc, and polishes to a golden color. The hardware bronze of the Chase Brass & Copper Co. contains 86% copper, 12.85 zinc, and 1.75 lead. Aluminum, even in small amounts, is not considered a desirable element in the red casting brasses as it decreases the ductility and requires more care in casting.

**Concrete.** A construction material composed of portland cement, sand, and gravel or broken stone, in the proportions 1 volume of cement to 2 of sand and 4 of stone, but these proportions are varied according to the strength and other qualities required. When hardened into massive structures, it is practically artificial rock. The quality of concrete is usually judged by its compressive strength. A rich mixture for columns and highly stressed structures is 1:1:3. A lean mixture used for some foundations is in the proportion of 1:3:6. After 28 days' setting, rich-mixture concrete should have a compressive strength of 2,800 psi, standard mixture 2,200 psi, and lean mixture 1,400 psi. The gradual increase in strength of concrete is due to the hydration of the tricalcium aluminates and silicates of the cement, and there should be a proper working time before the action begins. With a good grade of portland cement the initial set should not develop in less than an hour. The sand used in concrete was originally specified as roughly angular, but the rounded grains are now preferred. The stone is usually sharply broken. The weight of concrete varies with the type and amount of rock and sand employed. A limestone concrete will weigh about 150 lb per cu ft; the same mixture in trap rock may weigh 155 lb per cu ft.

Concrete blocks may be made from cement, sand, and gravel, or with cement and sand alone. For insulating purposes they may be made with cement and asbestos fibers. Careystone, of the Philip Carey Co., is cement with asbestos pressed into blocks, into corrugated slabs for roofing and siding, or into sheathing and wallboard. Reinforced concrete is a combination of concrete with a steel internal structure generally composed of rods or metal mesh. The strength of the concrete is thus greatly increased, and it is used for buildings, bridges, telegraph poles, roads, and fences. Nonslip concrete, for steps, is made by applying aluminum oxide grains, sizes 3 to 60 mesh, to the concrete before it hardens.

Insulating concrete and lightweight concretes are made by special methods, or by the addition of spongy aggregates. Slag may be used for this purpose. Aerocrete is a porous lightweight concrete produced by adding aluminum-bronze powder to the cement. The reaction between the flakes of metal and the lime in the cement forms hydrogen and causes bubbles. This concrete is a heat and sound insulator but is not strong. Haydite is a patented lightweight aggregate made by burning shale in a rotary kiln, which produces a material of expanded cellular structure. Haydite concrete weighs below 100 lb per cu ft, but is not as strong as gravel concrete. Superrock and Waylite are trade names for expanded aggregate made by treating molten slag with water or steam. Microporite is a German aggregate made by steam-treating ground silica and lime. Calicel, of the Keasbey & Mattison Co., is a lightweight spongy aggregate made by fusing silicates of lime and alumina and cooling to produce a stone of cellular structure. Fluftrök, of the Fluftrök Corp., is a lightweight aggregate made by heating obsidian in a kiln. The rock expands to 16 times its original volume, forming a porous material. Mixed with about 10% portland cement it is made into building blocks that are light and strong.

**Contact metals.** Metals used for contact points or surfaces for electrical apparatus. The qualities required are high electrical conductivity, corrosion resistance, and wear resistance. Because of its superior electrical conductivity and corrosion resistance, silver is preferred where great wear resistance is not needed. Fine silver, of 99.9% purity, is used widely as a contact facing, but where greater

hardness is required coin silver of 10% copper content is used. A harder Silver-copper alloy of 38% copper is used for commutator segments of small direct-current motors. Nickel brass is harder, cheaper, has good resistance to corrosion and wear, and the electrical conductivity is sufficiently high for push buttons and telephone contacts. Where high resistance to arcing is required tungsten is employed, but the conductivity is low. However, for high-speed equipment it is more important to have a heat-resistant metal than to have high electrical conductivity. An ordinary low-melting contact metal will last only about 25,000 contacts, while an aircraft magneto is required to make 36,000 sparks per minute, and a telegraph relay may operate 6 million times a day. Silver-tungsten alloys, made by powder metallurgy, combine the conductivity of silver with the arc resistance of tungsten, and are used for contacts. Silver-tungsten alloys of the Gibson Electric Co. contain 20 to 90% silver with hardnesses 80 to 100 Rockwell B and good conductivity. Gibsilo M-12 is a Silver-molybdenum alloy containing a high percentage of molybdenum, used for heavy circuit breakers subject to high arcing. Silver-graphite alloys, with low percentages of graphite, are used for contacts that require rubbing or sliding lubrication and for brushes and collector rings. Aeralloy, of the H. A. Wilson Co., is a Platinum-ruthenium alloy with high ruthenium content, used for aircraft magneto contacts. It is very hard and gives long wear life. Wilco No. 6 alloy, for automotive magneto contacts, is platinum hardened with ruthenium.

**Coolants.** Liquids employed for quenching steels in heat-treating, although this term is also used to designate the cutting oils used on machines to cool the work and improve the cutting. When water is used for the normal water-hardening steels, it may be modified with soda or other material to give a less drastic and more uniform cooling. A water bath containing 5% sodium hydroxide gives uniform rapid cooling. Oils are used in cooling or quenching baths for many alloy steels, as they remove the heat from the steel more uniformly and not as suddenly as water. Quenching oils are usually compounded, although fish oils alone are sometimes employed. Fish oils, however, have offensive odors when heated. Vegetable oils alone are likely to oxidize and become gummy. Animal oils become rancid. Lard and

palm oils give low cooling rates, while cottonseed, neatsfoot, and fish oils give more rapid cooling. Mineral oils compounded with fish, vegetable, or animal oils are sold under trade names and vary considerably in their content. Oil-quenching baths are usually kept at a temperature of not over 150°F by providing cooling pipes. Tempering oils differ from quenching oils only in that they are compounded to withstand temperatures up to about 525°F.

**Copal.** A general name for fossil and other hard resins found in nearly all tropical countries and used in making varnishes and lacquers, adhesives, and coatings. Copals are distinguished by their solubility in chloral hydrate. All of the copals are also soluble in alcohol, linseed oil, and in turpentine. The hardest and most prized varieties come from Africa. Zanzibar copal, from the tree *Trachylobium verrucosum*, or from species no longer existent, is one of the hardest of the varnish resins, with a melting point of 240 to 360°C, compared with 180 to 200°C for Congo copal from Guinea. Madagascar copal is from the tree *Hymenaca verrucosa*, and is darker than Zanzibar. Gum benguela is a semifossil resin from the tree *Gulbournia copaiifera* of West Africa. The melting point is 170°C. Many species of trees of the genus *Hymenaca* of tropical America furnish copals. The Brazilian copal known as Jutahycica resin is from the Jatahy tree which is plentiful in the Amazon Valley. Jatabó and Trapucá resins are fossil copals from species of *Hymenaca* of the state of Bahia, Brazil. Congo gum, chiefly from the tree *Copaifera demensi*, is the most insoluble of the natural resins but, after thermal processing, it is soluble in a wide range of solvents. The specific gravity of copals is from 1.04 to 1.13. The colors vary from white through yellow, red, brown, to brownish black.

The commercial copals are classed in five groups: East African, West African, Manila, East Indian, and South American. The name copal is applied in the East Indies to the resin of the tree *Agathis alba*, closely related to the Kauri pine. The types include Manila copal, Loba, and Boea. In Malaya the tree has been classed as *Dammara orientalis* and the copal is known as White dammar. In the Philippines the tree is called Almacido, and the gum, Manila copal. There are seven grades of Manila copal, from No. 1 pale, scraped chunks, to the No. 7 dust. Hard copal is harder than dam-

mar, and has a higher melting point, but the hardness of the resin depends greatly upon the seasoning time in the ground. The semi-hard and soft copals are produced directly from the trees by tapping. The melting point of a copal from *A. alba*, collected 1 day after tapping, averages 85°C, compared with 105°C when collected 3 months after tapping. Fossil copals of high quality and hardness are also obtained by separation from the low-grade coals of Utah. The copal, known as Copalite, has an amberlike appearance of light yellow to red color, with a specific gravity of 1.02 to 1.06, melting point 165°C, and hardness about the same as that of Congo gum. The coal yields about 5% gum.

**Copper.** One of the most useful of the metals, and probably the one first used by man. It is found native and in a large number of ores, but it is much less plentiful than nickel and some other metals. Its apparent plentifulness is only because it is easy to separate from its ores and is often a by-product from silver and other mining. The chemical symbol is Cu. It is yellowish red in color, tough, ductile, and malleable, gives a brilliant luster when polished, has a disagreeable taste and a peculiar odor. It melts at 1083°C and boils at 2310°C. The specific gravity is 8.91, and weight 0.321 lb per cu in. It is the best conductor of electricity next to silver, with a conductivity 92% that of silver. The coefficient of expansion is 0.000017 per deg C. The tensile strength of cast copper is from 17,000 to 20,000 psi with elongation 40 to 50%. Annealed wrought copper has a strength of 32,000 psi with elongation 56%, while cold-drawn copper has a tensile strength of 56,000 psi with elongation 6%. The Bus-bar copper used by the electrical companies has a tensile strength up to 40,000 psi. Copper does not have the ductility of brass for metalworking, but does not work-harden as rapidly as brass. Pure copper is difficult to cast, as the molten metal absorbs oxygen, forming oxides. Copper is used for electrical conductors, for making brasses and bronzes, for sheathing, fittings, pipe, and for cast articles. Small amounts of copper are added to some steels to give corrosion resistance.

More than half of all copper is sold in Wirebars of about 200 lb for rolling and drawing. About 25% of the copper used in the United States goes into electrical manufactures and about 15% into

electrical wiring. The United States produces more than half of all copper. Chilean and Belgian Congo copper are next in importance, but Peru, Canada, and other countries are important producers. Secondary copper is a term used to designate copper recovered from smelting scrap and old copper alloys. The production of secondary copper is about 40% that of new copper. Copper is marketed in three general grades: electrolytic, lake, and casting. Electrolytic copper has a purity not less than 99.9%.

Commercial wrought copper in bars, wire, sheets, and rods is marketed as Electrolytic tough pitch, Oxygen-free copper, Phosphorized copper, and Arsenical copper. Silver-bearing copper is 99.9% pure, carrying 8 to 30 oz of silver per ton. The silver raises the annealing temperature, and the metal is used for radiators and commutators. Electrolytic tough pitch, or High-conductivity copper, oxidized with phosphorus without residue and annealed, has an electrical resistance of 0.67879 microhm per in. cube at 20°C, which is taken as 100% conductivity. This copper has the disadvantage of becoming brittle when heated and of not giving a high finish. Much of the copper marketed for commercial use as copper contains slight amounts of silicon or other hardener, but even as little as 0.40% arsenic or other impurity will reduce the electrical conductivity drastically. Oxygen-free copper is 99.9% pure, has high conductivity, is not subject to brittleness, and will withstand much cold working. Phosphorized copper contains residual phosphorus. It has high strength, higher hardness and resistance to corrosion, but has lower conductivity. Anaconda condenser tubes of arsenical copper contain 0.25% arsenic. Lake copper, from the Lake Superior region, usually contains arsenic.

Hard-drawn wire or sheet arsenical copper has a tensile strength of 60,000 psi, while the annealed material has a strength of 32,000 psi and elongation 45%. Cast copper has only 80 to 90% the conductivity of wrought copper. A special grade of copper having high ductility, high conductivity, and fatigue resistance is made without melting by converting electrolytic cathode copper directly into rods and strips by rolling at elevated temperature in a reducing atmosphere. The Phelps Dodge Copper Products Corp. produces this copper under the name of PDCP copper. Electro-sheet copper is thin sheet copper produced by electrodeposition. It is marketed by the American Brass Co. in roll sheets of 1 to 7 oz per sq ft (0.0013 to



0.0094 in.), and is used for roofing and dampproofing. Rocan copper is a sheet copper of Revere Copper & Brass, Inc., having high strength and resistance to corrosion fatigue. It contains 0.50% arsenic. It is used for roofing and leaders. Roofing copper is hot-rolled soft copper sheet in 14- to 32-oz weights, but Cornice copper is cold-rolled to a hard temper. The 16-oz is used for gutters and leaders. Braziers' copper is a term used to designate heavy sheets of copper weighing from 1.5 to 6 lb per sq ft, used for coppersmiths' work. Coppersmiths' copper is hot-rolled, soft-temper, heavy sheets up to  $\frac{1}{2}$  in. Copper foil is sheet copper less than 0.005 in. in thickness. Free-cutting copper is deoxidized copper containing up to 0.70% tellurium, marketed in rods for making screw-machine products.

Cupaloy, of the Westinghouse Electric Corp., is nearly pure copper containing small amounts of silver and chromium, the chromium forming a hard crystalline structure and the silver acting as a stabilizer. When temper-hardened the wrought alloy has a tensile strength of 70,000 psi, elongation 15%, and Rockwell B hardness 80 to 85. It has 85% the electrical conductivity of copper. It is used for welding electrodes, commutator bars, and strong electrical parts. The Copper-silver alloy developed by the Army Signal Corps for high-strength electrical conductors contains 6.5% silver. Wire drawn to a tensile strength of 160,000 psi has a conductivity 70% that of copper. When drawn to a tensile strength of 116,000 psi, it has a conductivity 85% that of copper. Copper-iron alloy with 12.5% iron has a tensile strength of 150,000 psi and conductivity 50% that of copper. For this alloy magnesium is used as a deoxidizer in pouring the ingots at high temperature. Switch copper, of the Revere Copper & Brass, Inc., is electrolytic copper in shaped bars of close tolerance and burnished finish. It is used for switch blades and electrical parts. The minimum tensile strength is 36,000 psi, elongation 15% min, and Rockwell B hardness 35 to 65. Copper powder is usually chemically reduced copper in noncrystalline form. It is used in a liquid vehicle for copper coating, or for sintering. The powder produced electrolytically is flaked, suitable for pigment but not for sintering. Copper powder of the Nichols Copper Co. is 98.3% pure, and all particles pass through a 350-mesh screen. Copper powder in flake form for paint and ink pigment is produced by the Phelps

Dodge Corp. by electrolysis. The cathodes are coated with oxidized castor oil, and the deposited copper is in crystalline flakes easily reduced to a fine grade of red bronze powder by stamp milling. Copper shot is copper in the form of round globules, used chiefly in jewelry manufacture in alloying gold and silver. Leaded copper is copper in commercial rods and shapes containing a small amount of lead to make it free-machining. Copper is also marketed in the form of master alloys such as Copper aluminum, which is an alloy of 50% copper and 50 aluminum melting at 1070°F, used for making aluminum alloys.

**Copper acetate.** Also known as Crystals of Venus. A dark-green crystalline poisonous powder of the composition  $\text{Cu}(\text{CH}_3\text{COO})_2 \cdot \text{H}_2\text{O}$ , of specific gravity 1.882 and melting point 115°C. It is soluble in water and in alcohol. It is used as a pigment in paints, lacquers, linoleum, inks, and for making artificial verdigris or patina on copper articles. It is also used as a catalyst in making phthalic anhydride plastics. When used for mildewproofing cotton cloth, the copper precipitates out to form the Waxate, or copper soap coating. Verdigris is an old name for basic copper acetate as a blue-green pigment, but the name is now usually applied to the bluish-green corrosion crust on copper. The greenish-brown crust known as Patina, formed on bronze, is esteemed as a characteristic of antiquity. It is a basic sulphate of copper, usually with oxides of tin, copper, and lead. Another green copper paint pigment is Copper carbonate, also called Artificial malachite. It is a poisonous powder of the composition  $\text{CuCO}_3 \cdot \text{Cu}(\text{OH})_2$ , made by adding sodium carbonate to a solution of copper sulphate. The specific gravity is 3.7. It is insoluble in water.

**Copper ores.** There are about 15 copper ores of commercial importance, and these are widely distributed in almost all parts of the world. More than 40 countries produce copper on a commercial scale. The average copper content of ores, however, is usually low, and copper would be an expensive metal if it were not for the valuable by-products, silver, gold, nickel, and other metals. About 80% of the ores in the United States contain only 1.17 to 1.57% copper and are concentrated before smelting. The direct smelting ores average from 4.3 to 6.2% copper. The most important ore of copper is Chalcopyrite, also known as Copper pyrites and Yellow copper ore.

It occurs widely distributed, associated with other minerals, and may carry gold and silver. It is the chief copper ore in many parts of the United States, Canada, Chile, Africa, England, and Spain. Chalcopyrite is a sulphide of copper and iron,  $\text{CuFeS}_2$ , containing theoretically 34.5% copper. It usually occurs massive, with a hardness of 3.5 and a specific gravity of 4.2. The color is brass yellow, with greenish-black streaks. To obtain the copper, the ore is first smelted with enough sulphur to combine with all of the copper, producing a matte which is a mixture of  $\text{CuS}_2$  and  $\text{FeS}$  together with impurities. Air is then blown through the molten matte in a reverberatory furnace, converting the iron sulphide to oxide and the sulphur to sulphur dioxide. The remaining copper is cast into pigs which are called Blister copper, owing to its blistered appearance. Blister copper contains 96 to 99% copper, with various metals and arsenic and sulphur. It is not used commercially, but is refined in furnaces or electrolytically.

Chalcocite is another important ore. It is found in Montana, Arizona, Alaska, Peru, Mexico, and Bolivia. It is a Cuprous sulphide,  $\text{Cu}_2\text{S}$ , containing theoretically 79.8% copper. It usually occurs massive, but crystals are also found. The hardness is 2.5 to 3, and the specific gravity 5.5. It has a shining lead-gray color. Tennantite, or Gray copper ore, found in Colorado, Wyoming, and Montana, has the composition  $3\text{Cu}_2\text{S} \cdot \text{As}_2\text{S}_3$ , with sometimes antimony. When much of the arsenic is replaced by antimony it is called Tetrahedrite. Azurite, also called Blue copper carbonate and Chessylite, is a mineral found with other copper ores. It is a basic carbonate of copper,  $\text{Cu}(\text{OH})_2 \cdot 2\text{CuCO}_3$ , occurring in azure-blue crystals. Malachite, or Green copper ore, is an important carbonate ore,  $\text{Cu}(\text{OH})_2 \cdot \text{CuCO}_3$ , containing theoretically 57.4% copper. It has a bright green color, specific gravity 3 to 4, and hardness 3.5 to 4. Cuprite, or Red copper ore, is a cuprous oxide,  $\text{Cu}_2\text{O}$ , containing theoretically 88.8% copper. It occurs usually massive, but sometimes in crystals. The specific gravity is 6, and the hardness 3.5 to 4. The color may be various shades of red, with an adamantine luster in the clear crystalline form, or a dull earthy luster in the massive varieties. Cuprite is found in the copper deposits in Arizona, and is one of the ores in Chile, Peru, and Bolivia.

Bornite, also known as Horseflesh ore, Peacock ore, and Variegated ore, is an important ore of copper widely distributed and mined in

Chile, Peru, Canada, and the United States. It occurs in massive form, having a bronze color that turns purple on exposure. The composition is  $\text{Cu}_5\text{FeS}_4$ , having theoretically 63.3% copper. It has a metallic luster and a hardness of 3. Chrysocolla is a minor ore of copper occurring in the oxidized parts of copper veins of Arizona and New Mexico. It is a hydrous copper silicate of the composition  $\text{CuSiO}_3 \cdot 2\text{H}_2\text{O}$ . It occurs in compact masses with a specific gravity of 2 to 2.4 and a hardness of 2 to 4. The color is green to bluish. It was used as a green pigment by the ancient Greeks. Atacamite is an ore found in Bolivia, Arizona, and Australia. It is a copper chloride with copper hydroxide,  $\text{CuCl}_2 \cdot 3\text{Cu}(\text{OH})_2$ , generally found in confused crystalline aggregates, fibrous or granular. The hardness is 3 to 3.5, specific gravity 3.75, and the color may be various shades of green. The unique copper ores of Japan, called Kuromono, are complex sulphide-sulphate replacement minerals.

Much Native copper metal occurs in the Lake Superior region, particularly in Michigan, but it occurs irregularly and not in continuous veins. The Ontonagon boulder of native copper in the National Museum, weighing 3 tons, came from Michigan. A mass of native copper found in 1847 was 10 ft long and weighed 6 tons. The largest ever found weighed 18 tons.

**Copper oxide.** There are several oxides of copper, but usually the term refers to Red copper oxide, or Cuprous oxide,  $\text{Cu}_2\text{O}$ , a reddish crystalline powder formed by the oxidation of copper at high temperatures. It also occurs naturally in cuprite ore. The specific gravity is 6.0 and melting point  $1235^\circ\text{C}$ . It is insoluble in water but soluble in acids and alkalis. It is used in coloring glass and ceramics red, in electroplating, and in alternating-current rectifiers. Rextox, of the Westinghouse Electric Corp., is copper upon which a layer of copper oxide has been formed. Electric current will flow easily from the oxide to the copper, but only with difficulty from the copper to the oxide. It is thus used for transforming alternating current into pulsating direct current. Black copper oxide, or Cupric oxide,  $\text{CuO}$ , is a brownish-black amorphous powder of specific gravity 6.4 and melting point  $1065^\circ\text{C}$ . It is used for coloring ceramics green or blue. In its natural ore form it is called Tenorite. Copper hydroxide, formed by the action of an alkali on the oxides, is a poisonous blue

powder of the composition  $\text{Cu}(\text{OH})_2$  and specific gravity 3.37. It is used as a pigment.

**Copper-silicon alloys.** Silicon up to 6.7% is soluble in copper, and forms hard, strong alloys very resistant to corrosion. Above 3% silicon, the alloys are too hard for most uses. The plain copper-silicon alloys are used for springs. Manganese up to about 1% may be added to improve the working qualities, and the ratio of silicon to manganese is kept at 3:1. When hard-drawn these alloys can have tensile strengths up to 150,000 psi. Webert alloy, of the American Brass Co., contains small amounts of silicon and manganese, and is used for pressure die castings. The tensile strength is 85,000 psi. Arcoloy, of the American Radiator Co., is a casting alloy containing 97.25% copper, 2.63 silicon, 0.12 iron, and 0.01 phosphorus. Cusiloy A, of the Scovill Mfg. Co., has 95.5% copper, 3 silicon, 1 iron, and 0.5 tin. It is marketed in various forms, and the annealed wire has a tensile strength of 60,000 psi and elongation 50%. Herculoy 418, of Revere Copper & Brass, Inc., contains 96.5% copper, 3 silicon, and 0.5 tin. The tensile strength of the annealed sheets is 60,000 psi with elongation 50%, and of the cold-rolled sheet 85,000 psi, with elongation 10%. The weight is 0.308 lb per cu in., melting point 1820°F, but the electrical conductivity is only 8.1% that of copper. It is resistant to many chemicals, and is used as a structural metal in the chemical industries.

Alloys of this type but with lower silicon contents are softer and more ductile and are suited to cold heading, spinning, and drawing. Herculoy 419 has 2% silicon and 0.25 tin. Herculoy 421 has 1.5% silicon and 0.25 manganese. This alloy in annealed sheet form has a tensile strength of 38,000 psi and elongation 35%, while the cold-rolled sheet has a tensile strength of 60,000 psi and elongation 10%. The copper-silicon alloys are marketed in sheets, rods, bars, shapes, tubes, forgings, and ingots for castings. Both the silicon-tin and the silicon-manganese types are single phase, and the castings are dense and fine-grained, suitable for such uses as valves.

**Copper steel.** Steel containing about 0.25% copper and very low in carbon, employed for construction work where mild resistance to corrosion is needed and where the cost of the higher resistant chromium steels is not warranted. It is employed in sheet form for culverts,

ducts, pipes, and for such manufacturing purposes as washing-machine boilers. The copper neutralizes the corroding influence of the sulphur in the steel, and also aids in the formation of a fine-grained oxide that retards further corrosion. Copper is not added to unalloyed high-carbon steels because it causes brittleness and hot-shortness. When the carbon content is very low, the metal is in reality a Copper iron. Molybdenum in small quantities may also be added to give additional corrosion resistance, and the percentage of carbon may be raised to 0.40% when about 0.05% molybdenum is added. Toncan iron, of the Republic Steel Corp., has this composition, and has a tensile strength of 40,000 to 48,000 psi, elongation 32 to 40%, and weight 0.283 lb per cu in.

The copper-bearing iron specified for culverts by the ASTM contains not less than 0.20% copper and not more than 0.10% carbon, manganese, phosphorus, sulphur, and silicon as impurities. But up to 0.20% phosphorus in very low-carbon copper iron increases the corrosion resistance and the strength. The German corrosion-resistant copper iron known as Resista has 0.10% phosphorus with not more than 0.10% carbon. The tensile strength is up to 85,000 psi with elongation 20%. Cor-Ten, of the U.S. Steel Corp., is a structural steel containing somewhat more phosphorus with 0.30% copper, 0.5 chromium, 0.10 carbon, and 0.5 silicon. The tensile strength is 70,000 psi, elongation 22%, and the corrosion resistance is about five times that of plain carbon steel. Lyonore metal is an open-hearth steel of the Lyon Conklin Co. containing small amounts of chromium and nickel. In the low-alloy steels from 0.5 to 1.5% copper can be added as the copper graphitizes the free carbides, and these steels have excellent drawing characteristics and have a high fatigue limit. Yолоy, of the Youngstown Sheet & Tube Co., is a high-tensile, corrosion-resistant structural steel with 1% copper, 2 nickel, and up to 0.05 max carbon. The tensile strength is up to 90,000 psi, with elongation 30%. Copperoid is a plain copper steel of this company. Other copper-bearing steels are Cop-R-Loy, of the Wheeling Steel Co.; Apolloy, of the Apollo Steel Co.; Gohi iron, of the Newport Rolling Mill Co.; Newaloy, of the Newton Steel Co.; Beth-Cu-Loy, of the Bethlehem Steel Co.; Copper-Clude, of Spang, Chalfant & Co., Inc.; and Weircoloy, of the Weirton Steel Co. The Tri-Ten steel of the U.S. Steel Corp. is a manganese-nickel-copper

low-alloy structural steel balanced to withstand shock at low temperatures.

**Copper sulphate.** Also called Bluestone and Blue vitriol. An azure-blue crystalline lumpy material of the composition  $\text{CuSO}_4 \cdot 5\text{H}_2\text{O}$  and specific gravity 2.286. It is soluble in water and insoluble in alcohol. When heated, it loses its water of crystallization and melts at  $150^\circ\text{C}$ . It is used for wet electric-battery solutions, for copper plating, in dyestuffs, germicides, in coppering steel, and in various chemical processes. In its natural form, called Chalcantithite, it is a rare mineral found in arid regions and deposited from the waters in copper mines. It is produced commercially as a by-product in copper refineries, or by the action of sulphuric acid on copper or copper oxide.

**Coral.** A shiny, hard, calcareous material valued for jewelry, buckles, beads, and novelties. It is a growth composed of the skeletons of *Corallium nobile* and other species of aquatic protozoa. The structures are built up by these creatures into forms like leafless trees or shrubs, fans, mushrooms, or cups. White coral is common and not used commercially. The most valuable is the Red coral, a twiglike species that grows about 12 in. in height with thin stems. Pink coral and Black coral are also valued. Red and pink corals come from the Indian Ocean and off the coast of northeastern Africa. Black coral is from southeastern Asia. The red and black varieties are very hard and take a beautiful polish. The pink is softer, with a more delicate appearance, and is used for beads. The rate of growth of coral is very slow, the atolls, or coral islands, forming at the rate of about 0.010 in. per year. The gleaming white sand of tropical beaches called coral sand is usually not coral, but consists of the disintegrated limy skeletons of the seaweed *Halimeda opuntia*.

**Cordage.** A general term for the flexible string or line of twisted fibers used for wrapping, baling, power transmission, and hauling. Cordage fibers are any materials used for making ropes, cables, twine, and cord. In general, the cordage fibers are hard compared with those used for weaving into fabrics, but cotton and some other soft fibers are used for cord. Twine is cordage less than  $\frac{3}{16}$  in. in diameter, and composed of two or more rovings twisted together.

Rope is cordage made by twisting several yarns into strands, and then twisting the strands into a line. A cable is a strong rope, usually referring to the large sizes of special construction. Cord is an indefinite term for twine, but is, more specifically, the soft cotton twines used for wrapping. The term string is used for the weak cotton cords used for wrapping light packages. Seaming twines are made of flax fibers. Seine twine is a three-strand cotton twine with 2 to 56 plies per strand. Most of the Binder twine is made from sisal, but Indian twine is made from jute. Ramie fiber is used for marine twines. About 50% of American strong cordage is from Manila hemp, and about 30% from sisal. Manila hemp is very resistant to sea water. Sisal is used for the cheaper grades of rope, but it absorbs water easily. True hemp is considered a superior fiber for strong ropes. Untarred Hemp rope is used for elevator cables, and tarred hemp is employed for ship cables. Marine rope, used by the Navy, is almost entirely of Manila hemp. Most industrial rope is made in three strands and may be hard lay, medium lay, or soft lay.

Cordage fibers are also obtained from a wide variety of plants. Generally, after retting the fibers, the softer and finer fibers are separated out for use in weaving into fabrics and the harder and coarser fibers are marketed as cordage fibers. New Zealand hemp, or New Zealand flax, is a strong cordage fiber obtained from the leaves of the swamp lily, *Phormium tenax*, grown in New Zealand and in Argentina. The fibers are white, soft, and lustrous. One variety of the plant reaches a height of 16 ft and the other variety 6 ft. Olona fiber, grown in Hawaii and used locally for fishing nets, is from the plant *Touchardia latifolia*. The tensile strength is much greater than that of hemp, and it has great durability. Gravatá is a Brazilian name for the very long and resistant fibers from the leaves of the pineapple plant, *Ananas sagenaria*. The leaves of this species are up to 7 ft in length. The fiber known as Widuri of the East Indies is bast fiber from the tree *Calotropis gigantea* which yields the madar kapok. It has great strength and is resistant to sea water. It is used for ropes and fish nets. Agel fiber is from the stems and leaves of the Gebang palm of the Celebes where the various grades are used for sail cloth, rope, fishing nets, and the coarser fibers are woven into Bangkok hats. The fibers from the leaf stalks are fine and white. Caraguatá is a strong, highly resistant fiber from the plant



*Bromelia balanseae* of Paraguay. It was employed by the Indians for making hammocks, and is now used for cordage and burlap fabrics.

Synthetic fibers are also used for cordage. Nylon rope is about twice as strong as Manila rope, is lighter, and because of its property of stretching rapidly but recovering slowly it makes a desirable rope for lifting and towing, giving a smooth, shock-absorbing pull. Nylon ropes are used for airplane glider pulling and tugboat lines. The Saran rope, of the Plymouth Cordage Co., for chemical plant use is made of three strands of vinylidene chloride monofilament. The breaking strength is 70% that of manila rope, and it is flexible and chemical-resistant, but it is not recommended for temperatures above 170°F. Nylon and some other plastics have a tendency to fray in cordage, and may be coated with polyvinyl butyral to give abrasion resistance. Chemclad is Rayon cordage of the Carolina Industrial Plastics Corp., coated with polyvinyl chloride. Glass rope, woven from continuous filaments of glass fiber, is used for chemical and electrical applications where resistance to chemicals or electrical insulation is needed. It is strong, but is expensive and has low flexing strength. It comes in diameters from  $\frac{1}{4}$  to  $\frac{3}{4}$  in. Fiberglas cordage, of the Owens Corning Fiberglas Co., is marketed in diameters from  $\frac{1}{64}$  to  $\frac{1}{8}$  in. made of continuous filament or staple glass fibers. The  $\frac{1}{8}$ -in. untreated continuous filament cord has a breaking strength of 258 lb.

**Core oils.** Liquid binders used for sand cores in foundry work. The binder should add strength to the core, and should burn out after the metal is poured, so that the sand core will collapse. Linseed oil is considered one of the best binders, but it is usually expensive and may be mixed with cheaper vegetable oils or with mineral oil. In some cases fish oil or rosin is also used. Molasses, dextrin, or sulphite liquor may be included in prepared core oils. The specifications of the American Foundrymen's Association call for 50% raw linseed oil, 25 H grade rosin, and 25 water-white kerosene, with no fish oil. A good core oil should have a specific gravity of 0.9368 max, flash point 165 to 200°F, Saybolt viscosity 155 min, iodine number 154, and be of light color. However, any drying oil or semidrying oil can be used to replace all or part of the linseed oil. Perilla and corn oils are used, and core oils of linseed and soybean oil mixtures

have good strength. The liquor from sulphite pulp mills contains lignin and is used as a core binder. Glutrin, of the Robeson Process Co., is a core oil with sulphite liquor. Truline is a resinous binder in powder form marketed by the Hercules Powder Co. Uformite 580, of the Resinous Products & Chemical Div., Rohm & Haas Co., is a Core binder especially for aluminum sand cores. It is a modified urea-formaldehyde resin which bakes in the core at 325 to 375°F, and will break down in the core at temperatures above 450°F. Cycor 191, of the American Cyanamid Co., is a urea-formaldehyde resin in water solution for sand cores for short-cycle baking in an electronic oven.

**Cork.** The thick, spongy bark of a species of oak tree, *Quercus suber*, grown in Spain, Portugal, Italy, Algeria, Morocco, Tunisia, and to a limited extent in the United States. It is used for bottle stoppers, insulation, vibration pads, and floats for rafts and nets. About half of the cork used in the United States is for insulation corkboard, and 25% for crown bottle tops. The scrap cuttings are used for refrigerator insulation, packing for the transportation of fruits, and for the manufacture of linoleum and pressed products. When marketed as Granulated cork, this material usually comes in sizes of 1/2 in. and No. 8 mesh. Cork is also used natural or in the form of pressed compositions for gaskets, oil retainers, roll coverings, polishing wheels, and many other articles. The material has a cellular structure with more than 50% of the volume in air cells. The cell structure is peculiar, and each cell is in contact with 14 neighboring cells, and because of lack of capillarity it does not absorb moisture. When dried, cork is light, porous, easily compressed, and very elastic. It is one of the lightest of solid substances, the specific gravity being 0.15 to 0.20. It also has low thermal conductivity, and is valued as an insulator in buildings and refrigerators. Charring begins at 250°F, but it ignites only with difficulty in contact with flame. The cork tree grows to a height of about 30 ft. After it has attained the age of about 25 years it can be barked in the summer, and this barking is repeated every 8 or 10 years. The quality of the bark improves with the age of the tree, and, with proper barking, a tree will live for 150 years or more. The thickness of the bark varies from 1/2 to 2 in. Cork bark is shipped in bales of 170 lb, and Cork wastes in bales of 148 lb.

Brazilian cork is the bark of the tree *Angico rayado*, called Pao

santo bark, and also from the trees *Piptadenia incuriale* and *P. colomurina*. The bark has a cellular structure and, when ground, has the appearance of a low grade of true cork, but is softer. It is suitable for insulation. The trees grow in northeastern Brazil, beginning to produce in 12 to 15 years, and reproducing in about 5 years. A substitute for cork for insulation packings and acoustical panels is marketed by the Palmetex Corp. under the name of Palmetex. It is the compressed pith from the internal fibers of the saw-tooth palm, *Cerano repens*, of the Eastern Gulf states. It has lower heat conductivity than cork, but without a binder it is more friable.

**Corkboard.** Construction board made by compressing granulated cork and subjecting it to heat so that the particles cement themselves together. It is employed for insulating walls and ceilings against heat and cold, and also as a sound insulator. Cork tile is corkboard in smaller, regularly shaped blocks for the same purposes. The natural gum in the cork is sufficient to bind the particles, but other binders may be used. Corkboard produced by the Armstrong Cork Co. is marketed in sheets in thicknesses from 1 to 6 in. The weight is from 6 to 10 lb per cu ft, depending upon the amount of compression and the binder. The heat conductivity is 0.304 Btu per hr per bd ft for 1°F difference in temperature between the sides, or about one-third that of wood. Corkboard retains the properties of cork, being cellular, and without capillarity or tendency to absorb moisture. Novoid corkboard, of the Cork Import Corp., is made with both large and small granules tightly packed to leave only small air spaces. Corinco corkboard is produced by the Cork Insulation Co. Joinite, of L. Munder & Son, Inc., is a corkboard for use under machinery to deaden vibration and noise. Corkoustic is a sound-absorbent cork board of the Armstrong Cork Co. for walls and ceilings. It has a sound-absorbing coefficient of 0.30 compared with 0.032 for brick walls. Linotile, of this company, is a resilient tile made of powdered cork, oxidized oils, and color pigments.

**Corn.** One of the most important food grains of the world for both human and animal consumption, but also used industrially for the production of starch, glucose, alcohols, alcoholic beverages, and corn oil. Corn was unknown to Europe before the discovery of America where it was one of the chief foods of the Indians from

Canada to Patagonia. In Europe and in foreign trade it is known by its original name of Maize, and the Incan name of Choclo still persists in South America for the grains on the cob. In Great Britain corn means all hard grains including wheat, and the American term corn is an abbreviation of the name Indian corn. Corn is the seed grain of the tall leafy plant *Zea mays* of which there are innumerable varieties or subspecies. It grows in temperate climates and in the high elevations of the tropics where there is a warm growing season without cold nights, but high commercial yields are limited to areas where there is a combination of well-drained friable soil, plenty of moisture, few cloudy days, and no night temperatures below 66°F during the growing season of 4 months. Corn is an unnatural plant, with seeds not adapted for natural dispersal; it does not revert to a wild species. It is a product of long selection. No wild plants have ever been found, but it is believed to have been a cultivated selection from the grass Teosinte of Mexico.

About half the world production of corn is in the United States and Argentina, but large amounts are also grown in southern Europe and northern India. About the end of the nineteenth century corn constituted 15% of the energy value of the American diet, but it has now decreased to less than 4%. The grains are produced in rows on a cob enclosed by leafy bracts. They are high in starch and in other food elements, and form a valuable stock feed especially for hogs and poultry. Nearly 90% of the commercial corn in the United States is for animal feed. But corn is one of the cheapest and easiest sources of starch, and much of the Argentine corn is used for starch and glucose. The average yield of corn grains is about 24 bu per acre, although yields as high as 50 bu per acre are obtained.

Sweet corn is a type of Soft corn, *Z. saccharata*, cultivated for direct eating and for canning. There are about 70 varieties grown widely on farms, but not cultivated for industrial applications. Pop corn, *Z. everta*, has very hard, small, elongated oval grains which, when heated, explode into a white, fluffy, edible mass without further cooking. It was used by the Indians as a food for journeys, and is now grown for food and confections. The corns cultivated for stock feeding and for starch and glucose are varieties of Flint corn, *Z. indurata*, and Dent corn, *Z. indentata*. Flint corn has long cylindrical ears with hard smooth grains of various colors. Dent corn has

larger and longer ears which are tapering, with white or yellow grains. About 300 varieties of dent corn are grown in the corn belt of the United States, while the Argentine corn is largely flint varieties which yield high starch. Much of the corn grown in the United States is Hybrid corn. This is not a species, but consists of special seed stocks produced by crossing inbred strains. It is resistant to disease, and gives high yields. The Waxy corn grown in Iowa produces a starch comparable with the root starches. In the wet milling of corn for the production of Cornstarch, the germ portion of the grain is separated as a by-product and used for the extraction of Corn oil, or Maize oil. The germ contains 50% oil which is a bright-yellow liquid of specific gravity 0.920 to 0.925, iodine value 120. It contains 43% oleic, 39 linoleic, 7 palmitic, and 3 stearic acids. About 1.75 lb of oil per bu of corn is obtained by crushing the germ, and another 1.4% is obtained by solvent extraction. About 1% of oil remains in the Corn oil meal marketed as feed. Corn oil is used as an edible oil as a substitute for olive oil and in margarine, and also in soaps, belt dressings, core oils, and for vulcanizing into factice. Corn sirup and glucose are produced directly from the starchy corns. Zein, of the Corn Products Refining Co., is a protein extracted from corn. It is dissolved in alcohol to form a lacquerlike solution which will dry to a hard, tough film. It is used as a substitute for shellac, and is more water-resistant than shellac. Corn tassels are used for livestock and poultry feed. They are a rich source of vitamins. About 270 lb of dry tassels are produced per acre. Cornstalks contain up to 11% sugars, usually about 8% sucrose and 2 other sugars, but little sugar is produced commercially from this source, the stalks being used as cattle feed. Corncobs are used to produce Cob meal for feeds, and also processed to produce lignin, xylose, furfural, and dextrose. Korn-Kob, of Kube-Kut, Inc., is granular corn cob used as an abrasive material for finishing metal parts in tumbling barrels. It is tougher than maple and will not absorb water like wood granules.

Kafir corn is a variety of sorghum grass not related to true corn. The plant is a tall annual with a stalk similar to corn but with smaller leaves and long cylindrical beardless heads containing small round seed grains. It is widely grown in tropical Africa, and a number of subvarieties are grown on a limited scale in Kansas, Texas, and Oklahoma. The grain is similar in composition to corn, but has

a peculiar characteristic flavor. It is used as flour in bread mixtures, and in biscuit and waffle flour.

**Corrosion-resistant alloys.** Any metals that offer resistance to corrosion, such as the alloys of the noble metals, the stainless steels, and the nickel-copper alloys, may be termed corrosion-resistant alloys, but the name usually refers to the highly alloyed, chemical-resistant chromium or chromium-nickel ferrous alloys not otherwise specifically designated as stainless iron or steel. Many of these alloys are also heat-resistant, or resistant to scaling at high temperatures, and there is no real dividing line between the corrosion-resistant and the heat-resistant alloys. The high-chromium iron alloys are resistant to nitric acid and to sulphur attack.

The Chromium-iron alloys and the Chromium-nickel alloys give corrosion-resistant and acid-resistant properties within certain limits as defined by the stainless irons and steels. Other elements extend the range of these limitations. Molybdenum gives added resistance to hot oils. Copper neutralizes the corrosive effects of any sulphur present, and combines with the phosphorus to give an added corrosion-resistant element. It also graphitizes any free carbides and absorbs any oxygen present to form fine-grained oxides. With molybdenum in the alloy the copper content can be considerable without making the alloy brittle. Silicon gives resistance to acids except to hydrofluoric acid. The nickel gives strength to the alloys and prevents corrosion cracking. These alloys are white in color and take a brilliant polish even when the iron content is high, and they are thus valued for food-processing equipment. Those with some cobalt are more silvery in color, and have increased resistance. The use of chromium, nickel, and cobalt in ferrous alloys for acid resistance antedates the invention of the stainless steels. An old alloy under the name of Borchers's metal had 30 to 36% chromium, with nickel, cobalt, and sometimes molybdenum. Sideraphite was an iron alloy with a high content of nickel, and with copper and tungsten.

Most of the corrosion-resistant alloys are now marketed under trade names. Lebanon No. 34, of the Lebanon Steel Foundry, for resistance to sulphuric and hydrochloric acids, has 20% chromium, 30 nickel, 3.25 molybdenum, 5 copper, 3.25 silicon. The tensile strength is 72,000 psi and elongation 45%. One grade of Midvaloy,

of the Midvale Co., contains 60% nickel, 10 chromium, 2 tungsten, and 1.5 manganese. When cast, this alloy has a tensile strength of 65,000 psi and elongation 24%. Cooper alloy 531, of the Cooper Alloy Foundry Co., contains 10 to 14% chromium, 27 to 30 nickel, 3 to 4 each of molybdenum and copper, 0.10 max carbon, 0.5 to 0.8 each of silicon and manganese, and 0.4 to 0.6 antimony. The antimony forms an insoluble copper-antimony film that gives added resistance to hydrochloric acid. It is also highly resistant to nitric and sulphuric acids. Noncorrodite, of the Millbury Steel Foundry Co., is a high-chromium steel for castings. The silicon irons, containing high percentages of silicon, also form a group of corrosion-resisting metals much used for cast parts for chemical equipment.

Vitallium, an alloy of 65% cobalt, 35 chromium, and 5 molybdenum, originally used for surgical straps because of its noncorroding quality and high resistance to body acids and fluids, was adopted during the war for turbosuperchargers for military planes because of its resistance to hot gases at continuous temperatures of about 1500°F. This metal has good precision casting qualities. Eatonite, of the Eaton Mfg. Co., used for valve facings to withstand the corrosive action of hot gases and antiknock fuels, is a similar material but with tungsten instead of molybdenum, and part of the cobalt replaced by nickel. Stellite No. 21, of the Haynes Stellite Co., used for buckets for turbosuperchargers, contains 28% chromium, 6 molybdenum, 0.25 carbon, and the balance cobalt. At 1800°F it has a tensile strength of 32,900 psi. The high cobalt content in this class of alloy is now usually reduced by additions of titanium. An alloy used by the Germans to resist the hot gases of jet-propelled aircraft, under the name of Tinadure, contained 30% nickel, 15 chromium, 1.8 titanium, and 0.10 carbon. Chondure, for the same purpose, contained 12% chromium, 18 manganese, 1 vanadium, 0.20 nickel, and 0.5 carbon. Berlaloy contained 17% chromium, 15 nickel, 2 molybdenum, and 1.15 combined tantalum and cobalt.

**Corundum.** An extremely hard, crystalline mineral used as an abrasive. It is a natural aluminum oxide,  $\text{Al}_2\text{O}_3$ , usually containing some iron and lime as impurities. It is found in India, Burma, the Near East, South Africa, and in the states of Georgia and the Carolinas, but almost all of the commercial production is in South Africa.

The finest, clear, colored crystals are sorted out as gem stones, and the premium ore is the large crystal material left after the gem pickers have sorted for gem stones. This ore usually brings more than 50% higher price than the boulder chips. Small amounts are shipped in grain. The crude ore is washed, crushed, and graded. The hardness is about 8.8, specific gravity about 4, and melting point 1950°C. It has a high refractive index, and is next to the diamond in the passage of X rays. When pure the stone is colorless, but it usually contains metallic oxides, and the colors are white, gray, pink, yellow, brown, red, and blue. There are four grades to which all corundum shipped from South Africa must conform. South African government Grade A is over 92%  $\text{Al}_2\text{O}_3$ ; Grade B is 90 to 92%; Grade C is 85 to 90%; and Grade D is under 82%. In the United States the grain sizes for coarse grinding are 8 to 36 mesh, but most of the natural corundum is used for optical glass grinding in sizes from 60 to 275 mesh. Artificial corundum, or aluminum oxide made in the electric furnace, is purer, more uniform, and harder, and is preferred in the mechanical industries. The preference for corundum for Snagging wheels for grinding iron castings is because of the basal parting of the crystals which causes them to break at nearly right angles, giving new cutting edges. The crystals of corundum are prismatic, rhombohedral, pyramidal, and hexagonal. The word corundum is Hindu, and originally applied to gem stones. The Ruby is a red corundum colored with chromic oxide. The off-color reds in the rubies are also used for pivot-bearing jewels. The Sapphire is a blue corundum colored with titanic oxide. The deep cornflower blue is valued as a gem stone, and the pale stones are used for watch jewels. The Oriental topaz is a yellow corundum containing ferric oxide. The Indian sapphires of Mogok, Burma, Kashmir, and those of Ceylon, are famous as gems. The index of refraction of corundum is 1.77, and the dispersion factor is lower than that of the diamond so that these gems lack sparkle, but they are valued for their color and hardness. The Sintercorund, or sintered corundum, used by the Germans for making aircraft spark plugs, was not natural corundum, but was practically pure alumina fired at 1760°C.

**Cotton.** The white to yellowish fiber of the calyx, or blossom, of several species of plants of the genus *Gossypium* of the Mallow



family. It is a tropical plant, and the finest and longest fibers are produced in hot climates, but the plant grows well in a belt across southeastern United States and as far north as Virginia. It requires a growing season of about 200 days with an average summer temperature about 75°F and a dry season during the time of ripening and picking. Cotton was used in India and China in most ancient times, was described in Greece as a vegetable wool of India, but was not used in Europe until the early Middle Ages. All of the Asiatic species are short-staple, and the long-staple cottons are from species cultivated by the American Indians. Cotton has a wide variety of uses for making fabrics, cordage, padding, and for producing cellulose for plastics, rayon, and explosives.

There are many species and varieties of the plant, yielding fibers of varying lengths, coarseness, whiteness, and silkiness. Cotton fiber contains 88 to 96% cellulose, dry weight, together with protein, pectin, sugars, and 0.4 to 0.8% wax. Ordinary treatment does not remove the wax. When removed by ether extraction the fiber is stronger but is harsh and difficult to spin. The most noted classes are Sea Island, Egyptian, American upland, Brazilian, Arabian, and Nanking. Sea Island cotton, *G. barbadense*, was native to the West Indies, and named when brought to the islands off the American coast. It is grown best in hot moist climates, and is the longest, finest, and silkiest of the fibers. Its length varies from 1¼ to 2½ in., but it is cream-colored. Egyptian cotton, grown in Egypt and the Sudan, came originally from Peruvian seed. Peruvian cotton, *G. acuminatum*, is long-staple, silky, has strength and firmness, but is brownish in color. The Tanguis cotton from Peru is valued for fine English fabrics. Egyptian cotton, or Maco, is next in quality to Sea Island. The long staple is from 11⅛ to 13⅛ in., and the extra-long staple is over 13⅛ in. It has a fine luster and great strength. It also has a remarkable twist, which makes a strong, fine yarn. It is used chiefly in yarns for the production of fine fabrics, thread, and for automobile-tire fabrics. American-Egyptian cotton is grown in Arizona. The fiber has an average length of 15⅞ in., and has the same uses as the Egyptian. Upland cotton, *G. hirsutum*, is the species originally grown by the Aztecs of Mexico. It is whiter than Egyptian or Sea Island cotton, and is the easiest and cheapest to grow. There are 1,200 named varieties of this plant. The short-staple upland has

a fiber under  $1\frac{1}{8}$  in. in length, and can be spun only into coarse and medium yarns, but it is the most widely grown of cottons in the United States. Long-staple upland is from  $1\frac{1}{8}$  to  $1\frac{3}{8}$  in. in length. The common grades of cotton fiber in the United States vary in diameter from 0.0006 to 0.0009 in. Sea Island cotton fiber is as fine as 0.0002 in., compared with 0.001 in. for the coarse Indian cotton. The cotton of India, China, and the Near East is from *G. herbaceum*, and the fiber is short,  $\frac{3}{8}$  to  $\frac{3}{4}$  in., but is very strong.

In normal times, in spite of a surplus of cotton in the United States, the Indian cotton is imported for use in blankets and in hard fabrics. The Chaco cotton grown in Argentina is from Louisiana seed, and probably 70% of total world cotton is now grown from American upland seed although it varies in characteristics due to differences in climate and soil. The annual world production of cotton is about 30 million bales of 478 lb each. Cotton yarn is put up in 840-yd hanks, and the number, or count, of cotton yarn indicates the number of hanks to the pound. The No. 10 cotton yarn, therefore, will have 10 hanks, or 8,400 yd, to the pound.

Absorbent cotton is cotton fiber that has been thoroughly cleaned and the natural wax removed with a solvent such as ether. It is very absorbent and will hold water. It is marketed in sterilized packages for medical use. Cotton batting is raw cotton carded into matted sheets, and put up usually in rolls to be used for padding purposes. Cotton waste, used in machine shops for wiping under the general name of Waste, is usually in mixed colors, but the best grades are usually all white, of clean soft yarns and threads without sizing. It is very oil-absorbent. Comber waste consists of the lengths of fiber up to 1 in., and is not sold with the waste from yarns, but is sent to mills producing cheap fabrics. Cotton fillers, used as reinforcing materials in molding plastics to replace wood flour or other fibers, are made by cutting cotton waste or fabric pieces into short lengths. Filfloc, of the Rayon Processing Co., is cotton flock for this purpose; Fabrifil is cotton fabric cut into small pieces; Cordfil is cotton cord cut into very short pieces. They give greater strength to the molded product than wood flour. Acetylated cotton is a mildewproof cotton made by converting part of the fiber to cellulose acetate by chemical treatment of the raw fiber. Aminized cotton is produced by reacting the raw cotton with aminoethyl sulphuric acid in an alkaline solution. Amino

groups are chemically combined with the cellulose of the fiber. This cotton can be dyed with acid wool dyes, and it also absorbs metallic waterproofing agents more readily.

**Cotton fabrics.** Cotton cloth is made in many types of weave and many weights, from the light, semitransparent Voile, made of two-ply, hard-twisted yarn, and Batiste, a fine, plain-woven fabric, to the coarse and heavy canvas and duck. They may have printed designs, as in Calico which is highly sized, or have yarn-dyed plain stripes, plaids, or checks, as in Gingham, or have woven figures, as in Madras. Percale is a printed fabric similar to calico but with a higher yarn count. Swiss is a plain-woven, fine, thin muslin, stiff and crisp. Dotted Swiss is a very thin, transparent, plain-woven cotton with colored swivel or lappet woven dots. It is sized stiff and crisp. Dimity is a plain-woven, sheer fabric with ribs in the form of corded checks or stripes. It comes in white or colors. Organdy is a plain-woven, thin, transparent crisp fabric stiffened with shellac or gum, usually in delicate color shades. All of these are plain-woven. Poplin is a lateral-ribbed fabric, often mercerized. It is heavier than broadcloth. Rep has a rib produced by heavy warp yarns. Crash is a rough-texture fabric with effects produced by novelty yarns. Charmeuse in the cotton industry is a soft, fine, satin-weave fabric of Egyptian cotton used industrially as a lining material. Chambray is a plain-woven, lightweight cotton similar to gingham but with no pattern and a dyed warp and white filling. It is used for linings, shirtings, and dresses. Cotton damask is a type of jacquard figured fabric having warp sateen figures in a filling sateen ground or vice versa. The surface threads of the figures lie at right angles to those in the ground so that the light is diffusely reflected, causing them to stand out in bold relief. It is usually of coarse or medium yarns, 15's to 30's, and bleached and finished to imitate linen. Cotton crepe is a cotton fabric having a pebbled surface. The pebble is produced with sulphonated oil, lauric acid ester oil, or other soluble oil which is washed off after the treatment. When the word crepe is used alone, it usually signifies silk crepe. Domest is a warp-stripe cotton fabric similar to flannel, used for apparel linings. Venetian is a highly mercerized, stout, closely woven fabric with the yarn in reverse twist. It is used as a lining for hats, pocketbooks, and luggage. Cottonade is a

coarse, heavy cotton fabric made to look like woollens and worsteds in weave and finish, and is used for men's suit linings. Eiderdown is a cotton fabric of knitted soft-spun yarns, heavily napped on one or both sides. It is used for shoe and glove linings. Tarlatan is a thin cotton fabric with a net weave, heavily sized, used for linings.

Strex, developed by the U.S. Rubber Co., is an elastic full-cotton fabric that has 100% elongation without the use of rubber. It is made from yarn that has a twisting like a coiled spring. The fabric is used for surgical bandages, gloves, and wearing apparel. Glass cloth is a name given to cotton fabric made of smooth, hard-twisted yarns which do not lint, and is used for wiping glass. It may be of the type known as Sponge cloth, which is a twill fabric of nub yarn or honeycomb effect, or it may be of Terry cloth, which has a heavy loop pile on one or both sides. Another Wiping cloth for glass and instruments where a lint-free characteristic is important is made with a cotton warp and a high-tenacity rayon filling. It is a strong, soft, and absorbent. The Nun-Lint cloth of Rittenbaum Bros., Inc., for polishing glass and fine instruments, is a nonwoven fabric made by binding the cotton fibers with a plastic.

Twill is a fabric in which the threads form diagonal lines. Tackle twill, used for football uniforms, is also used in olive drab color for army parachute troop uniforms. It is a strong, snag-resistant fabric having a right-hand twill with a rayon warp and combed cotton filling. It is 8.5 oz per sq yd, 180-lb warp, and 80-lb filling. Cavalry twill is not a cotton cloth, but is of worsted or rayon twill woven with a diagonal raised cord. It is similar to Gabardine except that gabardine has a single cord and cavalry twill has a double cord. Bedford cord has the cord running lengthwise, and the cord is more pronounced than in cavalry twill. These three are usually woolen fabrics, but Parade twill is a mercerized cotton fabric of combed yarns, two-ply, with the fabric vat-dyed in tan. It is employed for work clothing. Foulard is a highly mercerized twill-woven cotton with a silky feel. It is plain or printed, and is used for dresses or sportswear. Cotton duvetyne is a twill-woven, mercerized cotton fabric with a fine nap that gives it a soft velvety feel. It is much used for apparel linings and pocket linings. Brilliantine is a lightweight fabric with a cotton warp and a twilled worsted filling, yarn-dyed. It is used for apparel linings.

**Cottonseed oil.** One of the most common of the vegetable oils, with about 5 billion pounds produced annually, of which 30% is produced in the United States. It is used primarily as a food oil in salad oils, margarine, cooking fats, and for sardine packing, but it also has a wide industrial use in lubricants, cutting oils, soaps, quenching oils, and in paint oils. The hydrogenated oil is widely used as a cooking grease. Its food value is lower than that of lard, but is often preferred because it is odorless and does not scorch. Cottonseed oil is expressed from the seed of the cotton plant, *Gossypium*, and is entirely a by-product of the cotton industry, its production depending upon the cotton crops. The yield of seed is 890 lb per 478-lb bale of cotton, and 100 lb of seed yields 15.5 lb of oil. When the seeds are crushed whole, the oil is dark in color and requires careful refining. The American practice is to hull the seeds before crushing. The oil is colorless, nearly odorless, and has a specific gravity of 0.915 to 0.921. Upland cotton seed contains about 25% oil, which has 40% linoleic, 30 oleic, and 20 palmitic acids. The residue is caked and sold as Cottonseed meal for cattle feed and fertilizer. About 900 lb of meal and from 450 to 620 lb of hulls are obtained per short ton of seed, the yield of hulls varying inversely with the yield of linters. The American oil has an iodine value up to 110, and a saponification value of 192 to 200. Egyptian and Indian oils are inferior in color, and the Indian oil has a fishy odor and a fluorescence. Cottonseed stearin is the solid product obtained by chilling the oil and filtering out the solid portion. It has an iodine value between 85 and 100, and consists largely of palmitin. It is used for margarine, soap, and as a textile size. Winter-yellow cottonseed oil is the expressed oil after the stearin has been removed.

**Cottonwood.** The wood of the large trees *Populus monilifera*, *P. deltoides*, and other species of the United States and Canada. It is a soft wood of a yellowish-white color and a fine, open grain. It is sometimes called poplar, or Carolina poplar, and Whitewood. The weight is about 30 lb per cu ft. The wood is easy to work, but is not strong and warps easily. It is used for packing boxes, paneling, and general carpentry. The *P. deltoides*, or Eastern cottonwood, used in paneling, has a specific gravity when kiln-dried of 0.43, a compressive strength perpendicular to the grain of 650 psi, and a shearing

strength parallel to the grain of 660 psi. This wood comes from the lower Mississippi Valley. Black cottonwood is from the large tree *P. trichocarpa*, of the Pacific Coast. The wood is used for boxes, excelsior, and pulpwood. It has a light color, uniform texture, and fairly straight grain. Swamp cottonwood, *P. heterophylla*, also called River cottonwood, grows in the Mississippi and Ohio River valleys. Balsam poplar is from the tree *P. balsamifera*, of the northeastern states. It is a soft weak wood used chiefly for containers and for making excelsior. The tree also goes under the Algonquin name of Tacamahac. The wood may be marketed as cottonwood even when mixed with aspen. It is an excellent paper-pulp material. The name cottonwood is also applied to the wood of the tree *Bombax malabaricum*, native to India, Burma, and Ceylon, which produces kapok. The wood is white in color, soft, and weighs about 28 lb per cu ft. It is much softer than cottonwood.

**Creosote.** Also called Dead oil and Pitch oil. A yellowish poisonous oily liquid obtained from the distillation of coal tar. It has the odor of carbolic acid, a specific gravity of 1.03 to 1.08, and a boiling point of 200 to 300°C. The crude Creosote oil is used as a wood preservative and as a harsh disinfectant. Creosote is also obtained in the distillation of pine wood tar, and is then a yellowish liquid with a smoky odor, a mixture of phenols and derivatives. Creosote oil contains the poisonous Acridine which may be separated out and used as an insecticide. The high distillates from pine-tar creosote oil may also be separated out and used for wood preserving. The higher distillates are used so that the impregnation in the wood will not be driven off by the sun. No-D-K, of the Tennessee Eastman Corp., is a wood-impregnating creosote of this class. Nevasota, of the Neville Co., is a refined creosote, with no crystals above 4°C, used for spray-coating wood. The distillation of wood also produces charcoal, gas, and Methyl acetate, a sweet-smelling liquid of the composition  $\text{CH}_3\text{COO} \cdot \text{CH}_3$ , and boiling point 54°C, used as a solvent for lacquers. Cresol, also known as Cresylic acid and as Methyl phenol, obtained in the distillation of coal tar, is a mixture of the three isomers of cresol,  $\text{CH}_3 \cdot \text{C}_6\text{H}_4 \cdot \text{OH}$ , and Xylenol,  $(\text{CH}_3)_2 \cdot \text{C}_6\text{H}_3 \cdot \text{OH}$ . The crude material is a brownish-yellow liquid solidifying at 11°C. It is used for making plastics, in ore flotation, in refining petroleum, in soap-

emulsion cutting oils as a disinfectant, and in medicine as a strong antiseptic such as Lysol which is a 50% solution of cresols in liquid soap. It is also used in the production of other chemicals. Ortho cresol is a colorless solid with a melting point of 30°C and a boiling point of 191.5°C. It is soluble in alcohol, but only slightly soluble in water. It is used in the manufacture of cumarones, disinfectants, and fumigants, and as a plasticizer. Meta cresol is a colorless to yellow liquid freezing at 12°C and boiling at 202.8°C. It is used in the manufacture of photographic developers, nitro cresols, disinfectant soaps, printing inks, paint and varnish removers, as a preservative in leathers, glues, and pastes, in the reclaiming of rubber, and in making synthetic resins, perfumes, and pharmaceuticals. Para cresol is a colorless solid melting at 36°C and boiling at 202.5°C. It is the least soluble of the cresols. It is used in the manufacture of cresotinic acid dyes, disinfectants, and pharmaceuticals.

**Crinoline.** A stiff fabric of very open weave, made of coarse cotton yarns and heavily sized. The weave is plain. It was originally made of horsehair and linen, and hence its name. Crinoline is bleached, or is dyed in plain colors, and is used industrially as a supporting medium for parts made of waxes or composition, or where a stiff coarse fabric is needed. Wigan is a cotton fabric similar to crinoline but more closely woven, used for interlinings and stiffening.

**Crotonaldehyde.** A straw-colored, inflammable, mobile liquid of the composition  $\text{CH}_3\cdot\text{CH}:\text{CH}\cdot\text{CHO}$ , with specific gravity 0.852 to 0.858, and boiling point 99 to 104°C. It is used as a solvent for resins, gums, and rubber, and in tanning leather. It is soluble in water, alcohol, benzol, and naphtha. Crotonaldehyde, also known as Crotonic aldehyde and Propylene aldehyde, has a pungent, suffocating odor and is a lachrymatory for tear gas. It is also used in city gas mains as a warning agent on the escape of poisonous fuel gas. One pound of crotonaldehyde per million cubic feet of air will awaken a sleeping person.

**Cryolite.** A mineral of the composition  $\text{Na}_3\text{AlF}_6$ , found in commercial quantities in Greenland, and used as a flux in the electric production of aluminum, in the making of special glasses and porcelain, as a binder for abrasive wheels, and in insecticides. For glass

batches 30 lb of cryolite is equivalent to 22.7 lb soda ash, 16.3 lb fluorine, and 11 lb aluminum hydrate. It acts as a powerful flux because of its solvent power on silicon, aluminum, and calcium oxides. In opal and milky glasses it forms a complex  $AlF_6$  anion, retaining the alumina and preventing loss of the fluorine. Cryolite occurs in masses of a vitreous luster, colorless to white, with a hardness of 2.5. It fuses easily. Kryalith, of the Pennsylvania Salt Co., is cryolite of 98 to 99% purity, and Kryocide is a grade of 90% purity. The latter is the dust from the natural ore, and is used as an insecticide. Synthetic cryolite is made by reacting fluorspar, boric acid, and a water solution of sulphuric acid to form fluoboric acid, which is then reacted with hydrated alumina and sodium carbonate to form cryolite and regenerate boric acid.

**Cryptostegia rubber.** Rubber obtained from the leaves of two species of perennial vines native to Madagascar, *Cryptostegia grandiflora* and *C. madagascariensis*. The former was grown in India, and the rubber was known as Palay rubber. It was brought to Mexico and Florida as an ornamental plant and now grows extensively in Mexico and the West Indies. The maximum rubber content is found in the leaves 3½ months old, at which time it is 2 to 3% of the dry weight of the leaf. There is also about 8% resin in the leaf which must be separated from the rubber as it makes it soft and tacky. The *C. madagascariensis* contains less rubber, but the leaves of hybrid plants grown from both species give increased yields of rubber. The hybrid does not come true to type from seed, and is propagated from cuttings. When extracted and separated from the resin, cryptostegia has the same uses as ordinary hevia rubber. Another plant that yields rubber from the leaves is the desert Milkweed, *Asclepias erosa*, *A. subulata*, and other species growing in the dry regions of Southwest United States. The short and slender leaves are produced only on the young stems and the gathering season is short. The dry leaves are ground, and the rubber is obtained by solvent extraction. The average rubber content is about 2%, but as much as 12% has been obtained from some species of wild plants. As with guayule and cryptostegia a considerable amount of resin is extracted with the rubber. Goldenrod rubber is extracted similarly from the leaves of the goldenrod, the dry leaves containing as much as 7% rubber



mixed with resin. The species which contains the most rubber is *Solidago leavenworthii*. It does not occur in the plant as a latex, but is in isolated globules in the cells, mostly in the leaf. The Milk bush, *Euphorbia tirucalli*, of Cuba and Jamaica, also produces rubber of good elasticity, but the crude latex from the bush causes skin blisters, and the extraction requires special treatment.

**Cumerone.** A colorless oily liquid of the composition  $C_8H_6O$ , employed in making synthetic resins. Cumerone occurs in the fraction of naphtha boiling between 165 and 175°C, and is isolated by acid treatment. The specific gravity is 1.096, and boiling point about 172°C. It has a characteristic odor, is insoluble in water, and is easily oxidized. Another product of a similar character is Indene,  $C_9H_8$ , a colorless liquid boiling at about 182°C that can be oxidized and polymerized readily. The Indene resins are classed with the cumerone resins, but they are lighter in color and are used in varnishes. The simple polymer, or di-indene resin, is a crystalline solid melting at about 58°C. The polyindene resins are made by polymerizing indene with ultraviolet light and oxygen. The Cumerone resins, which are polymers of  $C_8H_4 \cdot O \cdot CH:CH$ , made by the action of sulphuric or phosphoric acids on cumerone, are very soluble in organic solvents, and are used in lacquers, waterproofing compounds, molding, and in adhesives. The specific gravity of the molded resins is 1.05 to 1.15. They have high dielectric strength. Paracumerone, called also para-indene and Cumar gum, is a synthetic resin which is a copolymer of cumerone and indene. The grades vary from a soft gum to a hard brown solid, with melting points from 5 to 140°C. Varnishes made with it are resistant to alkalis. Nevindene, of the Neville Co., is a cumerone-indene resin of specific gravity 1.08 and melting point 10 to 160°C, used for compounding with rubber and synthetics. Nevilloid C-55 is a Cumerone-indene resin in water emulsion for coatings. It forms cohesive translucent films of slightly tacky nature. Blended with melamine resin it forms a clear and hard film. Cumar is the name of a cumerone-indene resin of the Barrett Co., but the name cumar has been applied to a range of pale yellow to reddish-brown coal-tar resins which are polymers of indene, cumerone, and other compounds, with melting points from 45 to 160°C. They are used in rubber compounding to increase tensile strength and tear resistance.

Piccoumaron resins of the Pennsylvania Industrial Chemical Corp. are paracumerone-indene thermoplastic resins produced by the polymerization of unsaturates in coal tar oils. They vary from light liquids to tacky solids with melting points from 10 to 120°C. The colors vary from pale yellow to reddish brown. They are resistant to alkalies, and are used in paints and waterproofings for concrete, and in adhesives for floor tile.

**Cupronickel.** Any alloy of copper and nickel, as nickel and copper form solid solutions in all proportions. Nickel and copper are found naturally alloyed in many copper mines, and as the two metals are difficult to separate the cupronickel alloys were among the first alloys used. They are ductile and malleable, are very corrosion-resistant, and have a maximum hardness at about 50% nickel. A 15% nickel alloy can be rolled from a thickness of 1½ in. to about 0.040 in. without intermediate annealing. Nickel whitens copper and gives the alloys a characteristic pinkish-white color sometimes called yellow, which can be whitened by the addition of small amounts of cobalt. At least 10% nickel is needed to obtain a nickel-white color, and this amount gives high corrosion resistance. Cupronickel with 2.5% nickel is used for the driving bands of shells, 15% nickel for bullet jackets and condenser tubes, and 25% for coinage. The higher nickel alloys are used for resistance wire, for corrosion-resistant equipment, and for parts where strength, toughness, and a white color without plating are required. For the latter use, however, the alloys contain other elements. When color is important, the alloys should not contain zinc because of the change in color by dezincification. Aluminum is also used as a whitener and hardener. An old formula for a silvery-white alloy for silverware, called Minargent, was for 100 parts copper, 70 nickel, 6 antimony, and 2 aluminum. The standard cupronickels are 5, 15, 20, and 30% nickel. Supernickel is a name given by the American Brass Co. to the 70-30 alloy for condenser tubes. This alloy and the 80-20 alloy are also marketed by the Revere Copper & Brass, Inc., for condenser tubes. The 70-30 alloy has a tensile strength, annealed, of 49,000 psi with elongation 50%, and when hard-drawn the strength is 75,000 psi with elongation 5%. The weight is 0.323 lb per cu in. Benedict metal is a white alloy used for condenser tubes, hardware, and chemical machinery parts.

It contains 85% copper, 14.5 nickel, and 0.5 other elements. The white alloy of the Scovill Mfg. Co. known as Adnic, used for valve diaphragms and parts for chemical equipment, has 70% copper, 29 nickel, and 1 tin. When hard-drawn it has a tensile strength of 113,000 psi and elongation 10%. The hot-rolled rod has a strength of 65,000 psi and elongation 45%. This is essentially the same alloy marketed by the Revere Copper & Brass, Inc., as Admiralty metal. Revere alloy 508, originally developed by the British Non-Ferrous Metals Research Association for condenser tubes, contains 88.5% copper, 10 nickel, and 1.5 iron.

Small amounts of silicon added to cupronickel form a nickel silicide that gives a Hardenable copper, which is the ancient tool material of the Incas. But, since the nickel is usually low in these alloys, they are not classed with the cupronickels. An alloy of this type marketed by the American Brass Co. under the name of Tempaloy contains 95% copper, 4 nickel, and 1 silicon. It is hard and strong, and can be forged or cold-rolled. Annealing by heating throws the nickel silicide into solid solution and produces a soft and ductile metal, which can be hardened again by holding at a temperature of 450°C for several hours. The tensile strength is from 50,000 to 150,000 psi with hardness above 200 Brinell. Small amounts of manganese and iron may be added to cupronickel to harden and strengthen the alloy. Davis metal, of the Chapman Valve Mfg. Co., for valves and fittings, contains 67% copper, 29 nickel, 2 iron, 1.5 manganese, and 0.5 carbon and silicon. The castings are hard and corrosion-resistant. Cufenium, a white alloy used as a base metal in tableware, contains 72% copper, 22 nickel, and 6 iron. Some chromium may be added for further corrosion resistance. Everbrite, of the American Manganese Bronze Co., has 60% copper, 30 nickel, 3 iron, 3 silicon, and 3 chromium. It is white in color, has a tensile strength, cast, of 75,000 psi, elongation 14%, and Brinell hardness 170. Cataract metal, of the Niagara Falls Smelting & Refining Corp., is the name of a series of cupronickel alloys containing small amounts of other elements. Copper-nickel alloy is the name used for the 75-25 and 50-50 cupronickel slabs, ingots, and shot used for adding nickel to brasses and bronzes. Federal specifications for copper-nickel alloy call for a minimum of 65% copper and 25 nickel with other elements allowable.

The high-nickel cupronickel alloys are very corrosion-resistant at high temperatures, and are used for electrical resistance wire and strip where the temperature does not exceed 1100°F. Lucero, of the Driver-Harris Co., is a 70-30 alloy, and Copel is a 55-45 alloy for resistance wire. The 55-45 alloy has an electrical resistivity of 294 ohms per cu mil ft, tensile strength, cold-drawn, of 140,000 psi. Because of its constant-temperature coefficient of resistance it was given the name of Constantan when used in low-temperature pyrometers. It has a high thermoelectric effect with either copper or iron, but cannot be used for high-temperature pyrometers as the melting point is 1290°C. Advance metal, of the Driver-Harris Co., and Cupron, of the Wilber B. Driver Co., are names for this alloy for pyrometer use.

**Curupay.** The wood of the tree *Piptadenia cebil*, native to Argentina, Paraguay, and Brazil. In northern Argentina and Paraguay it is also known under the Guaraní name Cevil. The wood is very hard and heavy, weighing 74 lb per cu ft, has a reddish color, and a handsome, wavy grain. It is used as an ornamental hardwood, and is much employed locally for construction. Another wood of the same order is Angico, from the *Angico rigida* of Brazil, also known as Queen wood and Angico vermelho. It is very hard, with a dense, close grain, a reddish-brown color, and weight of 70 lb per cu ft. It is employed where a heavy hardwood is required, and in cabinetmaking.

**Cutting alloys.** Nonferrous alloys used for cutting tools, as distinguished from alloy steels, although some may contain iron and be allied to the super high-speed steels. They may have a base of cobalt or nickel and they usually contain chromium and tungsten with enough carbon to form hard carbides. An early cutting alloy of this kind known as Cooperite contained 80% nickel with tungsten, molybdenum, and silicon. Stellite, of the Haynes Stellite Co., is made in two grades, 98M2 and Star J-metal for cutting tools. It contains high percentages of cobalt, chromium, and tungsten, about 2 of carbon, and small amounts of iron and molybdenum. The hard cutting properties are inherent in the alloy, and are not obtained by heat-treatment as in the steels. It retains its hardness at red heat. Stellite is silvery white in color, has a hardness of about 570 Brinell, and a tensile strength up to 130,000 psi. J-metal is a special high grade.

Delloy No. 6, of the Penn Rivet Corp., contains 43% cobalt, 33.4 chromium, 19.1 tungsten, and 2.7 carbon. It is marketed in standard tool bits. The tensile strength is 54,000 psi, compressive strength 325,000 psi, and hardness 61 to 64 Rockwell C. T and V alloy, of the Jessop Steel Co., has 45% cobalt, 32 chromium, 19 tungsten, and 2.4 carbon. These cast alloys have greater wear resistance than high-speed steel. Speedaloy, of the Tungsten Alloy Mfg. Co., is a cobalt-chromium-tungsten cast alloy for cutting tough alloy steels. Rexalloy, of the Crucible Steel Co., is another cast cobalt-chromium-tungsten cutting alloy. Steels of this cast type can be made with a boron content up to 1.5%, which gives increased hardness. Borcoloy, of General Aircraft Equipment, Inc., is a cobalt alloy with boron to give added hardness and wear resistance. Kutkost, of the General Tool & Die Co., is a cutting alloy containing boron marketed in the form of cast tool tips. Crobalt, of the Michigan Tool Co., is a cast alloy containing high cobalt and chromium, used for tools and wear-resistant parts.

**Cutting oils.** Oils used on cutting tools and on work being machined to aid in the cutting action. The chief object of the oil is to act as a lubricant between the tool and the work, decreasing the friction. These oils, therefore, are usually heavy oils or compounds distinguished from the thin solutions of soluble oils employed for flooding the work with the object of keeping it cool. However, the cutting oil also carries off much of the heat and enables the tool to stand up longer under the cutting action. There is no sharp dividing line between the cutting oils and the coolants which are designated in the mechanical industries as Soluble oils because they are generally used in the water solution. These soluble oils also have some lubricating action. Lard oil is a good cutting oil, but is seldom used alone because of its cost. It is mixed with mineral and vegetable oils, or with hydrogenated oils. The mineral-lard oils are used for machining copper alloys or for turning steel where a good surface finish is required. Lard oil mixed with kerosene is used for cutting aluminum and for monel metal. Ordinary mineral oils are used for light cutting operations and combine lubrication and cooling. For cutting brass, an emulsion of oil in soapy solution is often employed.

Sulphonated or Sulphurized oils are used for the tougher and harder brasses and bronzes, as the sulphur adds film strength to the

oil and also gives better penetration to the cutting edge. An oil of this nature is definitely also a soluble oil and is both a cutting oil and a coolant when it is in water solution. These soluble oils are made by treatment of an oil with sodium hydroxide or other alkali, either by direct mixture or by the addition of soaps to the oil. Oils thus treated emulsify readily because of the formation of sodium oleate and sodium palmitate, and they can be mixed with water in all proportions. The presence of sulphur is important for cutting action. Pine oil may be added to improve the odor. It also has a cleansing action. Cresol or other disinfectant is usually also added. Rosin or rosin oil may be added to improve cutting action.

Federal specifications for a compounded soluble oil permit a maximum of only 10% water, with no separation of the water in 24 hr at 75°F. The coolant known as Soda water in machine shops contains little or no oil and is a solution of soap and soda ash in water. It has a corrosive action, and also tends to wash out lubricant from the machine bearings. For 18-8 stainless steel and for high-carbon or alloy steels the sulphur-base oils are used as cutting oils, but highly sulphonated oils are not employed where there is reaction of the sulphur with the metals. Excel No. 60, of the Oil Products Co., Inc., is a high-sulphur fatty-acid oil for stainless steel. Antisep, of E. H. Houghton & Co., is a high-sulphur oil concentrate containing an anti-septic and a rust inhibitor. It is diluted with water for use. Cleartex, Sultex, and Transultex are sulphurized oils of the Texas Co. in different grades for the cutting of hard steels. Carbon tetrachloride mixed with turpentine in the proportion of 3 to 1 is used for hard chromium steels. A typical oil for screw cutting is made with 75% paraffin oil and 25 cottonseed oil. For cutting fine threads white lead mixed with a heavy oil may be used. Cutting compounds are marketed under many trade names. They may vary widely in composition, and may contain also antioxidants or inhibitors to prevent rancidity of the vegetable or animal oils used. The cutting lubricant marketed by the Acheson Colloids Corp. under the name of Aquadag is a solution of 22% colloidal graphite in water.

**Cuttle bone.** Also called Cuttlefish bone. A calcareous powder made from the internal shell of a Mediterranean marine mollusk of the genus *Sepia*, used as a fine polishing material for jewelry and in

tooth powders. Sepia is a dark-brown pigment made from the black secretion or inky fluid found in an internal ink sac of the *Sepia* mollusk. It is used in India inks of sepia or dark-brown color. The sepia fluid was formerly employed directly as a writing ink.

**Cylinder iron.** A general name for cast irons primarily designed for engine cylinders, pistons, and piston rings, but also used where a strong, hard, and wear-resistant iron is needed. Cylinder irons should be hard, close-grained, and be capable of casting readily without hard spots or holes. They should also have good heat conductivity, and copper may be added to increase the conductivity. A plain cylinder iron for internal-combustion engines contains 3 to 3.25% total carbon, 2 to 2.25 silicon, 0.40 to 0.75 manganese, and 0.12 max each of sulphur and phosphorus. But the cylinder irons now usually contain alloying elements. Nickel decreases the tendency of the low-silicon irons to chill in the thin sections, and also increases the strength. Some chromium is added to increase the strength and hardness, and molybdenum may be included to refine the grain and increase the strength. A low-silicon locomotive cylinder iron for 200 lb steam pressure has 1.25% nickel, 1 silicon, 0.60 to 1 manganese, and 3 total carbon. An outboard-engine cylinder iron contains 2% nickel and 0.50 chromium with a small amount of copper. A truck-engine iron containing 3% total carbon, 0.75 combined carbon, 2 silicon, 1.7 nickel, and 0.7 chromium, has a tensile strength of 38,000 psi and a Brinell hardness 229. High-grade cylinder irons with close grain and hardness of 185 to 210 Brinell in the bore have a range of 3.1 to 3.4% total carbon, 0.50 to 0.70 combined carbon, 1.8 to 2.4 silicon, 0.50 to 0.80 manganese, 0.25 to 1.5 nickel, 0.10 to 0.50 chromium, 0.10 to 0.70 molybdenum, 0.12 to 0.20 phosphorus, and 0.10 to 0.12 sulphur. They are made with about 20% steel scrap. The tensile strength is 35,000 psi.

**Cypress.** A number of different woods are called cypress, but when the name is used alone it is likely to refer to the wood of the Italian cypress, *Cupressus sempervirens*, native to the Mediterranean countries but now grown in the Gulf states and in California. This wood is light in weight, soft, light brown in color, and has a pleasant aromatic odor. It is very durable, and is used for furniture, chests, doors,

and general construction. Arizona cypress, *C. arizonica*, is a smaller tree, and the wood is used chiefly for fence posts. The wood usually referred to in the Eastern United States as cypress, and also as Marsh cypress, Red cypress, Bald cypress, Yellow cypress, Gulf cypress, and Southern cypress, is from the coniferous tree *Taxodium distichum*, and the Pond cypress is from *T. ascendens*, of the Southeastern states. Southern cypress grows along the coast from Delaware to Mexico, especially in Florida and the lower Mississippi Valley. The red cypress is along the coast and the yellow is inland, the coastal types being darker in color. The trees are sometimes very old, reaching a height of 120 ft in 800 years. The wood is yellowish red or pink in color, and is moderately hard with an open grain. The weight is about 32 lb per cu ft. It is very durable, and is valued for shingles, tanks, boatbuilding, or for construction where resistance to weather exposure is needed. The wood called yellow cypress on the West Coast, also known as Sitka cypress, Alaska cedar, and Yellow cedar, is from the tree *Chamecyparis nootkaensis*, or *Cupressus sitkaensis*, growing on the Pacific Coast from Alaska to Oregon. The trees reach 6 ft in diameter and 120 ft in height in 500 years. The heartwood is bright yellow, and the sapwood slightly lighter. The wood has a fine, uniform, straight grain, is light in weight, moderately hard, easily worked and polished, shock-resistant and durable. It is used for furniture, boatbuilding, and interior finish. The Monterey cypress, *C. macrocarpa* of California, is one of the chief trees planted on reforestation projects in New Zealand.

**Dammar.** Also written Damar. The resin from various species of trees of the genus *Shorea*, *Balanocarpus*, and *Hopea*, but the name is also applied to the resins of other trees, especially from the *Agathis alba*, the source of Manila copal. There is no dividing line between the dammars and the copals, and dammar may be considered as a recent or nonfossil copal, the Malay word damar meaning simply a gum. The best and hardest dammars are from deposits at the bases of the trees, which are then the seasoned or fossil resins like the copals. Dammar is obtained by tapping the trees and collecting the solidified gum after several months. It is used in varnishes, lacquers, adhesives, and coatings. The usual specific gravity is 1.04 to 1.12, and the melting point up to 120°C. The average grade of dammar does not have



a melting point much higher than 100°C. Dammar is a spirit varnish resin, gives a flexible film, but is softer and less durable than the copals. It is noted for its complete solubility in turpentine. It is also soluble in alcohol, and the Batavia and Singapore dammars are soluble in chlorinated compounds and in hydrocarbons. Dammar is classified according to color and size, the best grades being colorless and in large lumps. The high-grade pale-colored dammars from Batavia and Sumatra, including the so-called Cat's-eye dammar, are from species of *Hopea*. Most of the White dammar equivalent to Manila copal comes from Madagascar. It is semihard to hard, and is used in paints where resistance to wear is required, as in road-marking paints, but is not as hard as Congo copal. In general, the true dammars are from the *Shorea* and *Balanocarpus*, and they are inferior in hardness to the fossilized resins approaching the copals. The *Shorea* resins are usually dark in color. The Malayan black dammar, Dammar hitam, is from a species of *Balanocarpus*. The plentiful Dammar Penak is from the Malayan tree *B. heimii*, which also yields the important wood known as Chengal used for furniture and boatbuilding. Black dammar is from the tree *Canarium strictum*, of India, and comes in black, brittle lumps, easily ground to powder. The reddish Dammar sengai is also from a species of *Canarium*. These are types of elemi. Dewaxed damar, for making colorless, glossy lacquers, is highly purified damar marketed in xylol solution.

**Dandelion rubber.** The gum latex extracted from the roots of the Russian dandelion, which, when separated from the contained resin, has practically the same characteristics as the rubber from the hevea tree. Dandelion rubber, from various species of the dandelion genus, *Taraxacum*, chiefly the plants known as Kok sagyz, Tau sagyz, and Crim sagyz, native to Turkestan, is produced on a large scale in Russia. Because of the cost of production, the plant is grown only on a small scale in the United States and Canada. The roots, which extend 15 to 20 in. into the ground, contain up to 10% rubber after the plant has passed the first year flowering period. The normal yield is about 6% rubber with also considerable resin which must be separated before use of the rubber. The dry roots also contain a high percentage of Inulin,  $(C_6H_{10}O_5)_6 \cdot H_2O$ , which is easily convertible to sugar and to alcohol.

**Degras.** A brownish waxy fat of a faint disagreeable odor, obtained from the wool of sheep by washing, and used for leather dressing, as a rubber softener, in lubricating greases, in slushing oils, and for preparing lanolin. In crude form it is also called Wool grease. It contains Lanoceric acid,  $C_{30}H_{60}O_4$ , Lanopalmic acid,  $C_{15}H_{30}O_3$ , and about 25% of Lanosterol, a high alcohol related to cholesterol. Lanolin is the purified and hydrated fat, also known as Lanain, and in pharmacy as Lanum. In the cosmetics industry for use in toilet soaps, salves, and cosmetics it is termed Adeps lanae. The melting point is about  $40^{\circ}\text{C}$ . It is soluble in alcohol. Ceralan, of the Robinson-Wagner Co., is a waxlike material melting at  $55^{\circ}\text{C}$ , above which it becomes an amber-colored viscous liquid. It is a mixture of monohydroxyl alcohols, obtained by splitting lanolin, and contains 30% sterol, and free cholesterol. It forms water-in-oil emulsions, and is used in cosmetics as a dispersing and stiffening agent and as an emollient. Cholesterol is a white flaky material produced from lanolin and from fish meal. It is used as an emulsifier in drugs and cosmetics, and is a stable emollient. Amerchol L-101, of the American Cholesterol Products, Inc., is a liquid nonionic cholesterol containing other sterols. Wool grease from the scouring of wool was originally called Yorkshire grease. Moellon degreas is not wool grease, but is a by-product of chamois leathermaking. The sheepskins are impregnated with fish oil and, when the tanning is complete, the skins are soaked in warm water and the excess oil pressed out to form the moellon degreas.

**Denaturants.** Materials used chiefly for mixing with ethyl alcohol to be employed for industrial purposes to prevent the use of the alcohol as a beverage and to make it tax-free under the Tax Free Industrial Alcohol Act. The qualities desired in a denaturant are that its boiling point should be so close to that of the alcohol that it is difficult to remove by ordinary distillation, and that it should be ill tasting. Some of the denaturants are poisonous and cause death if the alcohol is taken internally. The usual denaturants are methyl alcohol, pyridine, benzene, kerosene, and pine oil. One or several of these may be employed, but denaturants must be approved by the Bureau of Internal Revenue. Completely denatured alcohol is a term used to designate alcohol containing poisonous denaturants, and these are

employed only for antifreeze, fuels, and lacquers, but not in contact with the human body. Special denatured alcohol is alcohol containing denaturants authorized for special uses, such as pine oil for hair tonics. Many approved denaturants are marketed under trade names. Denol is the name of a mixture of primary and secondary aliphatic higher alcohols. Agadite is a compounded petroleum product. Hydronol is a hydrogenated organic product. Denaturants are also used in imported oils that are permitted entry at lowered tax rates for industrial use so that they cannot be diverted for edible use. Rapeseed oil, for example, is denatured with brucine.

**Derris.** The root of various species of vines of the bean family, *Derris uliginosa*, *D. elliptica*, and *D. trifoliata*, growing in the East Indies. It is imported as crude root, and marketed as a fine powder of 200 mesh for use as an insecticide diluted with dusting clay to a rotenone content of 1%, or as a spray in kerosene or other liquid. The root contains Rotenone, a colorless, odorless, crystalline solid poison of complex composition,  $C_{22}H_{22}O_6$ , and melting point  $163^{\circ}\text{C}$ . The value of rotenone as an insecticide is that it is highly toxic to cold-blooded animals, including insects and worms, and nonpoisonous to warm-blooded animals. It is widely used as an agricultural insecticide as it is harmless to birds. It is about 30 times more toxic to cutting worms than lead arsenate. Rotenone is also found in many other plants, and when separated has the same toxic power. Cubé is the root of the vine *Lonchocarpus utilis*, of Peru, containing rotenone and used for the same purposes as derris. Timbó, also known as Urucú and as Tingi and Conambi, is the root of the vine *L. urucu*, of Brazil, also containing rotenone and used in the same manner. Barbasco is a name applied to timbó and all other fish-killing plants of the Orinoco Valley. The Caribs used the root either in shredded or in extract form for catching and killing fish. A cubic foot of root will poison an acre of water without harming the fish as food. Other plants of the same family are Nicou, Nekoe, and Haiari of the Guianas, and rotenone sometimes goes under the name of Nicouline. The high yield of rotenone from East Indian derris, up to 12%, is due to careful selection and propagation in cultivation, the semiwild roots of South America sometimes containing only about 2%. The Brazilian Government standard for timbó is 4% rotenone content.

From 1 to 4% rotenone is also obtained from the long leathery shoots of the perennial weed *Tephrosia virginiana*, known as Devil's shoestring, growing in Texas. Piperonyl butoxide is sometimes mixed with rotenone to give greater insect-killing power.

**Detergents.** Materials which have a cleansing action like soap. Although soap itself is a detergent, as are also the sodium silicates and the phosphates, the term usually applies to the synthetic chemicals, or Soapless soaps, which give this action. The detergents may be the simple sulphonated fatty acids such as turkey red oil; the Monopole soaps, or highly sulphonated fatty acids of the general formula  $(\text{SO}_2\text{OH})_x\text{R}\cdot\text{COONa}$ ; or the Gardinols, which are sulphonated fatty alcohols. All of the synthetic detergents are Surface-active agents with unsymmetrical molecules which concentrate and orient at the interface of the solution to lower interfacial tension. They may be Anion-active agents, with a positive-active ion; Cation-active agents, with a negative-active ion; or Nonionic agents. Most of the household detergents are anion-active, and are powders. Most of the nonionics are liquids, and are useful in textile processing since they minimize the difference in dye affinity of various fibers. The cationics have lower detergency power and are usually skin irritants, but they have disinfectant properties and are used in washing machines and dairy cleansers. They are called Invert soaps by the Germans. The synthetic detergents do not break down in the presence of acids or alkalies, and they do not form sludge and scum, or precipitate salts in hard waters like soap.

Detergents are widely employed in textile washing, metal degreasing, paper-pulp processing, and in industrial cleansing. They are also used in household cleansers, soapless shampoos, and tooth pastes. They are sold under a wide variety of trade names. The household detergent Dreft, of Procter & Gamble, is a fatty alcohol sulphonate. Nytron, of the Solvay Process Co., is a sodium sulphonate derived from petroleum hydrocarbons. It is a buff-colored powder. Surfax 1288, of E. F. Houghton & Co., is an aryl sulphopropionate with only slight detergent power, used in textile processing for rewetting and as a leveling agent for dye baths. Clavenol, of the Dexter Chemical Corp., is a polyethylene glycol condensate of the nonionic class. Irium is a name for Sodium lauryl sulphate,  $\text{C}_{12}\text{H}_{25}\cdot\text{SO}_4\text{Na}$ , when

used in dentifrice. It is a white powder made by reducing lauryl alcohol and sulphonating, the lauryl alcohol being produced either from lauric acid or from petroleum.

The largest percentage of the detergents are now produced from straight-chain paraffinic hydrocarbons derived from residues from petroleum cracking. Most of the detergents are alkyl aryl sulphonates,  $R \cdot Ar \cdot SO_3Na$ , or alkyl benzene sulphonates. The detergent characteristics vary with the number of carbon atoms in the alkyl chain and the arrangement of atoms in the chain. Detergency increases to a maximum at 12 to 15 atoms and then decreases. These detergents are 10 times as bulky as soda ash, but can be mixed with alkaline or phosphate cleaners. The German Igepons were made by esterifying oleic acid with isethionic acid and then saponifying. They were not stable in alkalies, but the more stable Igepon T had an amide linkage  $:CONH:$  to prevent breaking down by hydrolysis. The Germans produced fatty acids for synthetic detergents from the paraffin obtained in the hydrogenation of brown coal. The detergent sulphonates were then easily made by the action of sulphuric acid on the hydrocarbons that contain the double bond  $:CH:CH:$  or hydroxyl group  $:CHOH$ . The Isethionic acid used for the igipons has the formula  $HOCH_2-CH_2SO_3H$ , and has both alcohol and acid characteristics.

The Ultrawets, of the Atlantic Refining Co., Kamenol D, of the Kamen Soap Products Co., Oronite detergent of the Standard Oil Co. of California, and Santomerse of the Monsanto Chemical Co., are alkyl aryl sulphonates. This type of chemical is available in powder, bead, or paste forms, and one molecule in 40,000 molecules of water gives good detergency. The household detergent Surf, of Lever Bros., is an alkyl aryl sulphonate containing also phosphates. Lensex, of Shell Chemicals, is a sodium alkyl sulphate in a form of a paste for wool scouring.

**Dextrin.** Also called Amylin. A group of compounds with the same empirical formula as starch  $(C_6H_{10}O_5)_x$ , but with a smaller value of  $x$ . They have strong adhesive properties and are used as adhesive pastes, particularly for envelopes, gummed paper, and postage stamps, for blending with gum arabic, in pyrotechnic compositions, and in textile finishing. Dextrin is a white, amorphous, odorless powder with a sweetish taste. It dissolves in water to form a

sirupy liquid, and is also distinguished from starch by giving violet and red colors with iodine. Dextrin is made by moistening starch with a mixture of dilute nitric and hydrochloric acids, and then exposing to a temperature of 100 to 125°C. Dextrin varies in grade chiefly owing to differences in the type of starch from which it is made. British gum is a name given to dextrans that give high tack for paste use. Cartonite, of Paisley Products, Inc., is a liquid solution of a converted dextrin used as an adhesive in box-sealing machines. It is also marketed as a brown water-soluble powder.

**Diamond.** A highly transparent and exceedingly hard crystalline stone of almost pure carbon. When pure, it is colorless, but it often shows tints of white, gray, blue, yellow, or green. It is the hardest known substance, and is placed as 10 on the Moh hardness scale. But the Moh scale is only an approximation, and the hardness of the diamond is shown on the Knoop scale as 6,000 compared with 2,250 for boron carbide, which is 9 on the Moh scale. The diamond always occurs in crystals in the cubical system and has a specific gravity of 3.521 and a refractive index of 2.417. It has been valued since ancient times as a gem stone, but it is used extensively as an abrasive, for cutting tools, and for dies for drawing wire. These Industrial diamonds are diamonds that are too hard or too radial-grained for good jewel cutting. Jewel diamonds have the formation in regular layers, while industrial diamonds are grown in all directions. Technically these are called Feinig and nactig. Ballas diamonds, valued for industrial drilling, are formed with the crystallization starting from one central point. The stones thus formed do not crack in the tool as easily as those with layer formation. Stones for diamond dies are examined in polarized light to determine the presence of internal stresses. They are then drilled normal to the rhombic dodecahedron plane with cleavage planes parallel to the die-hole axis to obtain the greatest die-service life. The stones for industrial purposes are also the fragments and the so-called Bort which consists of the cull stones from the gem industry including stones of radiating crystallization that will not polish well. Bort also includes an amorphous variety of diamond in brown, gray, or black colors, known as Black diamonds, Carbonados, or Carbons, found in Brazil in association with gem diamonds. The carbons have no cleavage planes, are compact, and

thus offer greater resistance to breaking forces. The carbons vary greatly in quality and hardness. Diamond dust is a powder obtained by crushing the fragments of bort, or from refuse from the cutting of gem diamonds. It is used as an abrasive for hard steels, for cutting other stones, and for making Diamond wheels for grinding. Diamond powder is marketed in 16 standard grades by size of particle, the largest being 550 microns, and the smallest being 325 mesh, or 20 to 60 microns. There are also 8 grades of Diamond flour from 2 to 60 microns. Grit sizes for grinding wheels are 80 to 400. The coarse, No. 80, for fast cutting, has about 1,400 particles per square inch in the face of the bonded wheel. The best 400X powder is processed to give great uniformity of particle size to avoid scratching. Hyprez, of the Engis Equipment Co., is accurately graded diamond powder for fine polishing. The Dymo diamond powders of the Elgin National Watch Co., for fine polishing, are in 11 colors for easy selection of grades, from  $\frac{1}{2}$  micron to 100 mesh.

The value of diamonds bases on the gem value and is determined by color, purity, size, and freedom from flaws. The weight is measured in carats. Diamond splinters as small as  $\frac{1}{500}$  carat may be cut and faceted. The most valued gems are the blue white. A faint straw color detracts from the value, but deep shades of yellow, red, green, or blue are prized. Most of the diamonds come from South Africa, Brazil, India, and the Congo. The average diamond content of the Bushimaie deposits of the Belgian Congo is 5 or 6 carats per cubic meter. The diamonds are associated with pebbles of flint, jasper, agate, and chalcedony. About 50,000 diamonds have been found in Arkansas since the discovery in 1906. The average weight of the Arkansas diamonds is less than 1 carat, with the largest 40.22 carats. Some diamonds are found in the Appalachian region, the largest, from West Virginia, weighing 34.46 carats. Few of the American diamonds are of gem quality, but are of full hardness. The annual world production of diamonds is about 14 million carats, two-thirds of which are used for industrial purposes. The largest diamond found in Brazil, the President Vargas, was a flawless stone weighing 726.6 carats. It was cut into 23 stones. The famous Kohinoor diamond weighed originally 793 carats, and the Jonkers diamond from South Africa was a blue-white stone weighing 726 carats. The Cullinan diamond weighed 3,106 carats.

**Diatomaceous earth.** A class of compact, granular, or amorphous minerals composed of hydrated or Opaline silica, used as an abrasive, for filtering, in metal polishes and soaps, as a filler in paints and molding plastics, and for making insulating blocks and boards. In the portable drinking-water filters employed by the Army for tropical use the filtering medium was diatomaceous earth as it removes dysentery cysts and blood flukes as well as cleaning the water. Diatomaceous earth is formed of fossil diatoms in great beds and is not earthy, and a preferred name is Diatomite. In ground form it is sometimes referred to as Fossil flour. Tripoli and kieselguhr are varieties of crystalline diatomite. The American production of the mineral is mainly in Oregon, California, Washington, Idaho, and Nevada. After mining, the material is crushed and calcined. When pure it is white; with impurities it may be gray, brown, or greenish. The powder is marketed by fineness and chemical purity. The density is usually 12 to 17 lb per cu ft. Its high resistance to heat, chemical inertness, dielectric strength, and good surface finish imparted makes it a desirable filler for plastics. For insulating purposes, bricks or blocks may be sawed from the solid or molded from the crushed material, or it may be used in powdered form. Diatomite block has a porosity of 90% of its volume and makes an excellent filter. Celite, of Johns-Manville, is a 325-mesh uncalcined, amorphous diatomaceous earth for portland-cement mixtures, paper finishes, and for use as a flattening agent in paints. Diatomaceous earth is used in cement for fine ornamental detail work and for waterproofing. Sil-O-Cel, of this company, is insulating brick cut from diatomite. It will withstand temperatures up to 1600°F. Sil-O-Cel C-22 is calcined diatomaceous earth in powder form. It will withstand temperatures up to 2000°F. Superex, of the same company, is calcined diatomite powder bonded with asbestos fibers to resist temperatures up to 1900°F. Dicalite, of the Philip Carey Co., is a fine diatomite powder weighing 8 to 8.5 lb per cu ft loose, and 15 to 17 lb tamped, used for heat-insulating cement or as an insulating filler for walls.

**Die-casting metal.** Any alloy employed for making parts by casting in metal molds, or dies, in pressure-casting machines as distinct from other permanent mold castings where no pressure is used. The pressures may be as high as 5,000 psi, resulting in a dense structure in



the casting. The important groups of die-casting metals are aluminum base, zinc base, and copper base. Lead-base alloys are used, but mostly for casting ornaments and toys. Aluminum die-casting alloys are now largely silicon alloys with from 3 to 12% silicon, with or without copper, and with sometimes a small amount of magnesium. Some contain nickel for better color and higher strength and toughness. Additions of small amounts of tin improve machining and polishing qualities, but develop hot-shortness. An alloy with 95% aluminum and 5 silicon when die-cast has a tensile strength of 30,000 psi and elongation 7%. With 5% silicon and 4 copper the alloy has a strength of 40,000 psi, elongation 3.5%, and Brinell hardness 75. Alcoa 85, of the Aluminum Co. of America, is this alloy. Alcoa 218 has 8% magnesium and the balance aluminum. It has a tensile strength of 45,000 psi with elongation 8%. Reynolds alloy 13, of the Reynolds Metals Co., has 11 to 13% silicon with maximums of 0.5 nickel, 0.1 tin, 0.3 manganese, 0.8 iron, 0.6 copper, and the balance aluminum. The die castings have a tensile strength of 37,000 psi with elongation 1.8%. Reynolds alloy 380 has 7.5 to 9.5% silicon, 3 to 4 copper, 0.5 nickel, with small amounts of other elements. The tensile strength is 45,000 psi with elongation 2%. Aluminum-base alloy of the Milwaukee Die Casting Co., known as Ruselite, contains 94% aluminum, 4 copper, and 2 chromium and molybdenum. It has a whiter color and is very corrosion-resistant. The tensile strength is 30,000 psi with elongation 6%. An aluminum die-casting alloy of the Allied Die Casting Corp., known as Renyx, contains, in one grade, 91.5% aluminum, 4 nickel, 4 copper, and 0.5 silicon. It has good color and is resistant to corrosion. Renyx AZN is a zinc-base alloy containing 92% zinc, 4 aluminum, 3 copper, and 0.1 manganese. Alcoa 380 is an aluminum-base alloy with 8.5% silicon and 3.5 copper. It has a tensile strength of 45,000 psi, and elongation 2%.

The zinc-base alloys are not as strong as the aluminum-base alloys, but they require only a moderate casting temperature, are easily cast in pressure machines, are low in cost, and have good color that can be plated easily. They have a wide field of use, and the alloys are marketed in standard composition ingots under the name of zinc-base alloys or by trade names such as Zamak of the New Jersey Zinc Co. They usually contain about 4% aluminum, up to about 3% copper, with slight additions of magnesium or other elements. The mag-

nesium-base alloys are valued where light weight is essential. Alloy AM230, of the Aluminum Co. of America, is a magnesium alloy with 9 to 11% aluminum, 0.5 to 1 silicon, and 0.10 manganese. This alloy weighs 0.066 lb per cu in., and has a tensile strength of 31,000 psi. A typical copper-base alloy contains 64% copper and 36 zinc, and is a yellow brass. The tensile strength is 40,000 psi.

**Die steels.** Any tool steels used for dies. Originally, the term meant high-grade carbon steel with about 0.90 to 1% carbon that could be hardened to retain a keen cutting edge and not shrink or warp greatly in the hardening. Unalloyed tool steels are still widely used for many types of dies. They have the advantage of low cost and ease of machining. The modern tool steels of this kind are made to a high degree of uniformity, and the manganese and silicon contents are well adjusted to give depth of hardening and uniformity of grain structure. Typical of this type of steel is H-9 Extra steel, or Cold-heading die steel, of the Carpenter Steel Co. It contains 0.90% carbon, 0.40 manganese, and 0.40 silicon, and can be used for such severe service tools as coining dies, cold-heading dies, and knurls. Low-alloy steels with carefully adjusted alloy content are also widely used for dies for general purposes and are more easily machined and treated than the higher alloyed steels. A typical steel of this kind is Artdie steel of the Columbia Tool Steel Co. It contains 0.95% carbon, 0.30 chromium, 0.02 vanadium, 0.25 manganese, and 0.25 silicon. It is deep-hardening, and is used for production dies in the jewelry industry. The chrome-vanadium steels with about 1% chromium, 0.15 vanadium, with sometimes 0.45 tungsten, and 0.50 to 1 carbon are widely used for dies that require a high degree of hardness, toughness, and resistance to fatigue. These are usually SAE steel 6150 to 6195. Albany steel, of the Allegheny Ludlum Steel Co., is a steel of this type.

When the term die steel is now used alone, it is likely to refer to the pre-hardened die blocks of high-alloy steels for making forging, plastic-molding, and die-casting dies without subsequent hardening. Other die steels are more likely to be designated by the names for the specific types such as nondeforming steel, hot-die steel, wear-resistant steel, or vanadium steel. Die-block steels of this type, with high resistance to wear, having high chromium and high carbon, are also

used for molds or dies for pressing porcelain insulators and other ceramics. Airdi 225, of the Crucible Steel Co. of America, is an air-hardening die block steel with 12% chromium, 2.25 carbon, 1 molybdenum, and 0.25 vanadium. Airdi 110 is the same steel with only 1.1% carbon. It is easier to machine but is not as wear-resistant. Cromoco die steel, of the Firth Sterling Steel Co., has 12% chromium, 1 cobalt, 1 molybdenum, and 1.6 carbon. It is used for forming dies, swages, ring gages, and shear blades. It is air-hardening, and has high strength and hardness. Multimold steel of the Bethlehem Steel Co., for die-casting dies, contains 0.35% carbon, 0.80 chromium, and 0.30 molybdenum. It has some red hardness.

**Disinfectants.** Materials used for killing germs, bacteria, or spore, and thus eliminating causes of disease or bad odors in factories, warehouses, or in oils and compounds. In medicine the term Antiseptic is employed in a similar sense, and the term Germicide is often used for industrial disinfectants. Some disinfectants are also used as preservatives for leather and other materials, especially chlorine and chlorine compounds. Phenol is one of the best-known disinfectants, and the germ-killing power of other chemicals is usually based on a comparison with it. Practically all bacteria are killed in a few minutes by a 3% solution of phenol in water, but phenol has the disadvantage of being irritating to the skin. Industrial disinfectants are usually sold as concentrates to be diluted to the equivalent of a 3 to 5% solution of phenol. Too large a proportion of disinfectants in oils, solutions, or in the air may be injurious to workers, and the advice of health officials is ordinarily obtained before general use. Creosote oil and cresylic acid are employed in emulsions in disinfecting sprays and dips. Formaldehyde has high germicidal power, and is used for hides and leather. Antiseptic atmospheres may be produced by spraying chloramine T, iodine, or argyrol. Chloramine T is a white crystalline powder of the composition  $\text{CH}_3\text{C}_6\text{H}_4\text{SO}_2\text{NCINa} \cdot 3\text{H}_2\text{O}$ , soluble in water and in organic solvents. Besides its use as an antiseptic and germicide it is also employed as an oxidizing and chlorinating agent. Thymol is used as a disinfectant in ointments, mouth washes, soaps, and solutions. Condensation products of thymol with other materials are also used. Thymoform,  $\text{C}_{21}\text{H}_{28}\text{O}_2$ , made by condensing thymol with formaldehyde, is a yellow powder used as an

antiseptic dusting powder. Thymidol is an antiseptic made by condensing thymol with menthol. Dihydroxyacetic acid,  $\text{CH}(\text{OH})_2\text{COOH}$ , and its sodium salt, both white powders, are used in cosmetics, pharmaceuticals, and in coatings for food-wrapping papers, as they are nontoxic and do not irritate the skin. Hexylresorcinol,  $\text{CH}_3(\text{CH}_2)_5\text{C}_6\text{H}_3(\text{OH})_2$ , is a more powerful antiseptic than phenol and is not injurious to the skin or tissues. Pinosylvine is a natural antiseptic extracted from the heartwood of the pine tree, where it protects the tree against decay and insects. It is related chemically to resorcinol, and its germ-killing power is 30 times that of phenol. Ceresan M, of E. I. du Pont de Nemours & Co., Inc., is a powder designated as ethyl mercury toluene sulphonanilide, used for disinfecting seeds to protect against soil-borne plant diseases. Pittside, of the Columbia Chemical Div., used as an industrial germicide, is a stabilized Calcium hypochlorite, in water-soluble granules.

**Divi-divi.** The dried seed pods of the tree *Caesalpinia coriaria*, native to tropical America, employed in tanning leather. Most of the divi-divi is produced in Colombia, Dominican Republic, and Venezuela. It is used chiefly in blends with other tannins to increase acidity, to give a light color to the leather, and to plump and soften the leather. The pods are about 3 in. long, and contain up to 45% pyrogallol tannin. They require to be kept from fermentation, which develops a red coloring matter. The best pods are the thickest and lightest in color, and they are used to replace gambier, valonia, and myrobalans. The commercial extract contains 25% tannin. Algarobilla, from the pods of the *C. brevifolia*, of Chile, is a similar tanning agent. Cascalote is from the pods of the tree *C. cacolaco* of Mexico, and is the standard tanning material of Mexico. It is also used to replace quebracho for oil-well drilling mud. White ran, or Tari, is from the pods of the *C. digyna* of the Far East. Tara, or Bogotá divi-divi, also called Cevalina, is from the pods of the tree *C. tinctoria* of Colombia and Peru. The pods contain 32% tannin, and 1,000 lb of tara pods produce 500 lb of Tara powder. The material makes a soft leather, and is used to replace sumac.

**Dogwood.** A heavy hardwood noted for its ability to stay smooth under long-continued rubbing. Its outstanding use is for shuttles for weaving. The texture is fine and uniform. Other uses of the wood

are for small pulleys, golf-club heads, mallet heads, jewelers' blocks, skate rollers and bobbins. There are 17 known varieties of the plant in the United States, only four of which grow to tree size. The White dogwood is *Cornus florida*; the Pacific dogwood is *C. nuttalli*; Rough-leaf dogwood is *C. asperfolia*; and Blue dogwood is *C. alternifolia*. Dogwood grows sparsely throughout the Eastern states. The wood is marketed in bolts or short logs. Turkish dogwood was formerly imported for rollers and shuttles, as was also the Chinese dogwood, or Kousa, *C. kousa*.

**Dolomite.** A type of limestone employed in making cement and lime, as a flux in melting iron, as a lining for basic steel furnaces, for the production of magnesium metal, for filtering, and as a construction stone. It is a carbonate of calcium and magnesium of the composition  $\text{CaCO}_3\text{MgCO}_3$ , together with impurities, occurring widely distributed in coarse, granular masses or in fine-grained compact form known as Pearl spar. The specific gravity is 2.8 to 2.9 and hardness 3.5 to 4. It is naturally white, but may be colored by impurities to cream, gray, pink, green, or black. For furnace linings it is calcined, but for fluxing it is simply crushed. The raw dolomite, marketed by Basic Refractories, Inc., for open-hearth steel making is washed crushed stone in  $\frac{5}{8}$ -in. size. When calcined at a temperature of 2700 to 3100°F, dolomite breaks down to  $\text{MgO}$  and  $\text{CaO}$ . Calcined dolomite used in Germany as a water filter material under the name of Magno masse is in grain sizes 0.5 to 5.0 mm. Dolomite for the production of magnesia, some of which is cut as building marble, contains 10 to 20% magnesia, 27 to 33 lime, 1 to 12 alumina, 40 to 46 carbonic acid, 1 to 5 silica, and 0 to 3 iron oxide. The dolomite found in huge deposits in Oklahoma contains 30.7%  $\text{CaO}$ , 21.3  $\text{MgO}$ , and only very small amounts of silica, alumina, and iron oxide. For the production of magnesium metal, calcined dolomite and ferro-silicon are brought to a high temperature in a vacuum and the magnesium driven off as a vapor.

**Douglas fir.** The wood of the tree *Pseudotsuga taxifolia*, of the Northwestern United States and British Columbia. It is sometimes called Oregon pine, Douglas pine, Douglas spruce, Red fir, Fir, Yellow fir, and Puget Sound pine. The wood of young trees with wide growth rings is reddish brown, and is the type called red fir, though

the true red fir is from the large tree *Abies magnifica* of California and Oregon, the lumber of which is called Golden fir, and the wood of which is used also for paper pulp. The wood of older trees of slower growth with narrow rings is usually yellowish brown and is called yellow fir. Both woods may come from the same tree. The narrow-ringed wood is generally the stronger and heavier. Douglas fir averages below longleaf pine in weight, strength, and toughness, but above loblolly pine in strength and toughness, though below it in weight. The grain is even and close, with resinous pores less pronounced than in pitch pine. It is a softwood, and is fairly durable. The weight is 34 lb per cu ft. The compressive strength perpendicular to the grain is 1,300 psi; the shearing strength parallel to the grain is 810 psi. Douglas fir is used for general construction and millwork, plywood, boxes, flooring, and where large timbers are required. It is also used for pulping, and yields kraft paper of high folding endurance but of low bursting strength. The fibers are large. The trees grow to great heights, the average being 80 to 100 ft. The stand is estimated at more than 450 billion board feet, or about one-fourth of all timber in the United States. Douglas fir bark contains from 7.6 to 18.3% of a catechol tannin, the bark of young trees yielding the higher percentages. It is suitable for tanning heavy leathers, and yields a pliable, light-colored leather. Silvacon 383, of the Weyerhaeuser Timber Co., is douglas fir bark in flaky corklike granules used in flooring and acoustical tile. Silvacon 490 is the bark as a reddish powder used in dusting powders and paints. Silvacon 508 is hard, spindle-shaped small fibers from the tissue of the bark, used as a filler for plastics and in asphalt and fibrous paints.

**Drawing paper.** A heavy paper, usually white or buff color, employed for making drawings. For mechanical drawings the buff color is preferred as it is easier on the eyes and not so readily soiled. Drawing papers are smooth or rough, the first being hot-pressed. Good grades of drawing paper should permit considerable erasure without destroying the appearance. Buff detail paper for pencil use is made slightly rough or grained. High-grade paper for ink work is extra hard-sized and coated. Drawing paper is marketed in rolls of widths from 30 to 72 in., and in standard sheets varying from cap, 17 by 13 in., to antiquarian, 52 by 31 in. Tracing paper is usually a

good grade of hard transparent tissue paper in sheets and rolls, in white or buff colors.

**Driers.** Materials used for increasing the rapidity of the drying of paints and varnishes. The chief function of driers is to absorb oxygen from the air and transfer it to the oil, thus accelerating its drying to a flexible film. They are in reality catalyzers. Excessive use of driers will destroy the toughness of the film and cause the paint to crack. Solutions of driers are called liquid driers, and it is in this form that the driers are most used. Certain oils, such as tung oil, have inherent drying properties and are classed as drying oils but not as driers. Driers may be oxides of metals, but the most common driers are metallic salts of organic acids. Manganese acetate,  $(\text{CH}_3\text{COO})_2\text{Mn} \cdot 4\text{H}_2\text{O}$ , is a common paint drier. It is a pinkish crystalline powder soluble in water and in alcohol. Sugar of lead, used as a drier, is Lead acetate,  $\text{Pb}(\text{C}_2\text{H}_3\text{O}_2)_2 \cdot 3\text{H}_2\text{O}$ , a white crystalline material. Lead oleate,  $\text{Pb}(\text{C}_{18}\text{H}_{33}\text{O}_2)_2$ , is a drier made by the action of a lead salt on oleic acid. It is also used for thickening lubricants. Lead linoleate,  $\text{Pb}(\text{C}_{18}\text{H}_{31}\text{O}_2)_2$ , is a drier made by adding litharge to linseed oil and heating. Lead and manganese compounds together act more effectively as driers than either alone. Lead resinate adds toughness of film as well as drying power. Cobalt driers are twice as rapid in drying power as manganese driers, but too rapid drying often makes a wrinkled film which is desirable for some finishes but not for others. These driers may be sold under trade names. Zinar, of Newport Industries, Inc., is a Zinc resinate with 5.6% zinc content.

Naphthenate driers are metallic salts made with naphthenic acids instead of fatty-oil acids. They are usually more soluble in paint solvents, and, since the naphthenic acids can be separated into a wide range of molecular weights by distillation, a wider variety of characteristics can be obtained. Sodium naphthenate, with 8.6% metal content, and Potassium naphthenate, with 13.1%, are powders that are good bodying agents and emulsifiers as well as driers. Tin naphthenate, with 20% tin, may be added to lubricating oils as an antioxidant. Mercuric naphthenate, with 29% mercury, retards the growth of bacteria and mold when added to finishes. Barium naphthenate, with 22.6% barium, has binding and hardening properties, and is thus useful in adhesives and in linoleum. The Octoic driers of the

Witco Chemical Co. are metallic salts made with ethyl hexoic acid, and the metal content is lower than that of driers made with naphthenic acids. They are light in color, have no odor, and have high solubility.

**Drill.** A stout, twilled cotton fabric used for linings and where a strong fabric lighter than duck is required such as for laminated plastics. It differs from duck also in that it has a warp-flush weave that brings more warp than filling to the face of the cloth. It comes unbleached, bleached, or piece-dyed, or may be yarn-dyed. It is made in various weights, and is designated in ounces per yard the same as duck. Tan-colored drill is called Khaki. A somewhat similar fabric to drill is Denim, which is a heavy, twill-woven, warp-flush fabric but usually lighter in weight than drill. The warp is yarn-dyed, usually either light blue or dark brown, but also in other colors. The filling is made with one black and one white yarn. Denim is designated by the weight in ounces per yard. It is much used for workmen's overalls and jumpers, and the light weights for this purpose and for sportswear are called Jean. Denim is also used for upholstery, and industrially where a tough fabric is needed. Art denim, in plain colors or woven with small figures, is used for upholstery.

**Drill rod.** Tool-steel round rod made to a close degree of accuracy, generally not over or under 0.0005 in. the diameter size, and usually polished. It is employed for making drills, taps, reamers, punches, or for dowel pins, shafts, and rollers. Some mills also furnish square rods to the same accuracy under the name of drill rod. Common drill rod is of open-hearth high-carbon steel hardened by quenching in water or in oil. The usual commercial sizes are from 1½ in. in diameter down to No. 80, which is 0.0135 in. in diameter. The usual lengths are 1 to 3 ft. The sizes are by the standard of drill gages, with about 200 different diameters. The carbon content is usually from 0.90 to 1.05%, with 0.25 to 0.50 manganese, 0.10 to 0.50 silicon, and a maximum of 0.04 phosphorus or sulphur. It also comes in high carbon with from 1.50 to 1.65% carbon and 0.15 to 0.35 manganese. Drill rod can also be obtained regularly in high-speed steels, and in special alloy steels for dowel pins. Needle wire is round tool-steel wire used for making needles, awls, and latch pins. It comes in coils, in diameters varying by gage sizes from 0.010 to 0.105 in. Needle



tubing for hypodermic needles is stainless-steel tubing 0.035 in. in diameter or smaller. It requires about 100 cold-drawing operations and annealings to reduce it to this size. Stud steel is an English name for round bar steel made to close limits and hardened and descaled, used for heavy pins and studs. Pin bar is small-diameter rod of case-hardening steel used for dowel pins. Drill steel, for mine and quarry drills, comes in standard rounds, octagons, squares, and cruciform bars, solid or hollow, usually in carbon steel.

**Drug plants.** Known in the trade as Crude drugs and Botanicals. The roots, leaves, stalks, flowers, or bark of many plants are used for medicines or for the production of medicinal products. Many of these are acute poisons having specific physiological effects on nerves, blood, heart action, or organs of the body. Knowledge of the specific effect of each, with control of the amount to produce a needed effect to correct organic disturbances, constitutes the theory of the use of these. The manufacture and sale of drugs in all civilized countries are controlled by various laws and by recognized and listed standards known as formulary and pharmacopoeia. The term drug has come to have an awesome significance, but many drugs occur in the most common foodstuffs, and it is theoretically possible by a perfect balance of foods and by the taking of the right foods at the right time to obtain balanced physiological effects and perfect health. Conversely, the excessive consumption of some foodstuffs causes toxic conditions because of the contained drugs. Balance is complex and varies within different individuals. Some derangements of the human system are caused by food unbalance, some by germ action, and some by faults in the system that impede metabolism or generate toxic products. It is the purpose of drugs to correct unbalances. Many of the most valuable drug plants contain Alkaloids which have complex arrangements of carbon, hydrogen, oxygen, and nitrogen. Most of the alkaloids are violent poisons even in small quantities, and with few exceptions, such as quinine, are not employed as medicines except under the direction of trained physicians or pharmacists. The actual amount to produce sufficient effect without injury must be understood before use of a drug. Pain-killing drugs, for example, do not kill pain but diminish the conductivity of the nerve fibers, and thus prevent the brain from recording the pain.

Drug plants are almost unlimited in number. Belladonna, used to relieve pain, to check perspiration, and as a dilatant, consists of the leaves, roots, flowers, and small stems of the perennial herb *Atropa belladonna* cultivated chiefly in Yugoslavia and Italy, but also grown in the United States. The plant is called Banewort and Deadly nightshade. The leaves are dried in the shade to retain the green color. They contain two alkaloids, Atropine and Hyoscyamine. Henbane is the dried leaves and flowering tops of the ill-smelling herb *Hyoscyamus niger*, a plant of the nightshade family containing several alkaloids. It is used as a sedative. The plant is grown in southern Europe and Egypt and to some extent in the United States. It is harvested in full bloom and dried in the shade.

Stramonium is the dried leaves, flowers, small stems, and seeds of the Thorn apple or Jimson weed, *Datura stramonium*, an annual of the nightshade family which grows as a common weed in the United States. It is shipped from Ecuador under the name of Chamico. It produces the alkaloids, atropine and hyoscyamine, and is used as a nerve sedative, hypnotic, and antispasmodic. Under cultivation, the yield is 1,000 to 1,500 lb of dry leaf or 500 to 2,000 lb of seed per acre. In general, the yield of drug plants in cultivation is high, so that only small acreages are needed. Aconite is the dried root of the Monkshood, a herbaceous perennial plant, *Aconitum nepellus*. It is grown in Europe and the United States. The root contains the colorless, crystalline, extremely poisonous alkaloid Aconitine,  $C_{34}H_{47}O_{11}N$ . It is used as a cardiac sedative, diaphoretic, and to relieve pain and fever.

Digitalis, an important heart stimulant, consists of the leaves of the perennial Foxglove plant, *Digitalis purpureae*, native to Europe but also grown in New England and the Pacific Northwest. The leaves contain the bitter glucoside Digitoxin,  $C_{34}H_{54}O_{11}$ . Peyote is the root of a cactus, *Lophophora williamsii*, growing wild in the desert region of Mexico. The buttonlike tops of the root, called Mescal buttons, contain several alkaloids, and were used by the Indians to produce a sense of well-being with visions. Peyotina hydrochloride, made from the buttons, is used in medicine as a heart stimulant similar to digitalis, and also as an anesthetic to the nervous system. The Glucosides contain no nitrogen as do the alkaloids. They are ethers of single sugars. The glucoside Rutin, used for treatment of hemorrhage

and for high blood pressure, is a yellow nontoxic powder extracted from flue-cured tobacco and from Tartary buckwheat or Rye buckwheat. Ipecac is the rhizome of the shrub *Cephaelis ipecacuanha*, of tropical South America, chiefly Brazil. It contains Emetine,  $C_{30}H_{40}O_5N_2$ , and other alkaloids, and is used as an emetic, tonic, and expectorant. Gentian, also known as Bitter root, is the dried root of the perennial herb *Gentiana lutea* of central Europe. It contains glucosides, and is used in tonics, and also in cattle feeds.

Ginseng is the dried root of the plant *Panax ginseng* of China, and *P. quinquefolium* of North America. It is used as a stimulant and stomachic. Doggrass root, known in medicine as Triticum, is the powdered dried rhizome of Scotch grass, *Agropyron repens*, which abounds in the meadows of the northern United States. It has a slight aromatic odor and sweet taste and is used as a diuretic. Lobelia is the dried leaves and tops of the small annual plant *Lobelia inflata*, known in the northeastern states as Indian tobacco. It contains the alkaloid Lobinine, and is used as an emetic and antispasmodic. Erigeron is the herb and seeds of the Fleabane herb, *Erigeron canadensis*, which grows wild in the north central and western states. The herb yields 0.35 to 0.65% Erigeron oil used as an astringent and tonic. Hamamelis is the dried leaves of the witch hazel shrub, *Hamamelis virginiana*, of the eastern United States. It is used as a tonic and sedative, and the water extract of the leaves and twigs with 15% alcohol is known as Witch hazel. It is used as an external astringent. It is fragrant, and contains also tannic acid from the bark of the twigs. Ephedrine, or Ephedra, is an alkaloid extracted from the dried twigs of the Mahuang, *Ephedra sinica*, and other species of mountain shrubs of China and India. It is also grown in South Dakota. It is used as an adrenalin substitute to raise blood pressure, and also in throat medicines and nasal sprays. Hoarhound is an extract from the leaves and flowering tops of the small perennial herb *Marrubium vulgare* of North America, Europe, and Asia. It is used in preparations for colds, and also as a flavor in confections.

Cascara is the bark of the small Buckthorn tree, *Rhamnus purshiana*, of the Northwestern states and Canada. It was also called Chittem bark. It was used by the Indians and given the name Cascara sagrada by the Spaniards. The word cascara simply means bark; the word sagrada is not translated sacred but is a term applied to

medicinal botanicals. Cascara is used as a laxative and tonic. The European buckthorn, *R. frangula*, also yields cascara. Aloe, used in purgative medicines, is the dried resinous juice from the leaves of the bush *Aloe vulgaris* of the West Indies and *A. perryi* of West Africa. The cut leaves are placed in troughs where the juice exudes. It is then evaporated to a viscous black mass which hardens. Both aloe and cascara contain the glucoside Emodin, occurring also in senna and in Rhubarb. The latter, the stalks of which are much used as a food, is known in medicines as Rheum and is employed as a laxative and stomach tonic. Aletris root is a botanical drug from the Stargrass, *Aletris farinosa*, growing in the eastern United States. It is also known as Colic root, and is used as a tonic and uterine stimulant. Senega, used as an emetic and stimulant, is the dried root of the Snakeroot or Milkwort, *Polygala senega*, a small perennial herb grown in the eastern United States. Calumba root is the yellow root of the woody climbing plant *Coscinium fonestratum* of Ceylon. It is used as a cure for tetanus. The wood, which has a bright-yellow color, is used locally as a dye. Tanacetum is the dried leaves and tops of the Silverweed, *Tanacetum vulgare* of Michigan and Indiana, used as a vermifuge. The green herb yields about 0.2% Tansy oil, or Tanacetum oil, which contains a terpene Tanacetene, and borneol. It is used as an anthelmintic.

Ergot, used to stop hemorrhage, is the dried sclerotium of the fungus *Claviceps purpurea*, which develops on rye and some grasses. The purple structure that replaces the diseased rye grain contains the alkaloid Clavine,  $C_{11}H_{22}O_4N_2$ . Ergot is also used to produce Dihydroergocornine for treating high blood pressure by blockage of the sympathetic nerve impulses in the small arteries. Ergot oil, used in medicinal soaps, is obtained by extraction from the dry ergot. It was the original source of Ergosterol, an inert alcohol which, when irradiated, yields vitamin D. Ergot is produced chiefly in Spain, and its commercial production has not been encouraged in the United States because it is an undesirable disease on grain.

Araroba, or Goa powder, is a brownish, bitter, water-soluble powder scraped out of the split logs of the tree *Andira araroba* of Brazil. The Carib Indians used the powder for skin diseases, and it is now employed for eczema and skin affections. It contains Chrysarobin, a complex mixture of reduction products of a complex acid contained in

the wood. Labdanum is an oleoresin obtained in dark-brown or greenish lumps from the branches of the Rock rose, *Cistus ladaniferus*, and other species of the Mediterranean countries. It yields a volatile oil with a powerful sweet characteristic odor which is used as a stimulant and expectorant and also as a basis for lavender and violet perfumes. It was originally obtained in Greece by combing from the fleece of sheep that browsed against the bushes. Buchu is the dried leaves of the South African herb *Barosma betulina* used as an anticatarrhal.

**Drying oils.** Vegetable oils which are easily oxidized by exposure to the air and thus suitable for producing a film in paints and varnishes, and known as Paint oils. The drying of an oleoresinous varnish takes place in two stages. First, the reducer or solvent evaporates, leaving a continuous film composed of gums and drying oil. The drying oil is then oxidized by exposure, leaving a tough, hard skin. This oxidation is hastened by driers, but the drying oil itself is responsible for the film. The drying power of oils is measured by their Iodine value, as their power of absorbing oxygen from the air is directly proportional to their power of absorbing iodine. Linseed oil is the most common of the drying oils, though tung oil and oiticica oil are faster in drying action. Linseed oil alone will take about 7 days to dry, but can be quickened to a few hours by the addition of driers. Linseed oil and other oils may be altered chemically to increase the drying power.

Conjugated oils are oils that have been altered to give conjugated double bonds in place of isolated double bonds in the molecules of the fatty acids. Conjunlinol, of the Woburn Degreasing Co., is a drying oil of this class made from linseed oil. The iodine value is 154, and the drying time is greatly reduced. Normally, soybean oil is not classed as a drying oil although it may be blended with drying oils for paint use. But by chemical alteration it can be given good drying power. Conjusoy is a drying oil made by conjugation of soybean oil. The iodine value is 128, and the drying time is about half that of boiled linseed oil.

Castor oil, which has poor drying properties, is dehydrated to form a good drying oil. Other methods are used to alter oils to increase the drying power, notably polymerization of the linoleic and some

other acids in the oils, or oils may be fractionated and rebled to increase the percentage of acids that produce drying qualities. The Admerols, of the Archer-Daniels-Midland Co., comprise a series of drying oils made by treating linseed or soybean oil with butadiene, styrene, or pentaerythritol. Kel-X-L oil, of Spencer-Kellogg & Sons, is a modified linseed oil with an iodine value up to 170, used as a substitute for tung oil in quick-drying varnishes. Kellin, of the same company, is a quick-drying blended oil with a linseed-oil base, while Kellsoy is a similar oil with a soybean-oil base. Cykelin, of this company, is a quick-drying oil made by treating linseed oil with Cyclopentadiene,  $(\text{CH}:\text{CH})_2\cdot\text{CH}_2$ , a low-boiling liquid obtained from coal tar or from cracking petroleum. Cykelsoy is another drying oil made by treating soybean oil with cyclopentadiene. Dorscolene, of Dorward & Sons Co., is a drying oil made from fractionated and blended fish oils. The German substitute drying oil known as Resinol was a liquid obtained by the distillation of the heavy fractions of the benzolated oils derived from scrubbing coke-oven gas. Resigum is the final residue in the distillation of tar oil benzol which has been washed with sulphuric acid, caustic soda, and water. It contains a maximum naphthalene content of 5%. It is miscible with resins or copals, and with vegetable oils, and makes a good paint without other drying oils. The Synthetic drying oil of the Shell Development Co. is Glycerol allyl ether derived from propylene gas obtained in cracking petroleum.

Although the great volume of drying oils is produced from linseed, soybean, tung, oiticica, castor, and fish oils, many other oils have drying properties and are used in varying quantities. N'gart oil is from the seed nuts of a climbing plant of Africa; and is equal in drying power to linseed oil. Lallelantia oil, obtained from the seeds of the *Lallelantia iberica*, of southeastern Europe and Asia, resembles linseed oil in physical properties. Isano oil, obtained from the kernel of the nut of the *Ongokea klaineana* of tropical Africa, is a pale-yellow viscous oil that has little drying power, but when heat-treated sets up an exothermic action to produce a varnish oil. Anda-assu oil, also used in Brazil for paints, is from the seeds of the plant *Joannesia princeps*. The seeds yield 22% of a clear yellow oil with an iodine value of 142 which is bodied by heating. Manketti oil is a varnish oil with about two-thirds the drying power of linseed oil. It

is a light-yellow viscous oil from the seed nuts of the tree *Ricinodendron rautanenii*, of southwest Africa, and the *R. africanum*, of the French Congo.

**Duck.** A strong, heavy cotton fabric employed for sails, awnings, tents, heavy bags, shoe uppers, machine coverings, and where a heavy and durable fabric is needed. It is woven plain, but with two threads together in the warp. It is made in various weights, and is designated by the weight in ounces per running yard 22 in. wide. It is marketed unbleached, bleached, or dyed in colors, and there are about 30 specific types with name designations usually for particular uses such as Sail cloth. When woven with a colored stripe, it is called Awning duck. Russian duck is a fine variety of Linen duck. Large quantities of cotton duck are used for making laminated plastics and for plastic-coated fabrics, and it is then simply designated by the weight. Belt duck, for impregnated conveyer and transmission belts, is made in loosely woven soft ducks and in hard-woven, fine-yarn hard fabric. The weights run from 28 to 36 oz. Hose duck, for rubber hose, is a soft-woven fabric of plied yarns not finer than No. 8, made in weights from 10 to 24 oz. The grade of duck known as Elevator duck for conveyer belts is a hard-woven 36-oz fabric. Plied-yarn duck is used for Army tents instead of flat duck as it does not tear easily and does not require sizing before weaving. Canvas is duck of more open weave. The term is used loosely in the United States to designate heavy duck used for tarpaulins, bags, sails, and tents. But more properly it is a heavy duck of square mesh weave more permeable than ordinary duck, such as the canvas used for paintings and for embroidery work. The word duck is from the Flemish *doeck* meaning cloth, originally a heavy linen fabric. The word canvas is from the Latin *cannabis*, originally a coarse, heavy hempen cloth for tents.

**Duplex metal.** Sheet or plate metal composed of sheets of two different metals rolled together. It was developed as an industrial product only recently, particularly to give corrosion resistance or appearance without the expense of a solid plate, but the process is an old one in the jewelry industry. The early French duplex metal called *Double* consisted of copper or brass with a thin facing of noble metal for acid resistance, or of silver or gold for appearance. The Gold shell, used for costume jewelry, is a duplex metal with gold rolled on

a rich-low brass. This material was called Abyssinian gold, Talmi gold, and other names. Efkabimetal was a German doublé consisting of copper clad with a noble metal. The Inter-Weld metal of the American Silver Co. has a base metal of brass or nickel bronze to which is silver-soldered a sheet of pure nickel over which is welded the gold sheet. When rolled, the gold is extremely thin, but the nickel prevents the color of the base metal from bleeding through.

Feran, a German duplex metal, was made by passing strips of aluminum and iron through rolls at a temperature of 350°C and then cold-rolling to sheet. Alclad, of the Aluminum Co. of America, is an aluminum-clad aluminum alloy, with the exposed pure aluminum giving added corrosion resistance, and the aluminum-copper base metal giving strength. The base metal is Alcoa 17-S, and the pure aluminum coating is usually 0.0035 in. in thickness. It is used for aircraft sheathing. The German Lautal with pure aluminum rolled on is called Allautal. Zinnal is a German aluminum sheet with tin cladding on both sides, while Cupal is a copper-clad aluminum sheet. Chromaloid, of the American Nickeloid Co., consists of a zinc base with sheet chromium bonded on one face. The chromium face is highly polished, and the sheets are used for corrosion-resistant table tops and stamped parts. Nickeloid, of the same company, is sheet zinc with polished nickel bonded to the face. Alcuplate, of the Metals & Controls Corp., is aluminum with copper bonded to both sides, used for stamped and formed parts where good electrical conductivity and easy soldering in combination with light weight are desired. Aluminized steel of the Sylvania Electric Products, Inc., is cold-rolled steel which has a 0.005-in. coating of an aluminum-silicon alloy rolled into the surface and then annealed in hydrogen. It has a black surface, and is used for vacuum-tube parts to give thermionic radiation and absorb stray electrons.

Brass-clad steel, used for making bullet jackets and shell cases, consists of a 90-10 brass on one side of a mild steel sheet, with the brass equal to 20% of the weight of the sheet. The duplex metal called Bronze on steel, of the Johnson Bronze Co., used for bearings, is made by powdering the borings from castings of 80% copper, 10 tin, and 10 lead, and bonding this homogeneous powder to strip steel in a hydrogen furnace so that no oxides are formed. The strip is then rolled and subsequently formed into bearings and bushings. The



thin bronze coating saves tin and copper, and the bearing is more resistant to pounding than a cast bronze. Fernicklon, of the Kenmore Metals Corp., is nickel-coated wire for instrument use. Steel or copper rod is electroplated with a heavy plate of nickel and then cold-drawn to wire.

Calorized metals are steel or iron surface-treated with aluminum by a process that makes a surface impregnation of aluminum to resist hot gases and molten white metals. Insuluminum, of the General Electric Co., is calorized steel for lead pots and chemical equipment. It will withstand temperatures to 1650°F. Clad steels are available regularly in large sheets and plates, and are used extensively for tank cars, chemical tanks, and architectural work. They are made with coatings of nickel, stainless steels, or monel metal, the metals being rolled together at white heat under heavy pressure. The cladding metal on one surface is usually equal to 10% of the weight of the plate. The Nickel-clad flange steel, of the Lukens Steel Co., has a tensile strength of 55,000 psi. Niclad, of the Flannery Mfg. Co., has the nickel or nickel alloy deposited on the steel or iron by a continuous welding process. Stainless-clad copper, of the American Cladmetals Co., is copper sheet with stainless steel on both sides, used for making cooking utensils and food-processing equipment. With stainless steel alone, heat remains localized and causes sticking and burning of food-stuffs. Copper has high heat conductivity, is corroded by some foods, and has an injurious catalytic action on milk products. Thus, the stainless-clad copper gives the conductivity of copper with the protection of stainless steel.

**Dyestuffs.** Materials employed for giving color to textiles, paper, leather, wood, or other products. They may be either natural or artificial. Many chemicals will stain and color other materials, but a product is not considered as a dye unless it will impart a distinct color of some permanence to textiles. The natural dyestuffs may be mineral, animal, or vegetable, but the artificial dyes are derived mainly from coal-tar bases. Tyrian purple, from various Mediterranean snails, was in ancient times the most noted of the animal dyestuffs. Cochineal and kermes are other animal dyes. One of the earliest metallic or mineral dyestuffs was called Iron buff. It was made by allowing pieces of iron to stand in a solution of vinegar to corrode. After dipping

fabrics in this solution they were rinsed in a solution of wood ashes. Mineral dyes now include ochre, chrome yellow, and Prussian blue. Vegetable dyes may be water solutions of woods, barks, leaves, fruits, or flowers. The buff and brown textile colors of early New England were made by boiling fresh green butternuts in water, while a dark-red dye was made by boiling the common red beet in water. Vegetable dyes now include Brazil wood, barwood, sappan wood, fustic, logwood, madder, henna, saffron, annatto, indigo, and alkanet. The Camphire of the ancients mentioned in the Bible and Koran was a reddish-orange dyestuff made by grinding to a paste the red, sweet-scented spikes of the small cypress tree, *Lawsonia inermis*, of Egypt and the Near East. It was used by the Eastern and Roman women to stain the fingernails, and is now used under the name of Henna for dyeing leather and as a hair dye. It gives various shades from yellowish to red or brown. Argol, a brilliant red used extensively until replaced by synthetic dyes, is from the Orchilla, a lichen found in the Canaries and Near East. It was used to produce the brilliant colors of the medieval Florentine cloth. Chinese green, Buckthorn bark, or Lokao, is the powdered bark of the buckthorns, *Rhamorus globosa* and *R. utilis*, of China and Russia. It is used in dyeing silk and cotton. Weld, from the plant *Reseda luteola* of Europe, produces a very bright-yellow color with an alum mordant. With indigo it produces green. Woad is the dried fermented leaves of the plant *Isatis tinctoria* of Europe. It gives a blue color, but is now little cultivated.

The synthetic dyes are mostly coal-tar or aniline colors. They are more intense, brighter, faster, and generally cheaper than natural dyestuffs. There are thousands of these dyes, classified by a color index rather than by their chemical composition. The dyes are complex chemicals, but they usually contain characteristic groups of atoms so that the color or change in color can be predicted. The chemical names refer to the forms of atom groupings, such as the Azo dyes. Some of the dyes will color animal fibers well and not vegetable fibers, or vice versa, while some will color all fibers. Some can be dyed direct, while others require a mordant. Some are permanent, or fast, while others are water-soluble and will fade when the fabric is washed, or some may not be light-fast and will fade when exposed to light. Dyes are acid when they operate best in an acid bath, and basic when operative in an alkaline bath. Some of the so-called Vat dyes are insoluble and

are applied in the soluble colorless form and afterwards reduced or oxidized to color. The Sulphur dyes are made by treating the organic compounds with sodium sulphide. They are fast to washing and to light, but the range of color is more limited. They are used only on vegetable fibers as the bath is strongly alkaline.

**Ebony.** A hard, black wood valued for parts subject to great wear, and for ornamental inlaying. It is the wood of various species of trees of the ebony family, *Ebenaceae*, although the name is also applied to some woods of the genus *Dalbergia*, family *Leguminosae*. Black ebony, from the tree *Diospyros dende* of West Africa, and Ebony, from the tree *D. melanoxylon*, of India, are the true ebonies. Black ebony has a black heartwood with brownish-white sapwood. It is next to lignum vitae in hardness, has a fine, open grain, and weighs 78 lb per cu ft. It is used for inlaying, piano keys, and turnery. The ebony of India is also extremely hard, with a fine and even grain. The heartwood is black with brownish streaks. Marblewood, or Andaman marblewood, is an ebony from the tree *D. kurzii* of India and the Andaman Islands. The wood is black with yellowish stripes. It has a close, firm texture, is hard, takes a fine polish, and weighs 65 lb per cu ft. Marble ebony is another species from Madagascar. The ebony from Japan, called Kaki, is from the tree *D. kaki*. It has a black color streaked with gray, yellow, and brown. The grain is close and even, and the wood is very hard, but the weight is less than that of African ebony. Ebony wood is shipped in short billets, and is graded according to the color and the source, as Niger, Macassar, Cameroon. Green ebony is a name sometimes given to the cocoswood of the West Indies. Artificial ebony, formerly composed of asphaltic compounds, is now usually molded plastics. A heavy blackish wood used for fine inlay work is Acapau, from the large tree *Vouacaponia americana* of the Amazon Valley. It is valued in Brazil for furniture because of its resistance to insect attack. It is called Partridge wood in the United States.

**Elemi.** A soft, sticky, opaque resin with a pleasant odor, obtained from the Pili tree *Canarium luzonicum*, of the Philippines, and employed for giving body and elasticity to lacquers and in lithographic inks. In medicine it is used in ointments. It contains Dipentene,  $C_{10}H_{18}$ , which is called Limonene from its lemonlike odor, and is

known as Cajeputené when obtained from cajeput. It also contains a related terpinene oil, Phellandrene. Substitute elemi resins are obtained from various trees of the family *Burseraceae* of tropical Africa and America. The pili trees are hacked or stripped, and the resin collects on the bark, a tree yielding about 5 lb per year. West Indian elemi is from the tree *Dacryodes hexandra* of the West Indies. Nauli gum is elemi from the tree *C. commune* of the Solomons. Elemi oil, obtained by distilling elemi, is a colorless liquid of specific gravity 0.87 to 0.91, used in perfumes and in medicine. It has an aniselike odor.

**Elkskin.** The commercial name for a soft, pliable, and durable leather made from kips or from overgrown calf by a special tanning process and impregnation with oils. It is used chiefly for children's shoe uppers and for pocketbooks. A heavier elkskin, or Elk leather, for sport shoes and boots, is made from cow hides by the same treatment. Elkskin, like chamois, dries out to its original softness after wetting. Smoked elk is elk leather dyed cream-colored to imitate the original leather of elks, which was smoked over a wood fire.

**Elm.** The wood of several species of the elm tree, of the eastern United States and Canada, and northern Europe. The wood of the American elm, or White elm, *Ulmus americana*, has a fine grain, a weight of about 40 lb per cu ft, is hard and tough, and whitish brown in color. It is the best known commercially of the six species grown in the United States. The American elm is not a forest tree, but is grown as a shade and ornamental tree. It does not grow in the mountains. The trees sometimes reach a diameter of 6 ft and a height of 100 ft. The tough, durable wood is valued for ax handles, cooperage, and for parts requiring a combination of strength, bending qualities, and ability to withstand rough usage. The wood of this tree, and also of the rock elm, was formerly used for superstructures of naval ships because it did not sharp-splinter like oak. It was also the favorite wood for hubs and spokes of heavy wagon wheels. Rock elm, or Hickory elm, *U. thomasi*, is also native to the United States and Canada. It has a very fine, close grain and is slightly heavier. It is sometimes called Cork elm, although this name applies to the Wahoo, or Winged elm, *U. alata*, of the southeastern states, because of the corky appearance of the twigs. The winged elm is grown as a

shade tree, but the wood is valued for crates, caskets, and vehicle parts. The English elm, *U. procera*, has a straight trunk and rounded crown more like the oaks. The Chinese elm, *U. parvifolia*, has small leaves and is very resistant to disease. Slippery elm is a smaller forest tree, *U. fulva*, of northeastern United States. Considerable lumber comes from this tree under the name of Red elm. The inner bark of the tree is mucilaginous with a sweet taste and characteristic odor. It was used by the Indians as a chewing gum and as a poultice for skin affections. The dried and powdered bark is now used in medicine for skin affections and for the throat. It contains Ulmic acid, or Geic acid,  $C_{20}H_{14}O_6$ .

**Emery.** A fine-grained, impure variety of the mineral corundum, mixed with other minerals, chiefly magnetite. It occurs as a dark-brown granular massive material, with a specific gravity of 3.7 to 4.3 and a hardness of about 8. It usually contains only 55 to 75%  $Al_2O_3$ . It is used as an abrasive either ground into powder or in blocks and wheels. The grains are graded in sizes from 220 mesh, the finest, to 20 mesh, the coarsest. Emery paper and cloth are usually graded from 24 to 120 mesh, and the grains are glued to one side of 9- by 11-in. sheets. Flour of emery is the finest powder, usually dust from the crushing. Emery cake as made for buffing and polishing is now not likely to be made of emery, but a graded combination of aluminum oxide and iron oxide, with a higher percentage of the hard aluminum oxide for buffing, and higher iron oxide for polishing. It is furnished in various grades of fineness, with grains of 120 to 200 mesh, or flour sizes, F, FF, and FFF. Emery takes its name from Cape Emery, on the Island of Naxos. Most of the world supply comes from Greece and Turkey, but some is mined at Peekskill, N.Y.

**Emulsifying agents.** Materials used to aid in the mixing of liquids that are not soluble in one another, or to stabilize the suspension of nonliquid materials in a liquid in which the nonliquid is not soluble. The suspension of droplets of one liquid in another liquid in which the first liquid is not soluble is called an Emulsion. The emulsion of oil and water, used in machine shops as a cutting lubricant and work coolant, may be made with soap as the emulsifying agent. The emulsifying agent causes the droplets to be formed and protects droplets of the dispersed medium from uniting and thus separating out,

but most emulsions will separate on long standing. The oil itself may be treated so that it is self-emulsifying. Sulphonated oils will thus form emulsions with water without any other agent. Saponin, bentonite, and the root starches are commonly used emulsifying agents. For the suspension of drug materials in pharmaceutical mixtures gum arabic, tragacanth, albumin, or algin may be used. Tapioca, sweet-potato starch, egg albumin, and proteins are common emulsifying agents for food preparations. Bentonite is used in adhesive and lacquer emulsions. Propylene laurate is a light, high-boiling liquid that is self-emulsifying in water and is employed in pharmaceuticals and foods to stabilize the mixtures. Various long-chain chemicals are also used in making cutting compound emulsions as they also give antirust characteristics.

**Enamel.** A protective coating which upon hardening has an enameled or glossy face. Pottery enamels, Ceramic enamels, or Vitreous enamels are composed chiefly of quartz, feldspar, clay, soda, and borax, with saltpeter or borax as fluxes. The quartz supplies the silica, and such enamels are fusible glasses. In acid-resisting enamels alkali earths may be used instead of borates. To make enamels opaque, opacifiers are used. They may be tin oxide for white enamel, cobalt oxide for blue, or platinum oxide for gray. Enamel-making materials are prepared in the form of a powder which is called Frit. The frit-making temperature is about 2400°F, but the enamel application temperatures are from 1400 to 1600°F. For application to aluminum, a lower temperature must be used, and the enamels are made with a high proportion of lead compounds to lower the melting point. White glass enamel is a low-melting enamel used on brass clock dials and scales. Enamels applied to metal are fired at red heat, and each succeeding coat must have a lower melting point than the one before it so as not to destroy the preceding coat. They must also have about the same coefficient of expansion as the metal to prevent cracking.

The mineral oxide enamels fused to metals as coating were formerly called Porcelain enamel, but they are not porcelain and are now termed Vitreous enamels in the industry. They are carefully selected and blended oxides to produce thin and resistant coatings that will not chip easily. They are used to coat cooking utensils, signs, chemical

equipment and machine parts, and corrugated iron and steel for siding and roofing. Ground coats are usually 0.003 to 0.004 in. thick, and cover coats may be 0.003 to 0.008 in. thick. High-temperature coatings may contain as much as 90% zirconium and will withstand temperatures to 1650°F for long periods.

A blue cobalt undercoat is used to give good adhesion of white or colored enamels to steel, but special Enameling steels are available that require no ground coat, or, when Sodium aluminum silicate,  $\text{Na}_2\text{O} \cdot \text{Al}_2\text{O}_3 \cdot 6\text{SiO}_2 \cdot x\text{H}_2\text{O}$ , is used instead of borax, a dense white finish is produced without a ground coat. Mirac, of the Pemco Corp., is a white enamel which gives good adhesion direct to steel when fired at 1500°F. When small amounts of titanium are alloyed in the steel, vitreous enamels containing titanium oxide will adhere well to the steel. Ti-Namel, of the Inland Steel Co., is a sheet steel containing titanium to which a single white coat can be applied. Vitric steel, of the Republic Stamping & Enameling Co., is a vitreous enameled corrugated steel for building construction. Majolica is a name applied to enamels resembling marble, made by mixing liquid enamels of different colors, but Mottled graywear is made with cobalt oxide on steel that has a controlled misting on the surface. Cloisonné enamel is an ancient decorative enamel produced by soldering thin strips of gold on the gold base metal to form cells into which the colored enamel is pressed and fused into place. It is still produced by the old hand methods, but is imitated in synthetic plastics for such articles as clocks and radios. Enameloid-cloisonné is a name for such use by the Gemloid Corp. Glass-coated steel is made by covering high-silicon steel sheets with calcined magnesia and heating in an oxygen-free atmosphere. The magnesia reacts with the silicon in the steel and forms a tough glasslike enamel on the sheet.

The word enamel in the paint industry refers to glossy varnishes with pigments or to paints of oxide or sulphate pigments mixed with varnish to give a glossy face. In general, they do not have the heavy body of a paint and require undercoats. Japan is a name applied to black baking enamels. The same finish in other colors would not be called japan, as the original oriental lacquer was always black. Japan consists of a pigment, a gum, a drying oil, and a reducer, the same as any oil enamel. It is always baked, which drives off the solvent and fuses the gum into a uniform vitreous layer. Japans give a tough

durable finish to small machine parts, but require expensive between-coat rubbing, and are now replaced by synthetic baking finishes. The modified phenolmelamine and alkyd-melamine synthetic resins produce tough and resistant enamel coatings. Quick-drying enamels are the cellulose lacquers with pigments. Conductive coatings to produce an electrical path on glass or porcelain are enamels containing powdered silver. Enamels containing powdered metals are also used to provide a base for electroplating on plastics or other nonconductors. Fibrous enamel, used for painting roofs, is an asphalt solution in which asbestos fibers have been incorporated. When of heavy consistency and used for calking metal roofs, it is called Roof putty.

**Erbium.** A rare metallic element, symbol Er, which occurs in the rare mineral Gadolinite, or Ytterbite,  $4\text{BeO} \cdot \text{FeO} \cdot \text{Y}_2\text{O}_3 \cdot 2\text{SiO}_2$ , also the source of holmium, rhenium, and gadolinium. The mineral is found in Greenland and Sweden. Erbium has been obtained only in minute quantities as a dark-gray powder. It forms the rose-red Erbium oxide, or Erbia,  $\text{Er}_2\text{O}_3$ , and other highly colored reddish salts. At high temperatures erbia glows with a greenish light.

**Essential oils.** Aromatic oils found in uncombined form in various parts of plants, and employed for flavors, perfumes, disinfectants, medicines, stabilizers, for masking undesirable odors, and as raw materials for making other products. They are usually the esters upon which the odoriferous properties of the plants depend, and are called essential oils because of their ease of solubility in alcohol to form essences. They are also called Volatile oils, although this term is sometimes also applied to the light and volatile distillates from petroleum. The essential oils are of four general classes: the Pinenes or Terpenes of coniferous plants, containing carbon and hydrogen of the empirical formula  $\text{C}_{10}\text{H}_{16}$ , such as oil of turpentine; Oxygenated oils containing carbon, hydrogen, and oxygen, such as oil of cassia; Nitrogenated oils containing carbon, hydrogen, oxygen, and nitrogen, such as oil of bitter almonds; Sulphurated oils containing carbon, hydrogen, and sulphur, such as oil of mustard. Although fixed vegetable oils are obtained by expression, the essential oils are obtained by distilling the buds, flowers, leaves, twigs, or other parts of the plant. Rose oil is found only in the flowers. Orange and lemon oils are from both the flowers and the fruits, but are of different compositions.



Sweet birch and cinnamon oils are from the bark. Valerian and calamus are only in the roots, while sandalwood and cedar oils are only in the wood. Sometimes the essential oil is not in the plant, but is developed when the plant is macerated with water. The Alpha pinene extracted from turpentine is used for paints and varnishes as it has a high evaporation rate. It is a water-white liquid of pleasant odor boiling at  $163^{\circ}\text{C}$ . It is also used in the synthesis of camphor. Balsams are solid or semisolid resinous oils, and are mixtures of resins with cinnamic or benzoic acids, or both, with sometimes another volatile oil. They are obtained from a variety of trees, and are used in antiseptics, perfumes, flavors, and in medicine.

**Esters.** Combinations of alcohols with organic acids, which form several important groups of commercial materials. The esters occur naturally in vegetable and animal oils and fats as combinations of acids with the alcohol glycerin. The natural fats are usually mixtures of esters of many acids, coconut oil having no less than fourteen. Stearic, oleic, palmitic, and linoleic acid esters are the common bases for most vegetable and animal fats, and the esters of the other acids such as linolenic, capric, and arachidic give the peculiar characteristics of the particular fat, although the physical characteristics and melting points may be governed by the basic esters. Esters occur also in waxes, the vegetable waxes being usually found on the outside of leaves and fruits to protect them from loss of water. The waxes differ from the fats in that they are combinations of mono acids with monohydric, or simple, alcohols, rather than with glycerin. They are harder than fats and have higher melting points. Esters of still lower molecular weights are also widely distributed in the essential, or alcohol-soluble, oils of plants where they give the characteristic odors and tastes. All of the esters have the characteristic formulas  $\text{ArCOOR}$  or  $\text{RCOOR}$ , where R represents an Alkyl, and Ar an Aryl group, that is, where R is a univalent straight-chain hydrocarbon having the formula  $\text{C}_n\text{H}_{2n+1}$ , and Ar is a univalent benzene ring  $\text{C}_6\text{H}_5$ —. In the esters of low molecular weight which make the odors and flavors, the combination of different alcohols with the same acid yields oils of different flavor. Thus the ester methyl acetate,  $\text{CH}_3\text{COOCH}_3$ , is peppermint oil; amyl acetate,  $\text{CH}_3\text{COOC}_5\text{H}_{11}$ , is banana oil; and isoamyl acetate,  $\text{CH}_3\text{COO}(\text{CH}_2)_3(\text{CH}_3)_2$ , is pear oil. Esters are used as solvents,

flavors, perfumes, waxes, oils, fats, fatty acids, pharmaceuticals, and in the manufacture of soaps and many chemicals.

**Etching materials.** Chemicals, usually acids, employed for cutting into, or etching, the surface of metals, glass, or other material. The usual method is to coat the surface with a wax, asphalt, or other substance not acted upon by the acid, cut the design through with a sharp instrument, and then allow the acid to corrode or dissolve the exposed parts. For etching steel, a 25% solution of sulphuric acid in water is used, or a ferric chloride solution may be used. For etching stainless steels a solution of ferric chloride and hydrochloric acid in water in the proportion of 5:1:6 may be used. For high-speed steels, brass, or nickel, a mixture of nitric and hydrochloric acids in water solution is used, or nickel may be etched with a 45% solution of sulphuric acid. Copper may be etched with a solution of chromic acid. Brass and nickel silver may be etched with an acid solution of ferric chloride and potassium chlorate. For red brasses, deep etching is done with concentrated nitric acid mixed with 10% hydrochloric acid, the latter being added to keep the tin oxide in solution and thus retain a surface exposed to the action of the acid. For etching aluminum a 9% solution of copper chloride in 1% acetic acid, or a 20% solution of ferric chloride may be used, followed by a wash with strong nitric acid. Sodium hydroxide, ammonium hydroxide, or any alkaline solutions are also used for etching aluminum. Zinc is preferably etched with weak nitric acid, but requires a frequent renewal of the acid. Strong acid is not used because of the heat generated, which destroys the wax coating. A 5% solution of nitric acid will remove 0.002 in. of zinc per minute, compared with the removal of only 0.0005 in. per min. in most metal-etching processes. Glass is etched with hydrofluoric acid or with White acid. White acid is a mixture of hydrofluoric acid and Ammonium bifluoride, a white crystalline material of the composition  $(\text{NH}_4)\text{FHF}$ .

**Ether.** The common name for Ethyl ether, or Diethyl ether, a highly volatile, colorless liquid of the composition  $(\text{C}_2\text{H}_5)_2\text{O}$  made from ethyl alcohol. It is used as a solvent for fats, greases, resins, and nitrocellulose, and in medicine as an anesthetic. The specific gravity is 0.720, boiling point  $34.2^\circ\text{C}$ , and freezing point  $-116^\circ\text{C}$ . Its vapor is heavier than air and is explosive. Butyl ether,  $(\text{C}_4\text{H}_9)_2\text{O}$ , has a

much higher boiling point,  $140^{\circ}\text{C}$ , is more stable, and is used as a solvent for gums and resins. Isopropyl ether  $(\text{CH}_3)_2\text{CHOCH}(\text{CH}_3)_2$ , is a by-product in the manufacture of isopropyl alcohol from propylene. It has a higher boiling point than ethyl ether,  $69^{\circ}\text{C}$ , and lower solubility in water, and is often preferred as an extractive solvent. Methyl ether, or Dimethyl ether, also known as Wood ether, is a colorless gas of the composition  $(\text{CH}_3)_2\text{O}$ , with a pleasant aromatic odor. The boiling point is  $-23.5^{\circ}\text{C}$ . The specific gravity is 1.562 or, as a liquid compressed in cylinders, 0.724. It is soluble in organic solvents. It is used for fuel, as a welding gas, as a refrigerant, and for vapor-pressure thermometers. Hexyl ether,  $\text{C}_6\text{H}_{13}\text{OC}_6\text{H}_{13}$ , has a high boiling point,  $226.2^{\circ}\text{C}$ , very low water solubility, and a specific gravity of 0.7942. It is stable and not volatile, with a flash point of  $170^{\circ}\text{F}$ . It is used in foam breakers, and in chemical manufacture where anhydrous properties are desired. A low-boiling chemical used as an extractive solvent and for plastics because of its stability in alkalies and its high water solubility is Methylal,  $\text{CH}_3\text{OCH}_2\text{OCH}_3$ . It is a water-white liquid boiling at  $42.3^{\circ}\text{C}$ .

**Ethyl alcohol.** Also called Methylcarbinol, and Ethanol when made synthetically. It is the common beverage alcohol, which when denatured for nonbeverage purposes is called Industrial alcohol. About 90% of the ethyl alcohol used in the United States is denatured. Ethyl alcohol is a colorless liquid with a pleasant odor but burning taste. The composition is  $\text{CH}_3\text{CH}_2\text{OH}$ , specific gravity 0.79, boiling point  $78.5^{\circ}\text{C}$ , and freezing point  $-117.3^{\circ}\text{C}$ . It mixes with water in all proportions and takes up moisture from the air. It burns with a bluish flame and high temperature, yielding carbonic acid and water. The ignition temperature is  $965^{\circ}\text{F}$ . It is one of the best solvents, and dissolves many organic materials such as gums, resins, and essential oils, making solutions called Essences.

Ethyl alcohol is used as a solvent in varnishes, explosives, extracts, perfumes, pharmaceuticals, as a fuel, as a preserving agent, as an antifreeze, and in low-temperature thermometers. Up to 15% of alcohol can be used in gasoline motor fuels without change in the carburation. The German motor fuel Monopolin was a mixture of absolute alcohol and benzene. Ethyl alcohol is classed as a poison

when pure, but is employed as a beverage in many forms. In small quantities it is an exhilarant and narcotic. In all countries large amounts of Beverage alcohol are made from starches, grains, and fruits, retaining the original flavor of the raw material and marketed directly as wines, whiskies, and brandies. Alcohol is produced easily by the fermentation of sugars, molasses, grains, and starch. It is also made cheaply by hydrating ethylene produced by the cracking of petroleum hydrocarbons. In Europe it is also made from the waste liquor of pulp mills by fermentation of the wood sugar. Sulphite pulp liquor contains 1.8% fermentable sugars. It is also made directly from wood waste by fermenting the wood sugar molasses.

Alcohol is sold by the proof gallon, a 100 proof containing 50% alcohol by volume and having a specific gravity of 0.7939. The term Alcohol, alone, refers to 188 to 192 proof. High-purity, Grain alcohol, and Pure ethyl alcohol, are terms for 190 proof. Absolute alcohol, or Anhydrous alcohol, is 200 proof, free of water. Methylated spirits is a term first used in England to designate the excise-free mixture of 90% ethyl alcohol and 10 wood alcohol for industrial use. Denatured ethyl alcohol, made unsuitable for beverage purposes, may be marketed under trade names such as Synasol of the Carbide & Carbon Chemicals Corp. Solox, of the U.S. Industrial Chemicals, Inc., consists of 100 parts 190-proof alcohol, 5 ethyl acetate, and 1 gasoline, used for lacquers, fuel, and as a solvent. Neosol, of the Shell Chemical Corp., is 190-proof ethyl alcohol denatured with 4 parts of a mixture of tertiary butyl alcohol, methyl isobutyl ketone, and gasoline. A substitute for ethyl alcohol for solvent purposes and as a rubbing alcohol is Isopropyl alcohol, or Isopropanol, a colorless liquid of the composition  $(\text{CH}_3)_2\text{CHOH}$ , boiling point  $82^\circ\text{C}$ , and produced by the hydration of propylene from cracked gases. It is also used as a stabilizer in soluble oils, and in drying baths for electroplating. Petrohol, of the Enjay Co., Inc., is isopropyl alcohol.

**Ethylene.** Also called Ethene. A colorless, inflammable gas,  $\text{CH}_2:\text{CH}_2$ , which is produced in the cracking of petroleum. It was first produced in Holland by dehydrating ethyl alcohol by treating it with sulphuric acid. It was originally employed for enriching illuminating gas to give it a more luminous flame, and was called Olefiant gas because it formed an oil, ethylene dichloride, called Dutch liquid,

when treated with chlorine. Its nature as a chemical radical was early discovered, and it was believed by the French chemist Wurtz to be the connecting link between organic and inorganic compounds. Ethylene is now used to produce plastics, ethylene glycol, and a great number of other chemicals. Under the name of Calorene it is marketed in pressure cylinders to replace acetylene for flame-cutting torches. When burned with oxygen, it gives a flame lower in temperature than acetylene, but the gas is more stable in storage. It is produced by dehydrating ethyl alcohol with sulphuric acid, or breaking down alcohol by the catalytic action of heated aluminum oxide or bauxite. It is also produced by the cracking of petroleum. Ethylene is the starting point for a number of chemicals used in making plastics, acrylic acid, styrene, and the vinyl compounds. But ethylene is also polymerized directly with high temperature and pressure to form the water-white translucent Polyethylene plastics of various molecular weights from 1,000 to 40,000. The solid resins are thermoplastic, have high dielectric strength, light weight, low water absorption, good chemical resistance, high flexibility, good strength, and ease of extruding. They are thus valued for electrical-wire insulation, for coating textiles and paper, and for injection-molded parts. For coating purposes, and for thin film for wrapping, the plastic can be used without plasticizers. Resin DYLT, of the Bakelite Corp., is a low-molecular-weight polyethylene used for upgrading paraffin wax for use in cable coating. Polyethylene was used in Germany for high-frequency insulation under the name of Lupolen. Polythene, of E. I. du Pont de Nemours & Co., Inc., is a polyethylene plastic. The specific gravity is 0.85 to 0.95, tensile strength 1,600 to 2,000 psi with elongation 300 to 500%, softening point 220 to 240°F, dielectric strength 1,000 volts per mil. It is resistant to acids, alkalis, and oxygenated solvents, but is soluble in chlorinated hydrocarbons and hot aromatic solvents. The plastic is marketed in the form of molding powder, rod, sheet, tube, and thin foil. The powdered material can be flame-sprayed with an oxypropane flame for coating metals. Alathon, of this company, is polyethylene resin in grades from 8,000 to 19,000 molecular weight, for coating wrapping papers. It is odorless and tasteless, and retains flexibility at low temperatures. Reecon, of Reeves Bros., Inc., is an upholstery fabric woven of polyethylene monofilament. Polyethylene compounded with small

amounts of carbon black has high resistance to weathering, and is used for wire and cable covering.

**Ethylene glycol.** Also known as Glycol and Ethylene alcohol. A colorless, sirupy liquid,  $\text{CH}_2\text{OHCH}_2\text{OH}$ , with a sweetish taste, very soluble in water. It has a low freezing point,  $-25^\circ\text{C}$ , and is much used as an antifreeze in automobiles. A 25% solution has a freezing point of  $-5^\circ\text{F}$ , without appreciably lowering the boiling point of the water. It has the advantage over alcohol that it does not boil away easily, and permits the operation of engines at much higher temperatures than with water alone, thus giving greater fuel efficiency. It is also used as a substitute for glycerin, and as a solvent for nitrocellulose. Diethylene glycol,  $\text{C}_4\text{H}_{10}\text{O}_3$ , is a water-white liquid boiling at  $244^\circ\text{C}$ , used as an antifreeze, as a solvent, and for softening cotton and wool fibers in the textile industry. A 50% solution of diethylene glycol freezes at  $-28^\circ\text{C}$ . Cellosolve,  $\text{C}_2\text{H}_5\text{OCH}_2\text{CH}_2\text{OH}$ , of the Carbide & Carbon Chemicals Corp., is the monoethyl ether of ethylene glycol. It is a colorless liquid boiling at  $135.1^\circ\text{C}$ , and is a powerful solvent used in varnish removers, cleaning solutions, and as a solvent for paints, varnishes, plastics, and dyes. Carbitol, of the same company, is an ether of diethylene glycol of the composition  $\text{CH}_3\text{-CH}_2\text{OCH}_2\text{CH}_2\text{OCH}_2\text{CH}_2\text{OH}$ , used as a solvent for oils, dyes, resins, and gums. The boiling point is  $201.9$  and freezing point  $-76^\circ\text{C}$ . Methyl carbitol, with one less  $\text{CH}_2$  group, is also a high-boiling solvent for gums and resins, and Carbitol acetate is used as a high-boiling solvent for cellulose acetate. Glycol diformate,  $\text{HCOOCH}_2\text{-CH}_2\text{OOCH}$ , used as a solvent for cellulose acetate and nitrocellulose, is a colorless liquid soluble in water, alcohol, and ether. It hydrolyzes slowly, liberating formic acid.

**Ethyl silicate.** A colorless liquid of the composition  $(\text{C}_2\text{H}_5)_4\text{SiO}_4$ , used for making heat-resistant paints, for acidproof cement, for molded objects, and for preserving stone. The specific gravity is 0.920 to 0.950, and boiling range 90 to  $210^\circ\text{C}$ . It contains 25% available silica, though the Tetra ethyl orthosilicate has 27.9% available silica, and the Ethyl silicate 40 of the Carbide & Carbon Chemical Corp. has 40% silica. The latter is a brown liquid. Water hydrolyzes ethyl silicate to alcohol and Silicic acid,  $\text{H}_4\text{SiO}_2$ , which dehydrates to an adhesive amorphous silica. For molding, the ester is

mixed with silica powder, and for such products as bearings wood flour may be incorporated to absorb and retain the lubricating oil. Ethyl silicate solutions are employed for the surface hardening of sand molds and graphite molds for special casting. Silicic acid ester paints are used to harden and preserve stone, cement, or plaster, and for coating insulating brick. They are resistant to heat and to chemical fumes. Synthetic resin lacquers containing ethyl silicate have high adhesion to glass.

**Excelsior.** A name for the continuous, curly, fine wood shavings employed as a packing material to prevent breakage of fragile articles in shipping, or as a stuffing material. It is light and elastic. It was originally called Wood fiber or Wood wool. The raw material used in its manufacture is mainly aspen and basswood, or it may be made as a by-product of other wood manufactures. Poplar and cottonwood are also employed. A cord of wood yields about 1,500 lb of excelsior.

**Expanded metal.** Sheet metal that has been slit and expanded to form a mesh, which is used for reinforced concrete work or plaster wall construction, and also for making grilles, vents, and for such articles as trays, where stiffness is needed with light weight. The expanded metal has greater rigidity than the original metal sheet, and also permits a welding of the concrete or plaster through the holes. It is made either with a plain diamond-shaped mesh, or with rectangular meshes. One type is made by slitting the sheet and stretching the slits into the diamond shape. The other variety is made by pushing out and expanding the metal in the meshes so that the flat surface of the cut strand is nearly at right angles to the surface of the sheet. Expanded metal is made from low-carbon steel, iron, or special metals, in sheets from 8 to 12 ft in length and 3 to 6 ft in width, in several thicknesses. It is also marketed as Metal lath, usually 96 in. long, and 14 to 18 in. wide. Expanded metal of the U.S. Gypsum Co. is made of stainless steel and aluminum alloys in various thicknesses with openings from  $\frac{1}{2}$  to  $1\frac{1}{2}$  in. Rigidized steel is thin sheet steel that is not perforated, but has the designs rolled into the sheet so that the rigidity of the sheet is increased two to four times. Thus, extremely thin sheets of stainless steel can be used for novelties, small mechanical products, and for paneling. The Rigid-Tex steel, of

the Rigid-Tex Corp., is made in many intricate ornamental designs, and comes also in vitreous enameled sheets for paneling. Crimp metal, of the American Nickeloid Co., has various designs of embossing in either raised or depressed ridges rolled into the polished side of the metal. Perforated metals are sheet metals with the perforations actually blanked out of the metal. They are marketed in sheets in carbon steel, stainless steel, or monel metal, with a great variety of standard perforation designs. Those with round, square, diamond, and rectangular designs are used for screens and for construction. Agaloy, of the Agaloy Tubing Co., is perforated metal made into tube form.

**Expansive metal.** An alloy which expands on cooling from the liquid state. The expansive property of certain metals is an important characteristic in the production of accurate castings having full details of the mold such as type castings. The alloys are also used for proof-casting of forging dies, for sealing joints, for making duplicates of master patterns, for holding die parts and punches in place, and for filling defects in metal parts or castings. Antimony and bismuth are the metals most used to give expansion to the alloys. Lewis metal, one of the original expansive alloys, had one part of tin and one of bismuth, and melted at 138°C. Matrix alloy and Cerromatrix, of the Cerro de Pasco Copper Corp., contain 48% bismuth, 28.5 lead, 14.5 tin, and 9 antimony. The melting point is 248°F, tensile strength 13,000 psi, and Brinell hardness 19. Cerrobaze, of this company, is another alloy balanced to give the exact impression of the mold without shrinkage or expansion in cooling. It is harder than lead, and melts at 255°F.

**Explosive.** A material which, upon application of a blow, or by rise in temperature, is converted in a small space of time into other compounds more stable and occupying much more space. Commercial explosives are solids or liquids that can be instantaneously converted by friction, heat, shock, or spark, into a large volume of gas, thereby developing a sudden rise in pressure which is utilized for blasting or propelling purposes. Gunpowder is the oldest form of commercial or military explosive, but this has been replaced for military purposes by more powerfully acting chemicals. Smokeless powder was a term used to designate nitrocellulose powders as distinguished from the



smoky black gunpowder. Blasting powders are required to be relatively slow acting to have a heaving or rending effect. Military explosives used as propellants must not give instantaneous detonation, which would burst the gun, but are arranged to burn slowly at first and the explosion does not reach a maximum until the projectile reaches the muzzle. The more rapid-acting High explosives are generally used for bombs, torpedoes, Boosters, and Detonators. The detonators are the extremely sensitive explosives, such as lead azide, set off by a slight blow but too sensitive to be used in quantity as a charge. The booster explosives are extremely rapid but not as sensitive as the detonators. They are exploded by the detonators and in turn set off the main charge of explosive. Some explosives such as nitroglycerin can be exploded by themselves, while others require oxygen carriers or carbon carriers mixed with them. Other requirements of explosives are that they should not react with the metal container, be stable at ordinary temperatures, and should not decompose easily in storage or on exposure to the air.

Shaped charges of high explosive give a penetrating effect, known as the Monroe effect, used in armor-piercing charges. A solid mass of explosive spends itself as a flat blast, but with a conical hole in the charge, having the open end facing the target, a terrific piercing effect is generated by the converging detonation waves coming from the sides of the cone, and drives a jet of hot gases through the steel armor. Permissible explosives are explosives that have been passed by the Bureau of Mines as safe for blasting in gaseous or dusty mines. Most of the permissibles are of ammonium nitrate or gelatin base. Lox, used in mines and quarries, is an explosive consisting of a paper cartridge filled with carbon black or wood pulp soaked in liquid air. It cannot be tamped as it is very sensitive. It is fired by electric detonators. Cardox, an explosive used in coal mining, consists of liquid carbon dioxide in a steel cylinder with aluminum powder. The powder is fired by an electric spark, heating and gasifying the carbon dioxide. Picric acid, or Trinitrophenol,  $C_6H_2(OH)(NO_2)_3$ , a lemon-yellow crystalline solid melting at  $248^\circ F$ , is a powerful explosive used in shells, and because of its persistent color also used as a dye-stuff. It is called Melanite by the French, Lyddite by the English, and Schimose by the Japanese. It is made by treating phenol with sulphuric and nitric acids, or can be produced by treating acaroid resin

with nitric acid. It reacts with metals to form dangerous explosive salts, so that the shells must be lacquered. Cressylite, used for shells, is a mixture of picric acid and trinitrocresol. It has a lower melting point.

Explosive D, or Dunnite, made by the neutralization of picric acid with ammonium carbonate, is Ammonium picrate,  $C_6H_2(NO_2)_3 \cdot ONH_4$ . It forms orange-red needles that explode when heated to  $300^\circ C$ , but is not highly sensitive to friction. It is used as a bursting charge in armor-piercing shells. Trinitrotoluene, or Trinitrotoluol,  $C_6H_2(CH_3)(NO_2)_3$ , also commonly known as TNT, is the principal constituent of many explosives. It resembles brown sugar in appearance, melts at  $80^\circ C$ , and the fumes are poisonous even when absorbed through the skin. It is not as powerful as picric acid, but is very stable, not hygroscopic, and does not form unstable compounds with metals. It is exploded easily with mercury fulminate, and is used for shrapnel, hand grenades, mines, and depth bombs. TNT is made by the nitration of toluol with nitric and sulphuric acids. The intermediate product, Dinitrotoluol, is employed with hexanitrodiphenylamine for torpedoes. Hexanitrodiphenylamine,  $(NO_2)_3C_6H_2 \cdot NH \cdot C_6H_2(NO_2)_3$ , is a powder that explodes with great violence. It is highly poisonous, and causes painful blisters and inflammation. The commercial explosive Sodatol is made by mixing TNT with nitrate of soda.

Pentolite, used in rockets and as a booster and filler in shells, is made by nitrating an alcohol produced by treating a mixture of formaldehyde and acetaldehyde with lime. It is 20% more powerful than TNT. It melts below the boiling point of water and can be poured into shells. Trinitroaniline,  $(NO_2)_3C_6H_2NH_2$ , commonly known as TNA, is derived from aniline by nitration, and is one of the strongest of the high explosives. It is a yellowish-green crystalline powder melting at  $215^\circ C$ . It stains the skin yellow but is not poisonous. It is more sensitive to shock than TNT and is more costly. Trinitro anisol, used in Japanese Baka planes, has the composition  $C_6H_2OCH_3(NO_2)_3$ . It is about equal to TNT in power, and has the advantage that it does not attack metals.

Tetryl, or Pyronite,  $(NO_2)_3C_6H_2N(NO_2)CH_3$ , is a nitro derivative of benzene. It is a yellow crystalline powder melting at  $130^\circ C$ , and exploding when heated to  $186^\circ C$ . It is more sensitive to shock

than TNA, and has a higher rate of detonation than TNT. It is too sensitive to be used as a shell filler, and is employed as a booster and in commercial explosives to replace mercury fulminate for detonators. The extremely high explosive RDX is Cyclo trimethylene trinitroamine. It is used in bombs, torpedoes, mines, and rockets, but is very sensitive to shock and is mixed with waxes or plasticizers to reduce sensitivity. The blast effectiveness of TNT is increased 50% when 60% of RDX is mixed with it. When aluminum powder is added to high explosives, the brisance or blast effect is increased greatly. A powerful explosive used during the war contained 40% of RDX, 40 TNT, and 20 aluminum powder.

**Fat liquors.** Oil and grease emulsions used in tanneries for treating tanned leather to lubricate the fibers, increase the flexibility, and improve the finish. There are two general types of fat liquor emulsions: acid and alkaline. The acid group includes sulphonated oils and some soluble oil combinations. Alkaline types are emulsions of oils with soaps or alkalies. Leather may also be treated first with an alkaline liquor and then with an acid, or borax or soda ash may be added to sulphonated oils to produce alkaline liquors. For suède and white leathers, egg-yolk emulsions may be used. The oils employed in emulsions may be sperm, cod, or castor oil, and those that are neutral have a neatsfoot oil base. The soaps are usually special for the tannery trade. Prepared fat liquors are also marketed under trade names. The Tanners' greases, used for sponging or milling onto the leather, are also usually trade-named mixtures of waxes, sulphonated oils, and soaps.

**Fats.** Natural combinations of glycerin with fatty acids, some fats having as many as 10 or more different fatty acids in the combination. They are derived from animal or vegetable sources, the latter source being chiefly the seeds or nuts of plants. Fats in a pure state would be odorless, tasteless, and colorless, but the natural fats always contain other substances that give characteristic odors and tastes. Fats are used directly in foods and also in the making of various foodstuffs. They are also used in making soaps, candles, lubricants, and in the compounding of resins and coatings. They are also distilled or chemically split to obtain the fatty acids. The annual world consumption of fats is tabulated at 26 million metric tons, but actual

consumption is much higher because of unrecorded consumption in meats, nuts, and other products. Fats are most important for food, containing more than twice the fuel value of other foods. They are also important carriers of glycerin necessary to the human system. Metabolism, or absorption of fats into the system, is not a simple process, and is varied with the presence of other food materials. The fats with melting points above  $45^{\circ}\text{C}$  are not readily absorbed into the system. The heavy fats are called tallow. Lack of certain fats, or fatty acids, causes skin diseases, scaly skin, and other affections. Some fatty acids are poisonous alone, but in the glyceride form in the fats they may not be poisonous but beneficial. Fats can be made synthetically from petroleum or coal. During the war the Germans produced fatty acids by oxidation of paraffin recovered from the hydrogenation of brown coal and lignite. Edible fats were then produced by esterifying the  $\text{C}_8$  to  $\text{C}_{16}$  fractions of the acids. But the world resources of natural fats are potentially unlimited, especially from tropical nuts, forming a cheap source of fatty acids in readily available form.

**Fatty acids.** A series of organic acids deriving the name from the fact that the higher members of the series, the most common ones, occur naturally in animal fats. All of these acids contain the carboxyl group  $\text{—COOH}$ . The acids are used for making soaps, candles, coating compounds, as plasticizers, and for the production of plastics and many chemicals. The hydrogen atom of the group can be replaced by metals or alkyl radicals with the formation of salts or esters, and other derivatives such as the halides, anhydrides, peroxides, and amides can also be made. Some of the fatty acids can be polymerized to form plastics. Various derivatives of the acids are used as flavors, perfumes, driers, pharmaceuticals, and antiseptics. Certain fatty acids, such as oleic and stearic, are common to most fats and oils regardless of their source, while others, such as arachidic and erucic, are characteristic only of specific fats and oils. The names of the fatty acids often suggest their natural sources, though commercially they may be derived from other sources or made synthetically. Butyric acid,  $\text{CH}_3\text{CH}_2\text{CH}_2\cdot\text{COOH}$ , is the characteristic acid of butter. Also called Butanoic acid and Ethylacetic acid, it is made synthetically as a colorless liquid with a strong odor and completely soluble in water. With alcohols it forms butyrates of pleasant fruity odors used as flavors.

The cellulose esters of butyric acid are used in lacquers, and have good water resistance and easy solubility in hydrocarbons.

Some acids, such as linoleic, are found in greater amount in cold-climate products, while some other acids are found in most abundance in hot-climate products. Lauric acid, or Dodecanoic acid, occurs in high percentage in the oil of the coconut and other kernels of tropical palm nuts. It is a saturated acid much lower in carbon and hydrogen than linoleic acid, and is a semisolid melting at 44°C. It is one of the chief constituents of coconut oil that gives sudsing properties to soaps. It is also used for making detergents and plasticizers, and as a modifier for waxes in coatings and polishes. The ester of lauric acid is used for treating cotton fabrics to give a pebbly surface. Lauralene is a lauric acid of the Beacon Co. with an acid value of 324 and saponification number of 366. Methyl laurate is often preferred to lauric acid for all the uses. It is a stable, noncorrosive, water-white liquid. Caprylic acid, obtained from coconut oil, has a melting point of 11°C, acid number of 386, and iodine value of 1. It is used in cosmetics, as a fungicide, and in the manufacture of pharmaceuticals. Caproic acid, or Hexanoic acid,  $\text{CH}_3\text{CH}_2\text{CH}_2\text{CH}_2\text{CH}_2\text{COOH}$ , occurs in coconut and palm kernel oils, but is produced synthetically on a large scale for the manufacture of hexylresorcinol, hexylphenols, flavors, and high-boiling plasticizers. It is a liquid boiling at 203°C having a goatlike odor from which it derives its name. Fatty acids are called saturated when they contain all the hydrogen with which they can combine, and they have the type formula  $\text{C}_n\text{H}_{2n+1}\text{COOH}$ . They have high melting points. Unsaturated fatty acids, such as oleic and linoleic, are liquid at room temperature, and are less stable than saturated acids. Fatty acid glycerides in the form of animal and vegetable fats form an essential group of human foods. Fats of the highly unsaturated acids are necessary in the metabolism of the human body, the saturated acids such as oleic not being sufficient alone.

**Feathers.** The light fluffy outgrowth or plumage of birds. The industrially important feathers are those from the duck, goose, chicken, ostrich. Radiantly colored feathers from many other types of birds are used for ornamental and art purposes. An important featherwork art exists in Mexico as a development of the Aztec

**featherwork.** Down is the soft feathers of young birds or the soft undergrowth of adult birds, used as a stuffing material. Eider down, from the eider duck, is highly valued for stuffing. About 100 million pounds of chicken feathers annually come from the commercial preparation of chickens in the United States. Some of these are used in the textile and plastics industries. The midrib and quill are made into protein plastic, and the fluffy barbs are used as stuffing, or are mixed with wool or cotton for weaving into light warm fabrics. Ostrich feathers, from the domesticated ostriches of Argentina, South Africa, and Australia, are used for ornamental purposes, hats, and dusting brushes. The ostrich has 24 feathers on each wing, some as long as 25 in., and the grade depends upon the color and the length. Male ostrich feathers are black. The female feathers are a soft gray, with white feathers in the wings and tail. The life of the ostrich is 50 to 75 years, and the feathers begin to be clipped at the age of 10 months. Ostrich eggs, which weigh 4 lb and are laid every other day, are a valuable food by-product.

**Feldspar.** A general name for a group of abundant minerals used for vitreous enamels, pottery, tile, glass, in fertilizers, in fluxes, for roofing granules, and as an abrasive in soaps and cleaning compounds. Ground feldspar is also used for extinguishing magnesium fires as it melts and gives a smothering action. There are many varieties of feldspar, but those of greatest commercial importance are the Potash feldspars, Orthoclase or Microcline,  $K_2O:Al_2O_3 \cdot 6SiO_2$ , the Soda feldspar, Albite,  $Na_2O:Al_2O_3 \cdot 6SiO_2$ , and the Calcium feldspar, Anorthite,  $CaO:Al_2O_3 \cdot 2SiO_2$ . Orthoclase and microcline have the same composition but different crystal structures. Orthoclase is called Sunstone. Moonstone, cut as gem stone, is a feldspar with a blue or blue and white opalescence, but the blue opalescent moonstone of New Mexico is Sanidine, a quartz mineral. Amazon stone, or Amazonite, is a beautiful green microcline found in Italy, Madagascar, and Colorado, used as a gem stone. The Amazon stone of Virginia has bluish-green and white streaks, and was formerly shipped to Germany for cutting into ornamental objects. The colors of feldspar are from mineral oxides and impurities and are white, gray, yellow, pink, brown, and green. Albite is generally white, while microcline is more often green.

All of the chemical components of feldspar are glassmaking materials, and in making glass about 150 lb are used to each 1,000 lb of sand. But the mineral in its natural occurrence varies widely in composition even in the same mine, and thus must be controlled chemically to obtain uniform results in glass and ceramic enamels. It occurs in pegmatite dikes associated with quartz, mica, tourmaline, garnet, and spodumene. The mineral is ground to a uniform size, from 80 to 140 mesh, and shipped in bags. Crude unground feldspar is also marketed in bulk. The melting point varies from 1185 to 1490°C, but the preferred range is 1250 to 1350°C. The hardness is 6 to 6.5, and the index of refraction is 1.518 to 1.588, the lowest being orthoclase and the highest anorthite. The specific gravity is 2.44 to 2.62 for orthoclase and microcline, and 2.6 to 2.8 for anorthite. Tennessee and North Carolina feldspar has about 70%  $\text{SiO}_2$  and 17  $\text{Al}_2\text{O}_3$ , with 9 to 11  $\text{K}_2\text{O}$ , and 2 to 3  $\text{Na}_2\text{O}$ . New England feldspar is lower in silica and higher in potash. Potash spar from New York and New Jersey has about 12%  $\text{K}_2\text{O}$ , and is suited for glass and pottery. Soda spar, with about 7%  $\text{Na}_2\text{O}$ , is preferred for ceramic enamels. Cornwall stone, from England, is a kaolinized feldspar with about 2%  $\text{CaO}$ . A similar stone from North Carolina is called Carolina stone. Aplite is a ceramic fluxing stone found in Virginia and used chiefly to supplement feldspar to provide more alumina. It is a white massive material of feldspars and other minerals, containing 60% silica, 24 alumina, 6 calcia, 6 sodium oxide, and 3 potassium oxide. Another feldspar material is Alaskite, a feldspar and quartz mixture from North Carolina. It is classed as a pegmatitic granite. Ground feldspar for enamels is sometimes called Glass spar. Dental spar is specially selected potash feldspar used in making artificial teeth.

**Felt.** A fabric of wool, fur, or hair made by matting the fibers together under pressure when thoroughly soaked or steam-heated. The matting may also be accomplished by blowing the wet fibers under a powerful air blast and then pressing. The animal fibers mat together, owing to minute scales on their surface. Cotton and other vegetable fibers do not have the property of felting, but a percentage of vegetable or synthetic fibers may be incorporated to vary the characteristics of the felt. So great is the felting property of wool that

only 20% is needed in mixtures. Most commercial felts are mixtures. New and reworked wool and noils are mixed with cotton, rayon waste, ramie, jute, casein fiber, and other fibers. Cotton decreases the density and prevents voids in the felt. Filter felts usually have a high percentage of cotton fibers. Kapok gives lower thermal and sound conductance, and Insulating felt may contain a high percentage of kapok. Felt is made of staple fibers of about  $1\frac{1}{2}$  in. length, and noils of  $\frac{3}{4}$  to 1 in. Longer fibers tend to mat. Shorter fibers lack depth of penetration to give necessary strength. Since most of the wool used is secondary or waste, all grades are employed, from the fines to the coarse carpet wools.

Felt is the most ancient of all fabrics. It is now used for insulation, sound and vibration absorption, for padding and lining in instrument cases, hats, roofing, and where a soft resilient fabric is needed. Although the best hat felts are made with nutria or beaver fur, vast quantities of rabbit furs or mixed furs and wool are used. Hair felt is made of cattle hair, and is used for insulating cold-water pipes and refrigerating equipment, and for cushioning and padding. The Ozite felt of the American Hair & Felt Co. is an all-hair felt. Felt comes in thicknesses from  $\frac{1}{4}$  to 2 in., the  $\frac{1}{4}$  in. weighing 4 oz per sq ft. The K felt of the American Felt Co. is made to Army-Navy specifications and weighs 3.24 lb per sq yd per in. of thickness. It has a tensile strength of 12 psi and compressive strength of 3 psi at 50% deflection. It is for sound and thermal insulation.

Roll felt, for mechanical use, may have a density range 7 lb per sq yd for soft padding, to 16 lb for hard service. Cattle- and goat-hair felts are also used for glass polishing. Baize is an old name for a thin woolen felt used for desk and table tops, box linings, and for bases of instruments. Its name is derived from the fact that it was originally bay, or brown, colored, but the industrial baize is now usually green. The name is now used to designate a plain-woven, loose, cotton or woolen fabric with a short, close nap, in plain colors for the same purposes. Feltex, of the Philip Carey Co., is an asphalt-saturated felt for roofing, and Mica-kote is a heavy felt coated with asphalt and finished with mica flakes, used for roofing. Unisorb, of the Felters Co., Inc., is a heavy felt in blocks and sheets for isolation pads under machinery to absorb vibration. Slaters' felt is a tarred sheathing felt used in building construction, usually in 25- and 30-lb



rolls. Fire felt, of Johns-Manville, is made of asbestos fibers felted into sheets, blocks, or shapes, for boiler and furnace insulation. Slatekote, of the same company, is a heavy felt saturated with asphalt and coated with colored crushed slate, used for roofing.

**Ferric oxide.** The Red iron oxide,  $\text{Fe}_2\text{O}_3$ , found in abundance as the ore hematite, or made by calcining the sulphate. It has a dark-red color and comes in powder or lumps. The specific gravity is 5.20, and melting point about  $1550^\circ\text{C}$ . It is used as a paint pigment under such names as Indian red, Persian red, Persian Gulf oxide. In cosmetics and in polishing compounds it is called rouge. The Persian red oxide from the Island of Hormuz contains from 60 to 90%  $\text{Fe}_2\text{O}_3$ , and is marketed on a 75% basis. The brown ferric oxide is made from ferrous sulphate and sodium carbonate and is not a pure oxide. The names Metallic red and Metallic brown are applied to pigments from Pennsylvania ores containing a high percentage of red iron oxide. Venetian red is a name for red iron oxide pigments mixed with various fillers. The Tuscan red pigments are red iron oxide blended with up to 75% of lakes, but may also be barium sulphate with lakes. Ferric oxide pigments make low-priced paints, and are much used as base coats for structural steel work. The oxides come chiefly from Alabama, Tennessee, Pennsylvania, Persia, and Spain. The Auric brown of E. I. du Pont de Nemours & Co., Inc., used for giving light-fast shades to paper, is a hydrated ferric oxide ground to an extremely fine particle size. Black ferric oxide is a reddish-black amorphous powder,  $\text{FeO} \cdot \text{Fe}_2\text{O}_3$ , made by burning iron in an excess of oxygen. It is used as a paint pigment, for polishing compounds, and for decarbonizing steel. Magnetic black is a name for finely ground magnetic oxide used as a pigment. Hammer scale is the iron oxide  $\text{Fe}_3\text{O}_4$ , formed in the hot rolling or forging of steel, and is used for decarbonizing steel by packing the steel articles in the scale and raising to a high temperature. It is very hard, 5.5 to 6.5 Moh, and is also used as an abrasive.

**Ferrochromium.** A high-chromium iron master alloy used for adding chromium to irons and steel. It is also called Ferrochrome. It is made from chromite ore by smelting with lime, silica, or fluorspar in an electric furnace. High-carbon ferrochrome, of the Electro Metallurgical Co., contains 66 to 70% chromium in grades of 4.5, 5, 6,

and 7% carbon. It is used for making tool steels, ball-bearing steels, and other alloy steels. It melts at about 1250°C. It is marketed as crushed alloy in sizes up to 2 in., and as lump alloy in lumps up to about 75 lb. Low-carbon ferrochrome of this company and the Vanadium Corp. of America contains 67 to 72% chromium, in grades of 0.06, 0.10, 0.15, 0.20, 0.50, 1, and 2% carbon. It is used for making stainless steels and acid-resistant steels. Low-carbon ferrochrome is also preferred for alloy steel mixtures where much scrap is used because it keeps down the carbon and inhibits the formation of hard chromium carbides. The various grades of ferrochromium are also marketed as High-nitrogen ferrochrome, with about 0.75% nitrogen for use in making high-chromium cast steels which would normally have a coarse crystalline structure. The nitrogen refines the grain and increases the strength. Foundry-grade ferrochrome, for making cast irons, contains 62 to 66% chromium and 5 carbon. The V-Foundry alloy of the Vanadium Corp. has about 40% chromium, 18 silicon, and 6 manganese. It is used for ladle additions to cast iron to give uniform structure and increase the strength and hardness.

**Ferromanganese.** A master alloy of manganese and iron used for deoxidizing steels, and for adding manganese to iron and steel alloys and bronzes. Manganese is the common deoxidizer and cleanser of steel, forming oxides and sulphides that are carried off in the slag. Ferromanganese is made from the ores in either the blast furnace or the electric furnace. Standard ferromanganese has 78 to 80% manganese. British ferromanganese contains about 7% carbon, but the content in the American alloy is usually 5 to 6.5%. Low-carbon ferromanganese is also marketed containing 0.10 to 1% carbon. Low-phosphorus ferromanganese contains less than 0.10% phosphorus. The alloys are marketed in lumps to be added to the furnace. Spiegeleisen is a form of low-manganese ferromanganese with from 15 to 30% manganese and from 4.5 to 5.5 carbon. The German name, meaning mirror iron, is derived from the fact that the crystals of the fractured face shine like mirrors. Spiegeleisen has the advantage that it can be made from low-grade manganese ores, but the quantity needed to obtain the required proportion of manganese in the steel is so great that it must be premelted before adding to the

steel. It is used for making irons and steels by the bessemer process. Grade A spiegeleisen, of the Electro Metallurgical Co., has 19 to 21% manganese, and 1 silicon; Grade B has 26 to 28% manganese and 1 silicon. The melting point is from 1950 to 2265°F.

**Ferrophosphorus.** An iron containing a high percentage of phosphorus, used for adding phosphorus to steels. Small amounts of phosphorus are used in open-hearth screw steels to make them free-cutting, and phosphorus is also employed in tin-plate steels to prevent sticking together of the plates in annealing. Ferrophosphorus is made by melting phosphate rock together with the ore in making the pig iron. The phosphorus content is about 18% and is chemically combined with the iron. Another grade, made in the electric furnace and containing 23 to 25% phosphorus, is used for adding phosphorus to bronzes. A master alloy for adding selenium to steels to give free-machining qualities to steel, particularly the stainless steels, is Ferroselenium. A typical ferroselenium, of the American Smelting & Refining Co., contains about 52% selenium and 0.90 carbon.

**Ferrosilicon.** A high-silicon master alloy used for making silicon steels, and for adding silicon to transformer irons and steels. It is made in the electric furnace by fusing quartz or silica with iron turnings and carbon. It is marketed in various grades with from 15 to 90% silicon. The silicon forms a chemical combination with the iron, but the alloys having more than about 30% silicon are fragile and unstable. The silicon also causes the carbon to be excluded in graphite flakes. The alloys of high silicon content are called Silicon metal. One producer markets two grades, 15 and 45% silicon, while another has 15, 50, 75, 85, and 90% grades. Grades with silicon from 80 to 95% are marketed for use where small ladle additions are made for producing high-silicon steels, and also for producing hydrogen by reaction with caustic soda. The alloy is marketed in lumps or crushed form. Silicon is often added to steels in combination alloys with deoxidizers or other alloying elements. Ferrosilicon aluminum, containing about 45% silicon and 12 to 15 aluminum, is a more effective deoxidizer for steel than aluminum alone. It is also used for adding silicon to aluminum casting alloys. Silvaz, of the Electro Metallurgical Co., is a ferrosilicon aluminum containing also vanadium and zirconium. The alloy serves as a deoxidizer and

fluxes the slag inclusions, and also controls the grain size of the steel. Simanal, of the Ohio Ferro Alloys Corp., is a Deoxidizing alloy containing 20% each of silicon, aluminum, and manganese. Alsifer, of the Vanadium Corp. of America, contains 40% silicon, 20 aluminum, and 40 iron. The aluminum and silicon are in the form of an aluminum silicate which forms a slag that is eliminated during the teeming of the steel. Alsimin is a Swiss ferrosilicon aluminum with 50% aluminum. Silicon aluminum is a master alloy for adding silicon to aluminum alloys, and it does not contain iron. A 50-50 silicon aluminum, of Alloys & Products, Inc., has a melting point of 1920°F, but is soluble in aluminum at 1275°F. It comes in pyramid waffle form for breaking into small lumps.

**Ferrotitanium.** A master alloy of titanium with iron used as a purifying agent for irons and steel owing to the great affinity of titanium for oxygen and nitrogen at temperatures above 800°C. The value of the alloy is as a cleanser, and little or no titanium remains in the steel unless the percentage is gaged to leave a residue. The Ferro-carbon-titanium is made from ilmenite in the electric furnace, and the carbon-free alloy is made by reduction of the ore with aluminum. Ferrotitanium comes in lumps, crushed, or screened. High-carbon ferrotitanium, of the Vanadium Corp. of America, has 17% titanium and 7 carbon. It is used for ladle additions for cleansing steel. Low-carbon ferrotitanium has 20 to 25% titanium, 0.10 carbon, 4 silicon, and 3.5 aluminum. It is used as a deoxidizer and as a carbide stabilizer in high-chromium steels. Graphidox, of this company, for treating high-strength irons, has 10% titanium, 42 to 46 silicon, and 6 calcium. The Grainal alloys of this company, for controlling alloy steels, have various compositions. Grade No. 6 has 20% titanium, 13 vanadium, 12 aluminum, and 0.20 boron. Tam alloy No. 78, of the Titanium Alloy Mfg. Co., contains 15 to 18% titanium, 7 to 8 carbon, with low silicon and aluminum. It is used in cast iron and steels. Tam alloy No. 35 has 18 to 21% titanium, and only 3.5 to 4.5 carbon. Its melting point is 2750°F. Ferrotitaniums with 18 to 22% titanium are used for making fine-grained forging steels. Carbotam, of this company, contains 16 to 17% titanium, 2.5 to 3 silicon, 6.5 to 7.5 carbon, 1.5 to 2 boron, and less than 1 carbon. It is used for cast steels to contain boron for high hardness. Manganese tita-

nium is used as a deoxidizer for high-grade steels and for nonferrous alloys. A common grade contains 38% manganese, 29 titanium, 8 aluminum, 3 silicon, 22 iron, and no carbon. Nickel titanium is used for hard nonferrous alloys. The low-iron grade contains 15% titanium, 5 aluminum, 4 silicon, 1 iron, and 75 nickel.

**Ferrous sulphate.** Also called Iron sulphate and Green vitriol. It is a green crystalline material of the composition  $\text{FeSO}_4 \cdot 7\text{H}_2\text{O}$ . It occurs naturally as the mineral Melanterite. It is produced by the action of dilute acid on iron and is a by-product of the galvanizing and tinning industries, recovered from the pickling baths. The specific gravity is 1.898, melting point  $64^\circ\text{C}$ , and it is soluble in water. On exposure to the air it becomes yellowish because of the formation of basic iron sulphate, and on heating to  $140^\circ\text{C}$  becomes a white powder,  $\text{FeSO}_4 \cdot \text{H}_2\text{O}$ , which also occurs as the mineral Szomolnokite. Ferrous sulphate, under the name of Copperas, is an important salt in the ink industry to give color permanence to the inks. It is also employed in water purification, as a disinfectant, in polishing rouge, as a mordant in dyeing wool, and in the production of pigments. Prussian blue, or Chinese blue, is Ferric ferrocyanide,  $\text{Fe}_4[\text{Fe}(\text{CN})_6]_3$ , a blue amorphous powder used as a pigment. It is made by combining iron chloride and potassium ferrocyanide. Celestial blue is the light-blue pigment made by extending Prussian blue with barytes. Ferric sulphate is a grayish amorphous powder of the composition  $\text{Fe}_2(\text{SO}_4)_3 \cdot 9\text{H}_2\text{O}$ , or  $\text{Fe}_2(\text{SO}_4)_3$ . The specific gravity of the hydrous is 2.1, and of the anhydrous 3.097. It is very soluble in water, and is used as a pigment, as a mordant in dyeing, for etching aluminum and steel, and as a disinfectant. Ferrisul, of the Monsanto Chemical Co., is anhydrous ferric sulphate used for speeding the action of metal pickling baths and for descaling boilers. In etching steel, the action of anhydrous ferric sulphate is 30 times more rapid than sulphuric acid.

**Fertilizers.** Materials used to add to the soil to supply plant food either directly or by chemical reaction with the soil. The preparation of fertilizers is now one of the major industries, and the commercial fertilizers include nitrates, phosphates, potash salts, calcium salts, and mixtures. They may also include the materials which regulate the acidity of the soil for better plant production, such as lime, and the

materials which act as soil conditioners, as methyl cellulose. Chemicals used as fertilizers must not be of such nature as to kill earthworms, which normally average more than a million per acre and are needed for invigorating and loosening the soil. The value of fertile soils was understood in most ancient times, and natural fertilizers were used, including the use of sulphur for the vineyards of the Romans. But fertilizers were not understood or used in western Europe, and the lands were strikingly depleted before the introduction of their use from the Indians of America. The Algonquins employed fish as fertilizer, and the Incas of Peru and Bolivia used vast quantities of guano. Guano (Quichua word Huano, guttural h) is the excrement of fish-eating sea birds deposited in great amounts on the dry rocky islands of the Peruvian coast. It contains 12 to 16% nitrogen. It was formerly imported into the United States, but is now replaced by nitrates. Some guano from caves, deposited by bats, is recovered in the United States for fertilizer. During the American Civil War, Bat guano from the great caves of Virginia was used in the South to produce saltpeter. Much barnyard manure is employed as fertilizer, but does not enter the commercial mixed fertilizers except the dried and ground sheep and cow manures. Much local fertilization is also done by the planting and plowing under of legumes that bring nitrogen from the air and also serve as soil conditioners. Chilean nitrate, phosphate rock, and potash are the chief natural minerals used as fertilizers. Nitrogen is needed in most soils, and phosphorus is a necessary ingredient in soils. Large quantities of muriate of potash are used in fertilizers to supply  $K_2O$ , while vast quantities of hydrated lime are employed to supply  $MgO$  and to reduce acidity of some soils. Potassium, calcium, and sodium are also supplied in combination forms especially with ammonia to yield nitrogen. Ammonium sulphate yields both nitrogen and sulphur. Ground gypsum is a source of sulphur trioxide for cotton, tobacco, grapes, and some other crops. It also helps to liberate soluble potash and stimulates growth of nitrogen-fixing bacteria in the soil. Calcium cyanamid is employed as a fertilizer to yield nitrogen and calcium. Crude urea is now also used as a fertilizer, and has the nitrogen in the same form as in the natural guanos and manures. Uramon, of E. I. du Pont de Nemours & Co., Inc., is a urea fertilizer in the form of a dark-brown powder easily soluble in water and yielding 42% nitrogen, equivalent to

51% ammonia. It also contains calcium and phosphorus. Urea-form, developed by the U.S. Department of Agriculture, is a hygroscopic powder made by reacting urea with a small amount of formaldehyde and crushing. It may also be mixed with ammonium nitrate.

Superphosphates, made by sulphuric acid treatment of phosphate rock, are used in large quantities in fertilizer mixtures. The German fertilizer Nitrophoska is a nitrate-phosphate-potash made by treating phosphate rock with nitric acid, neutralizing with ammonia, and then granulating with potassium salts. The Calcium nitrate tetrahydrate which is precipitated off is also used as fertilizer. Fish meal, castor pomace, cottonseed meal, soybean meal, copra cake, and other residues from oil pressing are used as commercial fertilizers. Tankage from the meat-packing plants is also an important fertilizer material. Whale guano, from South Georgia and Newfoundland, is a mixture of whale-meat meal and bone meal. Ground bone meal is used in fertilizers to give phosphorus, calcium, and other mineral salts to the soil. Some plants require boron, and borax is applied as a fertilizer to some soils. Many vegetable products obtain their coloring and some characteristic properties from small quantities of copper, manganese, rubidium, iodine, and other elements that do not occur in all soils. Boron is necessary for sunflower growth, iron is necessary for pineapples, molybdenum is needed for cauliflower, and cobalt oxide is necessary in the soil to prevent salt sickness in cattle. Most plants require minute quantities of zinc to promote formation of Auxin, a complex butylcyclopentene ring compound needed for growth of plants. However, plants require balanced feeding, and indiscriminate use of fertilizers is often injurious. Too much manganese in the soil, for example, may cause necrosis, or inner bark rot, on apple trees, or excess of some common fertilizers may cause abnormal growth of stalk and leaves in plants.

**Fiberboard.** Heavy sheet material of fibers matted and pressed or rolled to form a strong board, used for making trunks and boxes and also for partitions in building construction. The fibers may be of wood or cellulose, jute, flax, straw, or hemp. Board made of asbestos fibers is not classed as fiberboard. Originally, fiberboard contained no bonding material other than the natural bonds in the materials,

but there is now no sharp dividing line between the boards made by different processes and with various resin binders. Fibrofelt, of the Union Fiber Co., Inc., is a pressed flexible fiberboard of matted flax- and rye-straw fibers made in thicknesses from  $\frac{5}{16}$  to 1 in. Masonite, of the Masonite Corp., is produced from by-product wood chips reduced to the cellulose fibers by high steam pressure. The long fibers and the lignin adhesive of the wood are retained, and no chemicals are used in pressing the pulp into boards. Masonite quarter board, for paneling, is made in boards  $\frac{1}{4}$  in. thick. Presdwood is a grainless grade made by compressing under hydraulic pressure, and is dense and strong. These types belong to the class known as Hardboard, in the processing of which the carbohydrates and soluble constituents of the original wood are dissolved out and the relative proportion of lignin increased, resulting in a grainless, hard, stiff, and water-resistant board free from shrinkage. The density of most hardboards is greater than 1.0, and the modulus of rupture is from 5,000 to 15,000 psi. The lignin acts as a binder for the fibers, but some hardboards are made harder and more resistant by adding a percentage of an insoluble resin. The process is not limited to the making of boards. Wood molding powder is made by the same method of treating wood fibers with steam pressure and hydrolyzing the hemicellulose, leaving the lignin free as a binder.

Hardwood, of the Elmendorf Corp., is a hard board made from hardwood waste compressed into sheets under heat and hydraulic pressure. The surface is hard with a high polish. A hard board, developed by the Scottish Cooperative Wholesale Society and called Heatherwood, is made by pulping heather and pressing into boards with a synthetic resin binder. Heather, or Heath, is a small flowering shrub, *Ericaceae tetralix* and *E. cinerea*, which grows profusely in Great Britain. Wonderwood, of the Wonderwood Corp., is a development of the Novopan made in Switzerland. It is made by pulping chipped waste wood and compressing with a resin binder. Tensilite 300, of the J. P. Lewis Co., is made of pulp combined with nitrile rubber and a phenolic resin and pressed into sheets. The specific gravity is 1.35, dielectric strength 600 volts per mil, and compressive strength 32,000 psi. It is suitable for mechanical and electrical applications as well as for paneling. The Forest hardboard of the Forest Fiber Products Co. is made of chipped wood that is pulped and mixed



with synthetic resin and wax and then hydraulically pressed. The board has a smooth glossy face, and is suitable for making furniture and toys and for paneling. Prespine, of the Curtis Co., Inc., is a paneling board of lower hardness and density made by mixing 5 to 15% phenolic resin with sawdust and wood chips and pressing at only 200 psi. These hard boards are used for many construction parts, but the lighter and less dense fiberboards are preferred for insulation and some construction uses. Kimflex board, of the Kimberly-Clark Mills, is a lightweight, pliable fiberboard used for shoe counters. It is made from balsawood pulp, using rubber latex as a binder. Electrite, of the West Virginia Paper & Pulp Co., is a wood fiberboard of high strength and high dielectric strength for electrical panels. Temlok, of the Armstrong Cork Products Co., is a fiberboard made from pine wood fibers impregnated with resin and compressed into building boards and tiles. Temwood, of the same company, is a lightweight board of wood fibers hydraulically pressed into grainless boards in hard and semihard grades. Temboard is a decorative wood fiberboard used for interior paneling. The Veneer fiberboard, of the Elmendorf Co., is made by cutting veneer waste into fibers of 0.010 to 0.015 in. thickness with strand lengths from 1 to 8 in. The flat side of the strand is edge-grained, and when felted the broad surface lies parallel to the faces of the board. From 10 to 20% phenolic resin is used as a fiber binder. The density of the boards is from 0.60 to 0.80. Disfico board, of the Diamond State Fibre Co., for making trunks and boxes, is made of pressed jute and hemp fibers. It comes in sheets in plain colors. Thermax, of the Northwest Magnesite Co., is an insulating board made of shredded wood fibers with a fire-resistant cement.

**Filter sand.** A natural sand employed for filtration, especially of water. Much of the specially prepared filter sand comes from New Jersey, Illinois, and Minnesota, and is from ocean beaches, lake deposits, and sand banks. The specifications for filter sand require that it must be of fairly uniform size, free from clay and organic matter, and chemically pure, containing not more than 2% combined carbonates. The grain sizes are specified in millimeters, the most common being from 0.35 to 0.65 mm. Very fine sand clogs the filter. Greensand, produced from extensive beds in New Jersey, is used as a

water softener. It is a type of marl classed as Zeolite, and consists largely of Glauconite containing about 75% silica, with iron oxide, potash, and alumina. But synthetic zeolite is a Sodium alumina silicate,  $\text{Na}_2\text{O} \cdot \text{Al}_2\text{O}_3 \cdot 6\text{SiO}_2 \cdot x\text{H}_2\text{O}$ , made by reacting caustic soda with bauxite to form sodium aluminate and then reacting with sodium silicate. In addition to filtering, the greensand softener extracts the calcium and magnesium from the water. It is regenerated for further use by passing common salt brine through it. Filter plates, for filtering acids and oils, are porous fused alumina with pores from 0.09 to 0.30 mm diameter.

**Fireclay.** Clays that will withstand high temperatures without melting or cracking, used for lining furnaces, flues, and for making firebricks and lining tiles. Common fireclays are usually silicate of alumina. Theoretically these clays contain 45.87% alumina and 54.13 silica, but in general they contain considerable iron oxide, lime, and other impurities. The nearer to the theoretical proportions, the better is the clay as a refractory. Clays with an excess of silica are also found. The German Klingenberg clay used for crucibles has about 60% silica. The term Refractory clay embraces nearly all clays having a melting point above  $1600^\circ\text{C}$ . But the clays alone are likely to shrink and crack, and they may be mixed with other clays, sand, or graphite. Firebricks are made in various shapes and sizes and are usually white or buff in color. Common firebricks from natural clays will melt at from  $2800$  to  $3100^\circ\text{F}$ . Some other materials used in making firebricks are chromite, bauxite, diatomaceous earth, and magnesite, or the artificial materials silicon carbide and aluminum oxide, but bricks made of these are designated by the name of the material or by trade names. Chromite bricks will withstand temperatures up to  $3700^\circ\text{F}$ , and Magnesia bricks up to  $3900^\circ\text{F}$ , while silicon carbide bricks without a clay binder will withstand heats to  $4000^\circ\text{F}$ . Firecrete, of Johns-Manville, is a lightweight refractory consisting of calcined high-alumina clay used for furnace doors and floors. It will withstand temperatures to  $2400^\circ\text{F}$  in continuous operation. Insuline, of the Quigley Co., is a calcined fireclay in small cellular particles. In insulating brick it is called Insulbrix, and as a lightweight concrete it is known as Insulcrete. The Allmul firebrick, of the Babcock & Wilcox Co., for glass furnaces, is mullite with no free silica.

**Flax.** A fiber obtained from the flax, or linseed, plant, *Linum usitatissimum*, used for making the fabrics known as linens, and for thread, twine, and cordage. It is valued because of its strength and durability. It is finer than cotton, very soft, and the fibers are usually about 20 in. long. Flax consists of the bast fibers, or those in the layer underneath the outer bark, which are of fine texture. The plants are pulled up by the roots, retted, or partly decayed, scraped, and the fibers combed out and bleached in the sun. For the best European flax the preparation is entirely by hand. The important centers of flax preparation are in Russia, central Europe, Italy, Ireland, France, and Egypt. Some flax is also grown in the United States. The plants that are grown for the oil seed, linseed, yield a poor fiber and are not employed to produce flax.

**Flint.** An opaque variety of chalcedony or nearly pure amorphous quartz which shows no visible structure. It is deposited from colloidal solution and is an intimate mixture of quartz and opal. It contains 96 to 99% silica, and may be colored to dull colors by impurities. Thin plates are translucent. When heated, it becomes white. Flint is finely crystalline. It breaks or chips with a convex, undulating surface. The hardness is 7, and specific gravity is 2.6. It was the prehistoric utility material for tools, and was later used with steel to give sparks on percussion. Gun flints are still made from a type of flint mined at Brandon, England, for special uses. Lydian stone, or Touchstone, was a cherty flint used for testing gold. Flint is now chiefly used as an abrasive, and in pottery and glass manufacture. Flint paper for abrasive use contains crushed flint in grades from 20 to 240 mesh, usually coated on one side of 70- or 80-lb paper. Flint is also used in the form of grinding pebbles. Potters' flint, used for mixing in ceramics to reduce the firing and drying shrinkage and to prevent deformation, is ground flint of about 140 mesh made from white French pebbles.

**Fluorine.** An elementary material, symbol F, which at ordinary temperatures is an irritating pale-yellow gas,  $F_2$ . Fluorine gas is obtained by the reduction and electrolysis of fluorspar and cryolite. It has a density of 1.69, a boiling point of  $-187^{\circ}\text{C}$ , and it solidifies at  $-223^{\circ}\text{C}$ . It is used in the manufacture of fluorine compounds. It combines violently with water to form hydrofluoric acid, and it also

reacts strongly with silicon and most metals. Sulphur hexafluoride,  $\text{SF}_6$ , is a very inert gas, resembling nitrogen in its inactivity. It is odorless, colorless, nonflammable, nontoxic, and is five times as heavy as air. It is used as a refrigerant, as a dielectric medium in high-voltage equipment, as an insecticide propellant, and as a gaseous diluent. It remains stable to  $800^\circ\text{C}$ . Aluminum fluoride,  $\text{AlF}_3$ , is a white crystalline solid used in ceramic glazes and for fluxing non-ferrous metals. Other metallic fluorides are marketed for special purposes. Silver difluoride,  $\text{AgF}_2$ , is a blackish powder used as a fluorinating agent; it contains about 26% fluorine. Chlorofluorine gas,  $\text{ClF}_3$ , is a violent fluorinating agent, and is used for the fluorination of some metals otherwise difficult to separate, such as uranium.

Fluorocarbons are compounds of carbon in which fluorine instead of hydrogen is attached to the carbon atoms. They range from gases to solids. When not less than two fluorine atoms are attached to a carbon atom they are very firmly held, and the resulting compounds are stable and resistant to heat and chemicals. Fluorocarbons may be made part hydrocarbon and part fluorocarbon, or may contain chlorine, oxygen, nitrogen, or other elements. Liquid fluorocarbons are used as heat-transfer agents, hydraulic fluids, and fire extinguishers. Benzene-base fluorocarbons are used for solvents, dielectric fluids, lubricants, and for making dyes, germicides, and drugs. Synthetic lubricants of the fluorine type consist of solid particles of a fluorine polymer in a high-molecular-weight fluorocarbon liquid.

Fluorine plastics of high heat and acid resistance, and of many varying physical properties, can be produced by polymerization of fluorocarbon groups. Teflon, of E. I. du Pont de Nemours & Co., Inc., is polymerized Tetrafluoro ethylene,  $(\text{CF}_2\cdot\text{CF}_2)_n$ . The plastic has high dielectric strength, 1,500 volts per mil, high heat resistance,  $550^\circ\text{F}$ , and superior chemical resistance. It is waxy and has self-lubricating properties, which make it useful for such purposes as pressure-valve seats in chemical equipment. The Chemiseal gaskets of the U.S. Gasket Co. are molded from Teflon. The material is also used for electrical wire covering, and in thin sheets as an insulator. It has a higher density than most plastics, with specific gravity of 2.2. Fluorothene plastic, of the Carbide & Carbon Chemicals Corp., has the formula  $(\text{CF}_2\cdot\text{CFCl})_n$ , differing from Teflon in having one chlorine atom on every unit of the polymer chain, replacing the

fourth fluorine atom. This plastic is transparent, and it can be injection-molded. The specific gravity is 2.1, and tensile strength 9,400 psi. It has very high dielectric strength, and will withstand heat to 300°F. Kel-F, of the M. W. Kellogg Co., is a similar plastic.

**Fluorspar.** Also called Fluorite. A crystalline or massive granular mineral of the composition  $\text{CaF}_2$ , used as a flux in the making of steel, for making hydrofluoric acid, in opalescent glass, in ceramic enamels, for making artificial cryolite, and as a binder for vitreous abrasive wheels. It is a better flux for steel than limestone, making a fluid slag, and freeing the iron of sulphur and phosphorus. About 5.54 lb of fluorspar is used per ton of basic open-hearth steel. Germany is a large producer of fluorspar. In the United States it is mined in Illinois, Kentucky, Nevada, and New Mexico. The specific gravity is 3.18, hardness 4, and the colors light green, yellow, rose, or brown. When ground, the color is white. The melting point is 1650°F. The usual grades for fluxing are smaller than  $\frac{1}{2}$  in. and contain 85% min  $\text{CaF}_2$ , with 5 max  $\text{SiO}_2$ . High-grade fluorspar for ceramic frit has 95 to 98%  $\text{CaF}_2$ , 3 max  $\text{SiO}_2$ , 0.12 max  $\text{Fe}_2\text{O}_3$ , and is known as No. 1 ground. Acid spar is a grade used in making hydrofluoric acid. It contains over 98%  $\text{CaF}_2$  and 1 max  $\text{SiO}_2$ , and is produced by flotation. Optical fluorspar is the highest grade but is not common. Fluoride crystals for optical lenses are grown artificially from acid-grade fluorspar. Pure Calcium fluoride,  $\text{Ca}_2\text{F}_6$ , is a colorless crystalline powder used for etching glass and in enamels. Calcium fluoride has silicon in the molecule,  $\text{CaSiF}_6 \cdot 2\text{H}_2\text{O}$ , and is a crystalline powder used for enamels.

**Flux.** A substance added to a refractory material to aid in its fusion, such as lime for melting iron. A secondary action of a flux, which may also be a primary reason for its use, is as a reducing agent to deoxidize or decompose impurities and remove them as slags or gases. In soldering, a flux may serve to remove oxides from the surface to be soldered. Materials such as charcoal or impure boron carbide used to cover baths of molten metals may also be considered as fluxes. Fluxes for melting iron are lime, limestone, dolomite, or fluorspar. For brass, bronze, or soft white metals, resins may be used, and the covering flux may be charcoal, salt, or borax. Cryolite is a flux for aluminum and for glass. Fluxing alloys for brasses and

bronzes are phosphor tin, phosphor copper, or silicon copper. They deoxidize the metals at the same time that alloying elements are added. For tinning steel, palm oil is used as a flux. For ordinary soldering, zinc chloride is a common flux. Tallow, rosin, or olive oil may also be used for soldering. Acetamide is used for soldering painted metals. For silver solders, borax is a common flux. For soldering stainless steel, the borax is mixed with boric acid, or pastes are made with zinc chloride and borax. Borax may also be used as a welding flux. White flux is a mixture of sodium nitrate and nitrite, and is a strong oxidizer used for welding. Welding fluxes for high-temperature welding are usually coated on the rod and contain a deoxidizer and a slag former. Deoxidizers may be ferromanganese or silicomanganese. Slag formers are titanium dioxide, magnesium carbonate, feldspar, asbestos, or silica. Soluble silicate is a binder, while cellulose may be used for shielding the arc. Manganox, of the Foote Mineral Co., is a prepared hausmanite with a manganese metal content of 64%, used for coating welding rods. It is more stable than the ferromanganese often used. Murex, of the Metal Thermit Corp., is a welding rod coated with a mineral flux and covered with asbestos. The flux and the asbestos form a slag that falls off the weld. Lapix, of E. F. Houghton & Co., is a mixture of carbon and clay used to cover the top of molten steel after pouring in ingot molds. It is exothermic and helps to maintain a longer liquid period so that the deoxidized materials rise to the top.

**Fluxing stone.** A common term for the limestone or dolomite used in the melting of iron. About 900 lb of limestone are employed for every long ton of pig iron produced in the blast furnace. If iron ore were reduced without a basic flux, the silica and alumina would unite with the iron oxides to form double silicates of iron and alumina, and there would be a heavy loss of iron. With the addition of limestone, the silica and alumina, having strong affinity for the lime and magnesia, form compounds that contain very little iron. These compounds form a liquid slag which floats on the surface of the molten iron and can be removed readily. The flux also removes sulphur and phosphorus from the iron. Some iron ores contain sufficient lime carbonate to be almost self-fluxing. Lime is more effective as a flux than limestone, but is more expensive. The action of the blast furnace

is first to convert the limestone to lime. Upon being heated to 1525°F limestone breaks down to lime, which then begins fusion with silica to form the slag at about 2600°F. Limestones for use as flux must be fairly pure, or additional undesirable compounds will be formed.

**Foil.** Very thin sheet metal used chiefly for wrapping and insulating but also for electrical applications. The word comes from the Latin *folium*, meaning leaf, and gold foil is called gold leaf. Tin foil is higher in cost than some other foils, but is much used for wrapping food products because it is not poisonous. Ordinary tin foil is made in thicknesses from 0.006 mm (0.00024 in.) to 0.200 mm (0.00787 in.), the former having 16,037 sq in. per lb, and the latter 432 sq in. per lb. Tin foil for radio condensers has 14,500 sq in. per lb. An English modified tin foil, which has greater strength and is non-toxic in contact with foods, contains 8.5% zinc, 0.15 nickel, and the balance tin. It can be rolled to thinner sheets. Lead foil, used for wrapping tobacco and other nonedible products, is rolled to the same thickness as tin foil, but because of its higher specific gravity has less coverage. The thinnest has 10,358 sq in. per lb, and the thickest 279 sq in. per lb. Lead foil has a dull luster, but it may be modified with some tin and other elements to give it a brighter color. Aluminum foil has a high luster, though not as high as pure tin foil. It is also produced with a satin finish for special purposes. Aluminum foil comes in 34 thicknesses, from 0.006 mm, having 43,300 sq in. per lb, to 0.200 mm, having 1,169 sq in. per lb. It can be made as thin as 60,000 sq in. per lb. It is obtainable in bright colors produced by dyeing or lacquering, and in printed or embossed designs. Since the tear resistance of thin aluminum foil is low, it is usually laminated with paper for food packaging. As it reflects heat waves, it is used also as an insulator in sheet form applied to building boards or in crumpled form in walls. The name Alfol was applied to crumpled aluminum foil for this purpose by the British National Physical Laboratory. Aluminum foil is an excellent radio reflector, and if strips are cut one-half the radar wave length they throw back a powerful echo. Thin foil is cut into strips in various lengths up to several inches to be thrown from airplanes and scattered in the wind. A bundle of 6,000 strips weigh 6 oz. Gold leaf is not normally classed as foil, but is used for architectural coverings and for hot-embossed

printing on leather. It is made by hammering in books, and can be made as thin as 0.0000033 in., a gram of gold covering 5,184 sq in. Usually, gold leaf contains 2% silver and copper for hardening.

**Formaldehyde.** Also called Methylene oxide. A colorless, poisonous gas of the composition  $\text{HCHO}$ , boiling at  $-21^{\circ}\text{C}$ . It is very soluble in water, and is marketed as a 40% solution by volume, 37% by weight, under the name of Formalin. The commercial formalin is a clear colorless liquid with a specific gravity of 1.075 to 1.081. When shipped by tank cars it contains 11 to 12% methanol, or 6 to 7% when shipped in drums, as a stabilizer to prevent precipitation of polymerized formaldehyde. The material is obtained by oxidation from methyl alcohol. It is used in making synthetic resins, as a reducing agent in the silvering of mirrors, and as a disinfectant. Trioxane, of E. I. du Pont de Nemours & Co., Inc., is polymerized formaldehyde, a colorless, plastic solid melting at  $64^{\circ}\text{C}$ . It has a sweet odor resembling that of chloroform. It burns with a hot, odorless flame, and is used in tablet form to replace solidified alcohol for heating. Glyoxal, of the Carbide & Carbon Chemicals Corp., is Dialdehyde, or Ethanedial,  $\text{CHO}\cdot\text{CHO}$ , marketed as a water solution as a substitute for formaldehyde for resin manufacture and as a hardening and preserving agent, and for treating rayon fabrics. It is faster in action and has less volatility and odor than formaldehyde. It is a light-yellow liquid boiling at  $50^{\circ}\text{C}$ . Paraformaldehyde,  $(\text{CH}_2\text{O})_3$ , also called Paraform, is a white amorphous powder used instead of formaldehyde where a water solution is not desirable. It is used as a catalyst and hardener for the resorcinol and some other synthetic resins, and as an antiseptic. Formol is a trade name for a solution of formaldehyde in methanol and water, used as an antiseptic. Formcel, of the Celanese Corp. of America, is a solution of formaldehyde in either methanol or butanol, to replace formalin where a water-free solution is desired.

**Formic acid.** Also called Methanoic acid and Hydrogen carboxylic acid. Formic acid is the simplest of the organic acids, with the composition  $\text{HCOOH}$ , and was originally distilled from red ants, receiving its name from the Latin name for ants. It is a pungent colorless liquid of specific gravity 1.22, boiling point  $101^{\circ}\text{C}$ , and freezing point  $8.4^{\circ}\text{C}$ , soluble in water and in alcohols. It is an easily oxidized reducing agent, and small amounts will blister the skin and give the



stinging sensation of ant or bee bites. Formic acid is produced by reacting sodium formate and sulphuric acid. It is used as a coagulant for rubber, as a disinfecting and deliming agent for hides, as a textile mordant, food preservative, in electroplating, as a germicide, and as a fermentation assistant in brewing.

**Fuel briquettes.** Various-shaped briquettes made by compressing powdered coal, usually with an asphalt or starch binder, but sometimes as Smokeless fuel without a binder. They are sometimes also made waterproof by coating with pitch or coal tar. They have the great advantage over raw coal that they do not take up large amounts of water like coal and thus have uniformity of firing. Fuel briquettes are made from anthracite screenings usually mixed with bituminous screenings as the bituminous coals require no binders. The usual forms of the briquettes are pillow-shaped, cubic, cylindrical, ovoid, and rectangular, and the usual size is not over 5 oz. The term Packaged fuel is used for cube-shaped briquettes wrapped in paper packages, used for hand firing in domestic furnaces. Koal Pak, of the Johnson Coal Cubing Co., consists of coal cubes wrapped eight to a package. The Coal briquettes of the Blaw-Knox Co. are made with anthracite dust and a small amount of Pocahontas-type bituminous coal with an asphalt binder. The cakes are 3 by 3 by 3 in. wrapped in kraft paper. The Coal logs of the Coal Logs Co., Inc., are briquetted smokeless fuel which consists of high-temperature coke made by carbonizing Utah low-grade coal, yielding 20 to 40 gal of tar as a by-product per ton of coal.

**Fuel oil.** Distillates of petroleum or shale oil used in diesel engines and in oil-burning furnaces. True fuel oils are the heavier hydrocarbons in kerosene, but the light or distillate oils are used largely for heating, and the heavy or residual oils for industrial fuels. In some cases only the light oils, naphtha and gasoline, are distilled from petroleum and the residue is used for fuel oil, but this is wasteful of the lighter oils. Fuel oil of low specific gravity requires preheating to obtain complete atomization. At 10°Bé the minimum temperature to atomize fuel oil is 300°F, but at 40°Bé a temperature of only 40°F is required. Fuel oils used in oil burners are 28 to 32°Bé, and have a Btu content of 142,000 per gal, completely atomizing at 90°F. Gas oil, which receives its name from its use to enrich fuel gas and increase

the luminance of the flame, is also used as a fuel in oil engines. It is the fraction of petroleum distilling off after kerosene, or above about 300°C. It is brownish in color and has a specific gravity of about 0.850. Ignition temperatures of crude oils vary from 715 to 800°F in air at atmospheric pressure. Bunker C oil, for diesel engines, is a viscous, black fuel oil of specific gravity 1.052 to 0.9659 with a flash point above 150°F. The National Bureau of Standards lists six grades of fuel oils with flash points from 100 to 200°F. For general comparison of oil and coal, with comparable fire and boiler equipment, 4.5 bbl of Bunker C oil equal one net ton of low-ash, high-volatile West Virginia coal.

**Fuller's earth.** A soft, opaque clay with a greasy feel used as a filtering medium in clarifying and bleaching fats, greases, and mineral and vegetable oils. It absorbs the basic colors in the organic compounds. It is also used as a pigment extender and a substitute for talcum powder. It was formerly much used in the textile industry as a fuller for woolen fabrics, cleansing them by absorbing oil and grease. It is a hydrated compound of silica and alumina. It may contain 75% silica, 10 to 19 alumina, 1 to 4 lime, 2 to 4 magnesia, and sometimes ferric oxide. The usual color is greenish white to greenish brown. The rose-colored fuller's earth from Florida is a variety of Montmorillonite,  $(\text{MgCa})\text{O} \cdot \text{Al}_2\text{O}_3 \cdot 4\text{SiO}_2$ . The Florida fuller's earth marketed by the Floridin Co. under the name of Floridin is a grayish-white material graded by sizes from B, which is 16 to 30 mesh, to XXX, which will pass 90% through a 200-mesh screen. Florex is this material processed by extrusion to increase the absorption capacity. A typical analysis gives 58.1% silica, 15.43 alumina, 4.95 iron oxide, 2.44 magnesia, with small amounts of CaO,  $\text{Na}_2\text{O}$ , and  $\text{K}_2\text{O}$ . The specific gravity is 2.3. Florigel is the hydrated material which forms viscous suspensions in water, and is used to replace bentonite, as a filler for soaps, and for clarifying liquids. Diluex is finely powdered Florida fuller's earth used as a diluent or carrier for insecticides. Activated clay, or Bleaching clay, for bleaching oils, may be acid-treated fuller's earth, or it may be bauxite or kaolin. Florite, of the Floridin Co., is activated bauxite. It is a red, granular, porous material of 20 to 60 mesh, used for decolorizing and clarifying oils and waxes.

**Fulminates.** Materials used in percussion caps and detonators because of their ready explosiveness with a slight blow. They may be called Cap powder in cartridge caps and Detonators when used for detonating or exploding artillery shells. Mercury fulminate,  $\text{Hg}(\text{CNO})_2$ , a gray or brown sandy powder, is the basis for many detonating compositions. It is made by the action of nitric acid on mercury and alcohol, and is ten times more sensitive than picric acid. It may be mixed with potassium chlorite and antimony sulphide for percussion caps. Lead azide,  $\text{PbN}_6$ , is sometimes substituted for mercury fulminate. It is much more sensitive, and in large crystals is subject to spontaneous explosion. It is precipitated to suppress crystal formation and to form a free-flowing powder less sensitive to handling. For primer caps, a substitute for mercury fulminate is a mixture of lead styphnate, lead triazoacetate, lead nitrate, and lead sulphocyanate. Lead styphnate, used as a detonator, is made by the sulphonation and nitration of resorcinol to form Styphnic acid, or Trinitroresorcinol,  $(\text{NO}_2)_3\text{C}_6\text{H}(\text{OH})_2$ . This powder is treated with magnesia and with a lead nitrate solution to form the lead styphnate powder. Azoimide, or Iminazoic acid,  $\text{HN}\cdot\text{N}_2$ , is an extremely explosive colorless gas liquefying at  $37^\circ\text{C}$  which can be used in the form of its salts. Silver azoimide,  $\text{AgN}\cdot\text{N}_2$ , is highly explosive, and Barium azoimide,  $\text{BaN}_6$ , explodes with a green flash.

**Fumigant.** A liquid, powder, or gas used in fumigating warehouses or ships to kill insects, worms, and burrowing animals. For general use a fumigant should not be injurious to grains or stored foodstuffs. Repellents are fumigants used for driving out insects but do not kill. However, some repellents may contain naphthalene, rotenone, or other materials having toxic properties, and are insecticides rather than fumigants. Methyl bromide, or Bromomethane,  $\text{CH}_3\text{Br}$ , a gas with a liquefying point at  $4.6^\circ\text{C}$ , is an effective fumigant not injurious to grains. Dowfume BR10, of the Dow Chemical Co., is a methyl bromide with chlorinated hydrocarbons, used in pressure cylinders for fumigating warehouses. Methyl bromide is also used for fumigating clothing warehouses and does not shrink or wrinkle woolen fabrics. Carboxide, of the Carbide & Carbon Chemicals Corp., is a mixture of carbon dioxide and ethylene oxide used as a fumigant. It does not injure grains or foodstuffs. Dihydroacetic acid

is used on dried fruits in storage to prevent decomposition. It acts in the nature of a fungicide.

**Furfural.** Also known as Furfuraldehyde, Furol, and Pyromucic aldehyde. A yellowish liquid with an aromatic odor, having a composition  $C_4H_3O \cdot CHO$ , specific gravity 1.161, boiling point  $161.7^\circ C$ , and flash point  $132^\circ F$ . It is soluble in water and in alcohol but not in petroleum hydrocarbons. On exposure it darkens and gradually decomposes. Furfural occurs in different forms in various plant life and is obtained from cornstalks, corncobs, straw, oat husks, and peanut shells by treating with mineral acids and distilling. Furfural is used for making synthetic plastics, as a plasticizer in other synthetic resins, as a preservative, in weed killers, and as a selective solvent especially for removing aromatic and sulphur compounds from lubricating oils. It is also used for the making of butadiene and other chemicals.

Various derivatives of furfural are also used, and the furfural derivatives, known collectively as Furans, have a widening field of use since they are readily obtainable from wastes and easily grown raw materials. Furfuryl alcohol,  $C_4H_3O \cdot CH_2OH$ , a yellow liquid with a brinelike odor, boiling at  $176^\circ C$ , and flash point at  $167^\circ F$ , is used as a solvent for nitrocellulose and for dyes. Furan, or Tetrol,  $C_4H_4O$ , used for plastics manufacture, is a colorless liquid boiling at  $32^\circ C$ . Methyl furan, or Sylvan,  $C_4H_3O \cdot CH_3$ , is a colorless liquid boiling at  $62^\circ C$ . Tetrahydrofuran,  $C_4H_8O$ , is a water-white liquid with strong solvent powers on resins. It is also an intermediate for the production of many chemicals. It reacts with carbon monoxide and water to form adipic acid. Furfural acetone,  $C_4H_3O \cdot CH:CHCOCH_3$ , is a reddish-brown liquid boiling at  $229^\circ C$ . Furfural, when treated with aniline at  $150^\circ C$ , forms an insoluble black Furfural-aniline resin used in resistant protective coatings and enamels. Furfural-acetone resin, or Furfuracetone, is a transparent elastic resin made by the reaction of furfural and acetone in the presence of an alkali. Furfural also polymerizes with phenol to form Furfural-phenol resins that are self-curing. They have high heat, chemical, and electrical resistance, and have excellent adhesion to metals and other materials, making them adaptable for chemical and electrical coatings. The resins have high gloss, but a very dark color. The

Tygon resins of the U.S. Stoneware Co. are furfural resins used for brush application as protective coatings for such purposes as chemical tank linings. They cure by self-polymerization, will withstand temperatures to 350°F, and are resistant to acids, alkalies, alcohols, and hydrocarbons.

**Fusible alloys.** Alloys having melting points below the boiling point of water, 100°C. They are used as binding plugs in automatic sprinkler systems, for low-temperature boiler plugs, for soldering pewter and other soft metals, for tube bending, and for casting patterns and many ornamental articles and toys. They consist generally of mixtures of lead, tin, cadmium, and bismuth. The general rule is that an alloy of two metals has a melting point lower than that of either metal alone. By adding still other low-fusing metals to the alloy a metal can be obtained with almost any desired low melting point. The original Newton's alloy contained 50% bismuth, 31.25 lead, and 18.75 tin. Newton's metal, used as a solder for pewter, contained 50% bismuth, 25 cadmium, and 25 tin. It melts at 203°F, and will dissolve in boiling water. Lipowitz alloy, another early metal, contained 3 parts cadmium, 4 tin, 15 bismuth, and 8 lead. It melts at 158°F, is very ductile, and takes a fine polish. It was employed for casting fine ornaments. A small amount of indium increases the brilliance and lowers the melting point. Wood's alloy, or Wood's fusible metal, was patented in 1860 and was the first metal used for automatic sprinkler plugs. It contained 7 to 8 parts bismuth, 4 lead, 2 tin, and 1 to 2 cadmium. It melts at 160°F, and this point was adopted as the operating temperature of sprinkler plugs in the United States; in England it is 155°F. An early alloy for tube bending contained 50% bismuth, 26.7 lead, 13.3 tin, and 10 cadmium. It melts at 158°F, and can be easily removed from the tube after bending by dipping in boiling water.

Cerrobend, or Bendalloy, of the Cerro de Pasco Copper Co., is a fusible alloy for tube bending which melts at 160°F. Cerrocast is a Bismuth-tin alloy with pouring range of 280 to 338°F, and shrinkage of only 0.0001 in. per in., used for making pattern molds. Cerrosafe, or Safalloy, is a fusible metal used for toy-casting sets as the molten metal will not burn wood or cause fires. Alloys with very low melting points are sometimes used for this reason for pattern and

toy casting. A fusible alloy with a melting point at 60°C contains 26.5% lead, 13.5 tin, 50 bismuth, and 10 cadmium. These alloys expand on cooling and make accurate impressions of the molds. Boiler-plug alloys have been made under a wide variety of trade names with melting points usually ranging from 212 to 342°F. D'Arcet's alloy, melting at 200°F, contained 50% bismuth, 25 tin, and 25 lead. Lichtenberg's alloy, melting at 198°F, contained 50% bismuth, 30 lead, and 20 tin. Guthrie's alloy had 47.4% bismuth, 19.4 lead, 20 tin, and 13.2 cadmium. Rose's alloy contained 35% lead, 35 bismuth, and 30 tin. Homberg's alloy, melting at 251°F, contained 3 parts lead, 3 tin, and 3 bismuth. Malotte's metal, melting at 203°F, had 46% bismuth, 20 lead, and 34 tin. The variation of these different alloys was largely because of the relative cost of the different alloying metals at various times. Fusible metals have also been used in strip form to test the temperature of steels for heat-treating. The Temperite alloys of the Cornish Wire Co. were for this purpose with melting points between 300 and 625°F in steps of 25 deg. The Tempil pellets of the Tempil Corp. are alloy pellets made with melting points in steps of 12.5, 50, and 100°F for measuring temperatures from 113 to 2500°F.

**Fustic.** Known also as Cuba wood. The wood of the tree *Chlorophora tinctoria* of tropical America, used for cabinetmaking and as a dyewood. It has a yellow color, is very hard, and has a fine, open grain. The weight is about 41 lb per cu ft. The liquid extract of the wood produces the yellow dyestuff Morin,  $C_{15}H_{11}O_7$ , and the red dye Morindone,  $C_{15}H_{11}O_5$ . Fustic extracts are mordant dyes and give colors from yellow to olive with various mordants. Morin is used also as an indicator to detect aluminum, with which it develops a green fluorescence. Young fustic, or Hungarian yellow wood, is a yellow dyewood from the *Rhus cotinus*. Osage orange, called Bois d'arc, is the bright orange wood of the bush *Maclura pomifera* growing in the swamplands of Texas and Oklahoma. It has a high tannin content and is used in the textile and leather industries for orange-yellow and gold colors and to blend with greens. As a tanning agent it is blended with quebracho and chestnut extracts.

**Gallium.** An elementary metal, symbol Ga, originally called Austrium. It is silvery-white, resembling mercury in appearance but

having chemical properties more nearly like aluminum. It melts at 85.6°F, and boils at 2912°F, this wide liquid range making it useful for high-temperature thermometers. Like bismuth, the metal expands on freezing, the expansion amounting to about 3.2%. Pure gallium is resistant to mineral acids, and dissolves with difficulty in caustic alkali. It forms many salts at different valencies. The weight is only about half that of mercury, having a specific gravity of 5.9. Commercial gallium has a purity of 99.9%. Small amounts of the metal have been used in tin-lead solders to aid wetting and decrease oxidation, but it is expensive for this purpose. It also finds some use in vapor lamps and in dental alloys. A Gallium-tin alloy has been used where a liquid metal is needed at low temperatures. Gallium is found in small amounts associated with zinc ores and is recovered from smelter flue dust. In Germany it is produced as a by-product of copper smelting. It is also a minor constituent in the mineral sphalerite to the extent of 0.01 to 0.1%, and it also occurs in almost all aluminum ores in the ratio of 50 to 100 grams of gallium per ton of aluminum. About 1 oz of gallium is obtained commercially per ton of bauxite.

**Galls.** Tanning materials obtained from the Nutgalls, or Gall nuts, from the oaks of Europe and the Near East and from the sumac of China and Japan. Nutgalls are plant excrescences caused by the punctures of insects. They contain 50 to 70% tannins, and are the richest in tannin of all the leather-tanning materials. The tannin is also valued for inkmaking and in medicine for treating burns. Green galls, or Aleppo galls, are obtained from the twigs of the Aleppo oak, *Quercus infectoria*, a shrub of the Near East. Those of blue color are the best quality, with green second, and the white of inferior grade. Chinese galls, from species of *Rhus*, are in the form of irregular roundish nuts which enclose the insect. They show no vegetable structure but have a dense resinous fracture and are very high in tannin. Gall, or Beef gall, is an entirely unrelated material. It is a bitter fluid from the livers of cattle, used in making soaps for washing dyed fabrics, and for fixing dyes in fabrics, and in water-color paints.

**Galvanized iron.** Iron or steel sheets coated with zinc and used for roofing, sheathing, culverts, and for making such articles as pails and tanks that require to be rust-resistant without painting. The most common sheets are of low-carbon steel, but the copper-bearing iron

and steels are also used to give added corrosion resistance. The common dipped sheets are annealed, pickled, cold-rolled to increase the polish, and then dipped in molten zinc. They have a characteristic spangle which in thick coats is likely to peel and flake off under distortion. Sheets are graded by perfection of coating, gage, and size, as primes, seconds, and gray-coated. Primes are the perfect sheets. Galvanized sheets are either plain or corrugated. They usually come in lengths of 6, 7, and 8 ft. and widths of 24, 26, 28, 32, 34, and 36 in. The thickness is by gage sizes, usually from No. 14 to No. 30. The No. 14 sheet carries a 2-oz zinc coating. Zinc alloy steel, of the Inland Steel Co., is zinc-coated steel sheet with the coating fused in and alloyed with the steel so that there is no spangle. The sheet can be spun or drawn without cracking the coating. Gal-Van-Alloy is the trade name of this company for the galvanized sheet. Zinc-coated steel is now made extensively by continuous electroplating. Weirzin, of the Weirton Steel Co., is zinc-electroplated sheet steel. Zincgrip, of the Armco Steel Corp., is zinc-coated sheet steel for deep drawing. The coating does not flake or peel in the drawing dies. Galv-Weld, of the U.S. Steel Supply Co., is a low-melting zinc alloy in stick form for regalvanizing welded joints.

Galvanized wire is steel wire coated with zinc for rust resistance either by dipping in molten zinc or by continuous electroplating, and is marketed plain, twisted, or barbed. Barbed wire has double-pointed wire barbs held in the twisted wire. Bethanized steel, of the Bethlehem Steel Co., is wire electrogalvanized and then passed through a die which polishes and hardens the coating.

**Gambier.** Also spelled Gambir. A tanning and dyeing material extracted from the leaves and twigs of the shrubs *Uncaria gambier*, *U. Dacyoneuro*, and other species of India, Malaysia, and the East Indies. It is similar to catechu, and is also called White cutch, Yellow cutch, Cube cutch, and Tara japonica. The cubes of extract are brittle, have a dull-gray color, and a bitter astringent taste. The material contains Catechin,  $C_{15}H_{14}O_6$ , a yellow astringent dye also found in catechu and kino resin. Catechin is soluble in hot water and in alkaline solutions and is neutral with no acid properties. Gambier also contains Catechutannic acid, a reddish tannin. The liquid extract contains 25% tannin, and the cube gambier has 30 to 40%. Gambier is



used in tanning leather and in dyeing to give yellow to brown colors. It produces the Cutch brown on cotton fabrics. It has excellent fastness as a dye and is used in shading logwood and fustic, or as a mordant for fixing basic dyes. In tanning it gives a soft porous leather, has less astringency than other tannins, and is employed for tanning coat leathers and for blending with other tannins. Gambier is also used in boiler compounds and in pharmaceuticals. Plantation gambier, or Singapore cube, is refined clear gambier in small square cubes, while ordinary gambier may have dark patches or a black color with a fetid odor. Gambier bulat is round gambier, and Gambier papu is in long black sticks, both used locally for chewing.

**Garnet.** A large group of hard minerals used chiefly for abrasive paper and cloth, but also for bearing pivots in watches, and the finer specimens for gem stones. Garnets are trisilicates of alumina, magnesia, calcia, ferrous oxide, manganese oxide, or chromic oxide. The general formula is  $3R''O \cdot R'''_2O_3 \cdot 3SiO_2$ , in which  $R''$  is Ca, Mg,  $Fe''$ , or  $Mn''$ , and  $R'''$  is Al,  $Cr'''$ , or  $Fe'''$ . There are thus 12 basic types of garnets, but sodium and titanium may also occur in the crystals, replacing part of the silicon, and there are also color varieties due to impurities.

The hardness is from 6 of grossularite to 7.5 of almandite and rhodolite, and the specific gravity is 3.4 to 4.3, with a melting point about  $1300^{\circ}C$ . The color is most often red, but it may be brown, yellow, green, or black. Spanish garnet is pale pink. High-iron garnets have the lowest melting points and fuse to a dark glass, while the high-chromium garnets have high melting points. Garnets occur in a wide variety of rocks in many parts of the world. The immense alluvial schist deposits of the Emerald Creek area of Idaho contain about 10% garnet. Almandite,  $3FeO \cdot Al_2O_3 \cdot 3SiO_2$ , forms crystals of a fine deep-red color with a hardness of about 7.5, which fuses to a glassy mass at  $1315^{\circ}C$ . It is the most common garnet and is produced chiefly in New York state. It is crushed and graded for coating abrasive paper and cloth. The choice crystals are used as gem stones. Cape ruby, from South Africa, is a red almandite. Pyrope has the composition  $3MgO \cdot Al_2O_3 \cdot 3SiO_2$ . It has a deep-red color to nearly black, and hardness of 6.5 to 7.5. The nearly transparent or translucent crystals are selected for gem stones. Rhodolite, a pale-rose to

purple variety of garnet, is a mixture of pyrope and almandite. These two garnets are found in the Eastern states.

Andradite has the composition  $3\text{CaO} \cdot \text{Fe}_2\text{O}_3 \cdot 3\text{SiO}_2$ , and the colors are yellow, green, or brown to black, with a hardness of 6.5. The orange-yellow variety is called Hessonite; the yellow-green is Tapolite; the green is Demantoid; and the black variety is called Melanite. The Uralian emeralds are choice green crystals of demantoid from the Ural Mountains. Uvarovite has the composition  $3\text{CaO} \cdot \text{Cr}_2\text{O}_3 \cdot 3\text{SiO}_2$ , and is emerald green. Grossularite,  $3\text{CaO} \cdot \text{Al}_2\text{O}_3 \cdot 3\text{SiO}_2$ , may be white, yellow, or pale green. Succinite is an amber variety; Romanzovite is brown; and Wiluite is pale green. Spessartite,  $3\text{MnO} \cdot \text{Al}_2\text{O}_3 \cdot 3\text{SiO}_2$ , is brown to red, the yellowish-brown variety being Rothoffite. The sodium garnet is Lagoriolite, and a variety of calcium spessartite is called Essonite.

**Gasket materials.** Any sheet material used for sealing joints between metal parts to prevent leakage, but gaskets may also be in the form of cordage or molded shapes. The simplest gaskets are waxed paper or thin copper. A usual requirement is that the material will not deteriorate by the action of water, oils, or chemicals. Gasket materials are usually marketed under trade names. Felseal, of the Felt Products Mfg. Co., consists of sheets of paper or fiber, 0.010 to 0.125 in. thick, coated with Thiokol to withstand oils and gasoline. Corbestos, of the Victor Mfg. & Gasket Co., to resist high heat and pressure, consists of sheet metal coated with graphited asbestos, the sheet metal being punched with small tongues to hold the asbestos. Chrome lock, of the Products Research Co., is felt impregnated with zinc chromate to prevent corrosion and electrolysis between dissimilar metal surfaces.

**Gasoline.** Known in England as Petrol. A colorless liquid hydrocarbon obtained in the fractional distillation of petroleum. It is used chiefly as a motor fuel, but also as a solvent. Ordinary gasoline consists of the hydrocarbons between  $\text{C}_6\text{H}_{14}$  and  $\text{C}_{10}\text{H}_{22}$ , which distill off between the temperatures 69 and  $174^\circ\text{C}$ , usually having the light limit at Heptane,  $\text{C}_7\text{H}_{16}$ , or Octane,  $\text{C}_8\text{H}_{18}$ . The octane number is the standard of measure of detonation in the engine. Motor fuel, or the general name gasoline, before the wide use of high-octane gasolines obtained by catalytic cracking, meant any hydrocarbon mixture

that could be used as a fuel in an internal-combustion engine by spark ignition without being sucked in as a liquid and without being so volatile as to cause imperfect combustion and carbon deposition. These included also mixtures of gasoline with alcohol or benzol.

The Federal specifications for motor fuel called for a hydrocarbon of which 90% would evaporate at 180°C, 50% at 125°C, and 10% at 65°C, with a maximum of 0.10% sulphur. The Gasanol used in the Philippines contained only 20% gasoline, with 5 kerosene and 75 ethyl alcohol, while the German Dynalkol contained 70% gasoline with alcohol and benzol. But the gasolines containing as much as 15% ethyl alcohol require special carburetion. The Dynax motor fuel for speed boats is a methanol-benzene blend.

The common commercial gasolines in the United States had an upper limit at 225°C, and an average specific gravity of 0.75, with the Aromatic-free gasolines having a specific gravity of 0.718. Aviation gasoline had a boiling range below 150°C, but aviation gasolines are now the high-octane cracked and treated gasolines. Straight-run distillation yields gasoline of octane numbers from about 40 to 60, and the yield is 20 to 30% of the petroleum. In the heat-cracking process the heavy hydrocarbons of the petroleum are fragmented and converted into lighter hydrocarbons of gasoline range. The octane number of the gasoline then ranges from 55 to 70, and the yield is higher. With catalytic cracking the octane number can be brought up to 100 or higher, and the yield proportionately increased. Cracked gasolines may be rich in the Olefins,  $C_nH_{2n}$ , or ethylene series, which have antiknock properties but which polymerize and form resins with high heat. They are stabilized with antioxidants. Filtering straight-run gasoline with bauxite removes sulphur impurities that cause knocking and raises the octane number. The octane number and the antiknock qualities are improved by slight additions of tetraethyl lead, but high-quality gasolines are produced that do not require lead additions. Dynafuel, of the Sun Oil Co., is a gasoline of this kind with octane value of 78 produced by catalytic cracking.

Synthetic gasoline was first produced in Germany by the Bergius process of hydrogenation of powdered lignite at high temperatures and pressures to produce gasoline, an intermediate oil, and a heavy oil. But gasolines are also produced from the high-volatile bituminous coals. The low-grade fuel bituminous coals contain a high pro-

portion of Anthraxylon, or Vitrain, which is that part of bituminous coal consisting of undisintegrated parts of trees and plants. This structure of coal has less carbon and can be liquefied more easily to produce gasoline and oils. A low-grade bituminous, such as Vigo No. 4 vein, with 65% anthraxylon, gives a liquefaction to gasoline and oils of more than 96%, while a Pennsylvania medium-volatile fuel coal gives only 79% liquefaction and requires a greater consumption of hydrogen. Gasoline is also produced from natural gas by the Fischer-Tropsch process, 100,000,000 cu ft of gas yielding 6,000 bbl gasoline and 1,000 bbl distillate fuels.

Gasoline gel, used in incendiary bombs, is gasoline made into a thick gel with a chemical thickener. It adheres to the surface where it strikes and will produce a temperature of 3000°F for 10 min. The thickener used under the name of Napalm was sodium palmitate, but also an aluminum soap made with an oleic, naphthenic, and coconut fatty acid mixture. The same principle is used for making quick-firing gels for commercial power boilers, but diesel oil is used instead of gasoline. The motor fuel known as Triptane is Trimethyl butane. In automotive engines it is free from knock so that higher compressions may be employed. In blends with 100-octane gasoline it increases the power output about 25% in aviation engines.

**Gear bronze.** Any bronze used for casting gears and worm wheels, but the term usually means a tin bronze of good strength deoxidized with phosphorus and containing some lead to make it easy to machine and lowering the coefficient of friction. A typical gear bronze contains 88.5% copper, 11 tin, 0.25 lead, and 0.25 phosphorus. It has a tensile strength up to 40,000 psi, elongation 10%, and Brinell hardness from 70 to 80, or up to 90 when chill-cast. The weight is 0.306 lb per cu in. This is SAE bronze No. 65. A Hard gear bronze, or Hard bearing bronze, of the U.S. Navy, contains 84 to 86% copper, 13 to 15 tin, up to 1.5 zinc, up to 0.75 nickel, and up to 0.5 phosphorus. A bronze for worm wheels contains about 87.5% copper, 11 tin, 1.5 nickel, and 0.15 phosphorus. The tensile strength is 51,000 psi, and hardness 100 Brinell. Hard and strong bronzes for gears are now often silicon bronze or manganese bronze.

**Gelatin.** A colorless to yellowish water-soluble tasteless colloidal hemicellulose obtained from bones or from skins and used as a dis-

persing agent, sizing medium, coating for photographic films, and as a stabilizer for foodstuffs and pharmaceutical preparations. It is also flavored and used as a food jelly. The protein Collagen is the gelatin-bearing substance in bone and skins. The bone is dissolved in hydrochloric acid to separate out the calcium phosphate and washed to remove the acid. The organic residue is called Osseine and is the product used to produce gelatin and glue. About 25% of the weight of the bone is osseine, and the gelatin yield is about 65% of the osseine. One short ton of green bones, after being degreased and dried, yields about 300 lb of gelatin. When skins are used, they are steeped in a weak acid solution to swell the tissues so that the collagen may be washed out. The gelatin is extracted with hot water, filtered, evaporated, dried, and ground or flaked. Gelatin differs from glue only in the purity. Photographic gelatin is made from calfskins. Vegetable gelatin is the algin from seaweed.

**German silver.** A general name for copper-nickel-zinc white alloys used as a base metal for plated silverware, for springs and contacts in electrical equipment, and for corrosion-resistant parts. Federal Trade Commission rulings prohibit the use of the term in marketing products, but the term is used in manufacturing, and the term nickel brass or a variety of trade names used in marketing. The alloys are graded according to the nickel content. Extra white metal, the highest grade, contains 50% copper, 30 nickel, and 20 zinc. The lower grade, called fifths, for plated goods, has a yellowish color. It contains 57% copper, 7 nickel, and 36 zinc. All of the early German silvers contained iron, up to 2%, which increased the strength, hardness, and whiteness, but iron is not desirable in the alloys used for electrical work. Some of the early English alloys also contained up to 2% tin, but tin makes the alloys brittle.

**Germanium.** A rare elementary metal, symbol Ge. It is a grayish-white crystalline metal of great hardness, being 6.25 Moh. The specific gravity is 5.35, and melting point 958°C. It is resistant to acids and alkalis. The metal is trivalent and will form chain compounds like carbon and silicon. It gives greater hardness and strength to aluminum and magnesium alloys, and as little as 0.35% in tin will double the hardness. It is not used commonly in alloys, however, because of its rarity and great cost. It is used chiefly in the form of its

salts to increase the refraction of glass, and as metal in rectifiers and detectors for radio and radar. Its crystals are rectifiers for changing alternating current to direct current. It is also used in transistors for amplifying electric current. Lump germanium is used in crystal rectifiers. Germanium-helium alloy is not a true alloy, but is made by exposing the molten metal at a temperature of  $1000^{\circ}\text{C}$  to a helium atmosphere until the gas impregnates the metal. The alloy will pass electrical current in one direction, but has high resistance to it in the other direction. It is used for rectifiers. A 12% eutectic Germanium-gold alloy with a melting point of  $359^{\circ}\text{C}$  is used for soldering jewelry.

Germanium is obtained as a by-product from flue dust of the zinc industry, or it can be obtained by reduction of its oxide from the ores. The chief ore of the metal is Germanite which is a copper ore found in southwest Africa. Germanite contains no less than 20 elements. Together with about 45% copper and 30 sulphur, it contains 6 to 9% germanium and 1 gallium, with various amounts of iron, zinc, lead, arsenic, silica, titanium, tungsten, molybdenum, nickel, cobalt, manganese, cadmium, and carbon. Renierite, found in the Belgian Congo, is a Germanium sulphide containing up to 7.8% germanium in the ore. The rare lead-silver ore, Ultrabasite, found in central Europe, also contains germanium. Many other metal ores, such as lepidolite, sphalerite, and spodumene, contain small amounts of germanium, so that it has an indirect use, especially in ceramics. As much as 1.6% Germanium oxide,  $\text{GeO}$ , occurs in some English coals.

**Gilsonite.** A natural asphalt found in Colorado and Utah, used for roofing, paving, in rubber compounds, and in waterproof paints. It is a lustrous, black, almost odorless, brittle solid, having a specific gravity of 1.10. The melting points of the commercial screened material are  $275$ ,  $305$ , and  $330^{\circ}\text{F}$ . It is one of the purest asphalts and has high molecular weight. It is soluble in alcohol, turpentine, and mineral spirits. Gilsonite was named after Samuel Gilson, who discovered it about 1875. The selects come from the center of the veins, are very pure, have high solubility in naphtha, and have fusing points from  $270$  to  $310^{\circ}\text{F}$ . But most commercial gilsonite is now melted and regraded. Elaterite and Wurtzilite are similar asphalts

found in Utah, used chiefly for acid-resisting paints. Grahamite, or Glance pitch, is another pure asphalt found in large deposits in Oklahoma, and in Mexico, Trinidad, and Argentina. It is used in insulation and molding materials and in paints. The alkali-resistant concrete floor paint of the Tiz-Nu Corp., called Rubbermastic, has a gilsonite base. Gilsonite dust, used for foundry cores, is a by-product of Utah mining. Manjak is a variety of grahamite from Cuba, Barbados, and Trinidad, used for insulation, japans, and varnishes. It is the blackest of the asphalts, has a higher melting point than gilsonite, but is usually not as pure. Millimar, of R. T. Vanderbilt Co., Inc., is processed gilsonite in 20-mesh powder used for rubber compounding.

**Ginger.** The most important spice obtained from roots, and one of the first Oriental spices known in Europe. It is the prepared root of the perennial herb *Zingiber officinale*, grown in India, China, the East Indies, and Jamaica. The roots are pale yellow and contain starch, an essential oil, and a pungent oleoresin, Gingerin. The first crop is the best; the product from the regrowth is called Rhatoon ginger and is inferior. Ginger is employed as a spice and condiment, in flavoring beverages and confections, and in medicine as a digestive stimulant and carminative. It has a cooling effect on the body. Preserved ginger is made by peeling off the thick scaly skin of the boiled roots and boiling in a sugar solution. Dried ginger is prepared by drying the peeled roots in the sun. When the roots have been boiled in lime water before peeling, Black ginger is produced. White ginger is made by bleaching the roots.

Other plants of the ginger family are also used as spices and flavors. Angelica is from the perennial herb *Angelica archangelica*, of Syria and Europe. All parts of the plant are aromatic. Angelica oil, distilled from the fruit, is used in perfumes, flavors for vermouth and bitters, and in medicine. Candied angelica consists of the stems steeped in sirup. It is bright green in color, has an aromatic taste, and is used for decorating confections. Galangal is from the roots of the perennial herb *Languas officinarum*, of China. It has an aromatic odor and pungent taste similar to a mixture of ginger and pepper. It is used chiefly as a flavor, but also in medicine. Turmeric, highly popular in India and Malaya as an ingredient of curries, is from the rhizomes

of the perennial plant *Curcuma longa*, of South China and the East Indies. When used as a dye it is called India saffron. The roots are cleaned and dried in the sun. It is very aromatic, with a pungent bitter taste. Curry powders are not turmeric alone, but mixtures of turmeric with pepper, cumin, fenugreek, and other spices. Turmeric is used to flavor and color foodstuffs, and as a dyeing agent for textiles and leather and in wood stains. The natural dye is reddish brown, and gives a yellow color to textiles and foods. It is also used as a chemical indicator, changing color with acidity or alkalinity. Zedoary consists of the dried roots of the perennial plant *C. zedoaria*, grown in India. Zedoary oil is a viscid liquid of reddish color with an odor resembling ginger and camphor. It is used in flavoring, in medicine, and in perfumery.

**Glass.** An amorphous solid made by fusing silica with a basic oxide. Its characteristic properties are its transparency, its hardness and rigidity at ordinary temperatures, its capacity for plastic working at elevated temperatures, and its resistance to weathering and to most chemicals except hydrofluoric acid. The so-called organic glasses of transparent plastics, and the soft, soluble glasses with phosphates replacing the silica, are not glass in the established sense of the term, regardless of their transparency. Glass was made in ancient times by fusing sand and an alkali. The Egyptians were famous glassmakers, and were able to blend in various mineral oxides for color and other effects, but glass was not used extensively for windows until modern times. A simple Soda-lime glass may be represented by the formula  $\text{Na}_2\text{O} \cdot \text{CaO} \cdot 6\text{SiO}_2$ , which is nearly the type formula of the garnets except for the silicate crystallization, but glass is not a simple chemical compound. The structure is described as an open chain of silicon atoms, with the atoms of the oxides occupying the spaces in the loose structure. It does not crystallize like silica alone, and many garnets when melted will cool to an amorphous glass. However, to obtain a chemically homogeneous vitreous, or glassy, solution, with a minimum number of molecules in the crystalline state, requires a controlled slow cooling of the glass.

In its simplest form glass is made by melting together silica and soda ash. Bottle glass is a simple soda-lime-silica glass, the greenish color being due to iron impurities. The lime acts as a flux, and the calcium



silicate produced gives the glass a chemical stability which quartz and fused silica do not have. The brilliance and sparkle in glass for bottles for food and drug containers are obtained by adding a small amount of barium. Glass is made in special furnaces by melting selected batches of raw materials to which may be added broken scrap glass called Cullet. The hardness, transparency, and brilliance of the glass vary with the composition. Metallic oxides may be used to color glass or to give special properties. Feldspar is employed as a source of alumina and to prevent disassociation of the soda ash and silica. Soda ash prevents fogging. Crown glass for windows is a hard, white soda-lime glass high in silica, a typical composition being 72%  $\text{SiO}_2$ , 13  $\text{CaO}$ , and 15  $\text{Na}_2\text{O}$ . It derives its name from the circular crowning method of making the sheets, but it is highly transparent and will take a brilliant polish. The so-called Hard glass, or Bohemian glass, for brilliant glassware, is a potash-lime glass with a high silica content, the potash glasses in general not being as hard as the soda glasses, and having lower melting points. The artistry is largely responsible for the quality of Bohemian glass.

Heat-resistant glass may be borosilicate glass that is heat-treated or leached to remove the alkali. Such glasses withstand high heat and sudden cooling without shattering. The Duran glass used in Germany for chemical tubes and pipes contained  $\text{B}_2\text{O}_3$  and a small amount of alumina, with the smallest possible amount of alkali. Pyrex, of the Corning Glass Co., is a borosilicate glass for chemical equipment and cooking utensils. It has a specific gravity of 2.25, Scleroscope hardness of 120, and refractive index 1.4754, with high light transmission. It will withstand temperatures to  $1100^\circ\text{F}$ , and is shock-resistant. The Vicor glass of the same company is a silica glass made from a soft alkaline glass by leaching in hot acid to remove the alkalies, and then heating to  $2000^\circ\text{F}$  to close the pores and shrink the glass. The glass will withstand continuous temperatures to  $1600^\circ\text{F}$  without losing its strength or clarity. It will withstand temperatures to  $1800^\circ\text{F}$ , but becomes cloudy and opaque. The glass has high thermal shock resistance.

Phosphate glass, developed by the American Optical Co., will resist the action of hydrofluoric acid and fluorine chemicals. It contains no silica, but is composed of  $\text{P}_2\text{O}_5$  with some alumina and magnesia. It is transparent and can be worked like ordinary glass,

but it is not resistant to water. Fluorex glass, marketed in rods and tubes by the Haverford Glass Co., is a phosphate glass containing 75%  $P_2O_5$  and less than 0.5 silica. It is decomposed by alkalis.

Quartz glass, or pure fused quartz, is entirely transparent to ultraviolet rays, but it is not a glass in the strict sense of the term, and fused quartz must have a special long heat-treatment to prevent crystallization. Flint glass for windows is a highly transparent soda-lime-quartz glass. Lustraglas, of the American Window Glass Co., is a highly transparent flat-drawn quartz glass. Window glass is any highly transparent glass for windows. Thermopane, of the Libbey-Owens-Ford Glass Co., is a heat- and sound-insulating window glass made with two panes of glass separated by a metal bonded to the edges of the glass, leaving an insulating layer of dehydrated air between the two glass sheets. The highly refractive flint glass used in the Rhinestones for cheap jewelry and for the Paste diamonds, which derive their name from their softness as compared with the diamond, contain lead. They have an index of refraction of 1.67, but lack the double refraction and regular molecular arrangement of true gem crystals. Lead is also used in the Crystal glass used for cut glassware, and the brilliance from the lead is higher in the potash glasses than in the soda. English crystal, which is a potash glass, contains as high as 33% lead oxide. It has high clarity and brilliancy, but is soft. Leaded glasses are also heavy, a crystal glass having a specific gravity of 6.33 compared with 2.25 for a borate glass. The boric oxide glasses, or Borax glasses, are transparent to ultraviolet rays. The so-called Invisible glass is a borax glass surface treated with a thin film of sodium fluoride. It transmits 99.6% of all visible light rays, thus casting back only slight reflection and giving the impression of invisibility. Ordinary soda and potash glasses will not transmit ultraviolet light. Glass containing 2 to 4% ceric oxide absorbs ultraviolet rays, and is also used for X-ray shields. Glass capable of absorbing high-energy X-rays or gamma rays may contain tungsten phosphate. Fluorescent glass for mercury-vapor discharge tubes contains ceric oxide. The Kromex glass of the MacBeth-Evans Glass Co., used for gasoline dispensing pumps, is a glass made to stop the passage of ultraviolet rays.

The Conductive glass of the Libbey-Owens-Ford Glass Co., known as Electrapane, used for windshields to eliminate icing, and also for

shielding electronic instruments against stray radio-frequency radiations, is a plate glass with a thin film of tin oxide 0.00002 in. thick on one side or both sides. The oxide is applied at high temperature, is completely transparent, and will conduct an electric current to heat the glass. A similar conductive glass of the Pittsburgh Plate Glass Co. is called Nesa. Transparent mirror glass of the Libbey-Owens-Ford Glass Co. is coated under high vacuum on one side with an extremely thin film of chromium. The glass is a reflecting mirror when the light behind the glass is less than in front, and is transparent when the light intensity is higher behind the glass. Photosensitive glass of the Corning Glass Works is made by mixing submicroscopic metallic particles in the glass. When ultraviolet light is passed through the negative on the glass, it precipitates these particles, making them come out of solution. As the shadowed areas of the negative penetrate further into the glass than the highlight areas, the picture is in three dimensions and in color. The photograph is developed by raising the temperature of the glass to 1000°F.

Metal salts are used in glass for coloring as well as controlling the characteristics. Manganese oxide is added to most glass to neutralize iron oxide, but an excess colors the glass violet to black. Jena blue glass gets its color and fluorescence from a mixture of cobalt oxide and ceric oxide. Ruby glass, of a rich red color, is produced with selenium and cadmium sulphides, or with copper oxide. It is also produced with Purple of cassius, or Gold-tin purple, a brown powder which is a mixture of the yellow Gold chloride  $\text{AuCl}_3$  and the dark-brown Tin oxide  $\text{SnO}$ . Red-stained glass is made by placing a copper compound on the surface of the hot glass, or the copper may be introduced into the hot glass as a vapor of copper chloride. Intensity of color varies with the time and temperature. Amber glass is made with controlled mixtures of sulphur and iron oxide that give tints varying from pale yellow to ruby amber. Amber glass is much used for medicine bottles to prevent entry of harmful light rays. The Actinic glass of the Pennsylvania Wire Glass Co., used for skylights and factory windows, has a yellow tint that softens and diffuses the light and impedes passage of heat rays. Neophane glass is glass containing neodymium oxide which reduces glare and is used in yellow sunglasses, or small amounts may be used in windshield glass. Opalescent glass, or Opal glass, used for light shades, table tops, and cosmetic

jars, has structures that cause light falling on them to be scattered, and they thus are white or translucent. They owe their properties to tiny inclusions with different indexes of refraction, such as fluorides, sulphides, or oxides of metals. Alabaster glass has inclusions of larger dimensions in lower numbers per unit than opal glass, and it shows no colors, whereas opalescent glass appears white by reflected light but shows color images through thin sections. Opal glass may contain lepidolite, which mineral contains various metals.

Monax glass, of the MacBeth-Evans Glass Co., is a white diffusing glass for lamp shades and architectural glass. Glass blocks for translucent units in factory walls are made from types of opalescent glass. Insulex, of the Owens-Illinois Glass Co., is a translucent glass brick of this kind. Polarized glass, for polarizing lenses, is made by the American Optical Co. by adding minute crystals of tourmaline or peridot to the molten glass, and stretching the glass while still plastic to bring the axes of the crystals into parallel alignment. Florentine glass does not refer to a mixture but to an ornamental glass made by casting on an embossed bed, or by rolling with a roll upon which the designs are cut. Powdered glass, used as a filler in plastics, paints, composition tiles, and roofings, is made by grinding broken scrap glass.

**Glass fiber.** The fine flexible fibers made from glass, used for heat and sound insulation, fireproof textiles, acid-resistant fabrics, retainer mats for storage batteries, panel boards, filters, and electrical insulating tape, cloth, and rope. It is distinct from mineral wool in that it is a glass made to definite formulation with a uniformity not found in mineral wool. Molten glass strings out easily into threadlike strands, and this Spun glass was early used for ornamental purposes, but the first long fibers of fairly uniform diameter were made in England by spinning ordinary molten glass on revolving drums. The original fiber was about 0.001 in. in diameter. It was called Glass silk and Glass wool, and the loose blankets for insulating purposes, were called Navy wool. The term navy wool is still used for the sewn insulating blankets of fine fibers faced on both sides with flame-proofed muslin. These are made to Navy specifications for temperatures of 600 to 1000°F, and used for duct and pipe insulation and for soundproofing. It is also available in loose batts. Glass fibers are

now made by letting the molten glass drop through tiny orifices and blowing with air or steam to attenuate the fibers. The usual composition is that of a soda-lime glass, but it may be varied for different purposes. The glasses low in alkali have high electrical resistance, while those of higher alkali are more acid resistant. They have very high tensile strengths, up to about 400,000 psi, but the breaking strength of yarns is expressed in pounds for any given yarn.

The commercial glass fibers marketed under the name of Fiberglas by the Owens-Corning Fiberglas Co. are made in seven standard diameters from 0.0002 to 0.008 in. The textile fibers from 0.0002 to 0.0004 in. are very flexible and silky and can be spun and woven on regular textile machines. Fiberglas cloth and Fiberglas tape are made in satin, broken twill, and plain weaves, the satin weave cloth 0.007 in. thick weighing 7 oz per sq yd. The Lagging cloth for high-temperature pipe insulation is a heavy Fiberglas cloth of 20 oz per sq yd. Glass insulating sheet, of the Irvington Varnish & Insulator Co., consists of tightly woven Fiberglas fabric impregnated with a clear or black insulating varnish. The finished cloth varies in thickness from 0.005 to 0.012 in., the glass fabric of the thinnest being 0.003 in. The 0.005-in. sheet has a tensile strength of 110 psi of width, equal to 22,000 psi, and a dielectric strength of 1,200 volts per mil. Glastic, of Laminated Plastics, Inc., is a laminated sheet of glass fiber bonded with a heat-resistant plastic designed for electrical insulation to resist arcing. The sheets come in thicknesses from  $\frac{1}{32}$  to 1 in. Glass insulating tape, of the Industrial Tape Corp., is Fiberglas fabric in tape form coated with a pressure-sensitive adhesive. The glass fabric used by Bar-Ray Products, Inc., for making garments to shield against X rays has a high lead content in the glass.

Glass cloth of plain weave of either continuous fiber or staple fiber is much used for laminated plastics. The cloth comes in thicknesses from 0.002 to 0.023 in. in weights from 1.43 to 14.7 oz per sq yd. Glasfab, of the Lexington Supply Co., is a loosely woven glass fabric, 2.2 oz per sq yd, for application to roofs to be coated with asphalt. Fiberglas yarns are marketed in various sizes and twists, in continuous or staple fiber, and with glass compositions for chemical or electrical applications. Vitron yarn, of Glass Fibers, Inc., is a plied low-twist yarn for braiding insulation for magnet wire. Glass sewing thread has a high twist. The minimum breaking strength of the 0.014-in. thread

is 12 lb, and that of the 0.020-in. thread is 24 lb. Glass mat is composed of 0.0005-in. fibers felted or intertwined in random orientation to make a thin, porous material. It is used for making panel boards, impregnated sheets, and for air filters. Glasfloss, of the Glasfloss Corp., is prepared glass mat in thicknesses 0.10 to 0.125 in. Conolon, of the National Research & Mfg. Co., and Conolite, of the Consolidated Vultee Aircraft Corp., are lightweight construction boards made by impregnating glass fabric with 20% of a thermosetting resin and curing with heat and a light pressure of 10 psi. The tensile strength of the board is 120,000 psi, specific gravity 1.15, and hardness 98 Rockwell M. It is used for aircraft paneling and light structures. Alsynite, of the Allied Synthetics Co., is a translucent corrugated building sheet made of glass fiber mat impregnated with plastic. It weighs 8 oz per sq ft, and comes in standard corrugated sheet sizes. Corresite, of S. Blickman, Inc., is glass fabric with synthetic resin molded in the form of pipes and fittings for chemical use. Glass filter cloth is made in twill or satin weaves in thicknesses from 0.030 to 0.070 in., and is used for chemical filtering. Glass fabric belting is marketed by the B. F. Goodrich Co. to replace cotton conveyer belting for handling hot materials. Fiberglas PF is glass fiber preformed into pipe, sheet, and other insulation coverings bonded with a thermosetting resin. It will withstand temperatures to 600°F. Fiberglas block is also bonded with a small amount of resin and will withstand temperatures to 600°F.

**Glass sand.** Sands employed in glassmaking. They are all screened, and usually washed to remove fine grains and organic matter. The grain standards of the American Ceramic Society specify that all should pass through a No. 20 screen, between 40 and 60% should remain on a No. 40 screen, between 30 and 40% should remain on a No. 60 screen, between 10 and 20% on a No. 100 screen, and not more than 5% should pass through a No. 100 screen. Sand for first-quality optical glass should contain 99.8%  $\text{SiO}_2$ , a maximum of 0.1  $\text{Al}_2\text{O}_3$  and 0.02  $\text{Fe}_2\text{O}_3$ . Third-quality flint glass may contain only 95%  $\text{SiO}_2$  and as high as 4  $\text{Al}_2\text{O}_3$ . Only in the eighth- and ninth-quality amber glasses is the content of  $\text{Fe}_2\text{O}_3$  permitted to reach 1%. Potters' sand is usually a good grade of glass sand of uniform grain employed for packing to keep the ware apart.

**Glucose.** A sirupy liquid of the composition  $\text{CH}_2\text{OH}(\text{CHOH})_4\text{CHO}$ , which is a monosaccharide, or single sugar, occurring naturally in fruits and in animal blood, or made by the hydrolysis of starch. It is also produced as a dry white solid by evaporation of the sirup. Glucose is made readily from cornstarch by heating the starch with dilute hydrochloric acid, which is essentially the same process as occurs in the human body. Most of the commercial glucose is made from cornstarch. It is only 70% as sweet as cane sugar and has a slightly different flavor. It is used in confectionery and other foodstuffs, in tobacco and inks to prevent drying, in tanning, as a reducing agent, and for blending with cane sugar and sirups to prevent crystallization on cooling and because it is usually cheaper than sugar. The name glucose is usually avoided by the manufacturers of edible products, because of prejudices against its substitution for sugar, but in reality it is a simple form of sugar easily digested. It is used in medicine as a blood nutrient and to strengthen heart action, and may be harmful only in great excess. When free from starch, it is called Dextrose. It is also marketed as Corn sirup, but corn sirup is not usually pure glucose, containing some dextrine and maltose. The maltose, or Malt sugar, in the combination has the empirical formula  $\text{C}_{12}\text{H}_{22}\text{O}_{11}$ . When hydrolyzed in digestion, it breaks down easily to glucose. When purified, it is transparent and free of malt flavor. It is not as sweet as the sucrose of cane sugar, but is used in confectionery and as an extender of cane sugar. Glucose derived from grapes is called Grape sugar. The glucose in fruits is called Fruit sugar, Levulose, or Fructose. This is dextroglucose, and when separated out is in colorless needles which melt at  $104^\circ\text{C}$ . It is used in pharmacy. Corn sugar is also a solid white powder, being glucose with one molecule of water of crystallization. When the refined liquor is cooled, the corn sugar crystallizes in a mother liquor known as Hydrol, or Corn sugar molasses. This molasses is screened and washed off, and marketed for livestock feed. The crystalline monohydrate sugar is known as Cerelese.

**Glue.** A cementing material usually made from impure gelatin from the clippings of animal hides, sinews, horn and hoof pith, from the skins and heads of fish, or from bones. The term Animal glue is limited to Hide glue, Extracted bone glue, and Green bone

glue. Fish glue is not usually classed with animal glue, nor is casein glue. The vegetable glues are also misnomers, being classed with the mucilages. Synthetic resin glues are more properly classed with adhesive cements. Animal glues are hot-work glues, applied hot, and bind on cooling. Good grades of glue are semitransparent, free from spots and cloudiness, and are not brittle at ordinary temperatures. Bone glue is usually light amber in color; the strong hide and sinew glues are light brown. The stiffening quality of glue depends upon the evaporation of water, and it will not bind in cold weather. Glues made from blood, known as Albumen glues, and from casein are much used for fastening plywood. However, they do not have the strength of the best grades of animal glue, and are not resistant to mold or fungi. Marine glue is a glue insoluble in water, made from solutions of rubber or resins, or both. The strong and water-resistant plywoods are now made with synthetic resin adhesives.

Animal glue has been made since ancient times, and is now employed for cementing wood, paper, and paperboard. It will not withstand dampness, but white lead or other material may sometimes be added to make it partly waterproof. Casein glues and other protein glues are more water-resistant. Soybean glue is made from soybean cake and is used for plywood. It is marketed dry. It has greater adhesive power than other vegetable glues, or pastes, and is more water-resistant than other vegetable pastes. Hide glue is used in the manufacture of furniture, abrasive papers and cloth, gummed paper and tape, matches, and print rollers. The bone glues are used either alone or blended in the manufacture of boxes, cartons, and trunks. Green bone glue is used chiefly for gummed paper and tape for cartons. In making bone glue the bones are crushed, the grease extracted by solvents, and the mineral salts removed by dilute hydrochloric acid. The bones are then cooked to extract the glue. Glues are graded according to the quality of the raw material, the method of extraction, and the blend.

There are 16 grades of hide glue and 15 grades of bone glue. Those with high viscosity are usually the best. Most glue is sold in ground form, but also as flake or pearl. Glues for such uses as holding abrasive grains to paper must have flexibility as well as strength, obtained by adding glycerin. The Animal protein colloid of Swift & Co. is a highly purified bone glue especially adapted for use as an



emulsifier, and for sizing, water paints, stiffening, and adhesives. Hoof and horn-pith glue is the same as bone glue, and is inferior to hide glue. Fish glue is made from the jelly separated from fish oil, or from solutions of the skins. The best Fish glue is made from Russian isinglass. Fish glues do not form gelatin well and are usually made into Liquid glues for photo mounting, gummed paper, household use, and for use in paints and sizes. The liquid glues are also made by treating other glues with a weak acid. Pungent odors indicate defective glue. The glues made from decomposed materials are weak. Preservatives such as sulphur dioxide or chlorinated phenol may be used. In use, glues should not be boiled. The melting point is usually about 140°F.

**Glycerin.** Also called Glycerol. A trihydroxy alcohol of the composition  $C_3H_5(OH)_3$ , forming an important constituent of oils and fats from which it is set free during saponification. Glycerin is a colorless, sirupy liquid with a sweet, burning taste. It is soluble in water and in alcohol. Much of the American production comes as a by-product in the manufacture of soap, but it is also a by-product in the fractionation of fats, or as a by-product in the fermentation of sugar or molasses for alcohol. It is also made synthetically from propylene. The German glycerin substitute Glycero-gen contains 40% glycerin, 40 propylene glycol, and 20 hexyl alcohols, and was made by the catalytic hydrogenation of hexose from wood. Coconut oil yields about 14% glycerin, palm oil 11%, tallow 10%, soybean oil 10%, and fish oils 9%. Glycerin has a boiling point of 220°C, freezing point 17°C, and the double-distilled product has a specific gravity of 1.260. It is marketed crude or distilled. In water solutions the freezing point is lowered, reaching -60°F, the lowest point, at 37% of water. It is thus valuable as an anti-freeze liquid. Glycerin is used in making plastics, as a plasticizer in resins, to control flexibility in adhesives and coatings, in water solution with phosphoric acid as the electrolyte for the electrolytic polishing of metals, and in making nitroglycerin and dynamite. It does not evaporate easily and has a strong affinity for water, and is thus used in products that require to be kept from drying such as foodstuffs, cosmetics, tobacco, and stamping inks. As it is nontoxic, it is used as a solvent for pharmaceuticals. It is also used as an antiseptic in

surgical dressings, as an emollient in throat medicines, and as a counterirritant in cosmetics.

**Gold.** An elementary metal, symbol Au, known since the most ancient times as one of the precious metals. It is so chemically inactive that it is found mostly in the native state. It is found widely distributed in all parts of the world. It is employed chiefly for coinage, ornaments, jewelry, and for gilding. Gold is extracted by crushing the ores and catching the metal with quicksilver. About 25% of the gold produced in the United States is placer gold and about 5% is a by-product of the copper industry. Ore with only 50 cents worth of gold per ton can be profitably worked by modern methods. The average gold recovered from ore in Western United States is 0.2 oz per ton of ore, and in Alaska 0.044 oz per ton. Native gold is usually alloyed with silver, placer gold being the purest. The natural alloy of gold and silver was known as Electrum, and under the Egyptian name of Asem was thought to be an elementary metal until produced as an alloy by the Romans. Gold is yellow in color, soft, and is the most malleable of all the metals. It can be beaten into extremely thin sheets. A gram of gold can be worked into leaf covering 6 sq ft, and only 0.0000033 in. thick, or into a wire 1.5 miles in length. Cast gold has a tensile strength of 20,000 psi. The specific gravity is 19.32, and the melting point 1943°F. It is not attacked by nitric, hydrochloric, or sulphuric acid, but is dissolved by aqua regia, or by a solution of azoimide.

Because of its softness, gold is almost always alloyed with other metals, usually copper, silver, or nickel, and graded on a basis of degrees of fineness in 1,000 parts, or on the basis of carat gold value, pure gold being 24 carats. Green gold, used in making jewelry, is an alloy of gold, silver, and copper, graded from 14 to 18 carats. The 18-carat green gold contains 18 parts gold and 6 silver, with no copper. The 15-carat grade contains 15 parts gold, 8 silver, and 1 copper. The 14-carat grade contains 14 parts gold, 8¼ silver, and 1¾ copper. Coinage gold in the United States is 90% gold and 10 copper. In England it is 91.66% gold and 8.33 copper, and this alloy is called Standard gold. In Australia 8.33% silver is used instead of the copper, and the Gold-silver alloy is called Australian gold. Dental gold is a term for a wide range of wrought and cast alloys with

usually from 65 to 90% gold, 5 to 12 silver, and frequently platinum and sometimes palladium. A very small amount of iridium may also be used for hardening. Colors vary from white to yellow, and such alloys are also used for jewelry and for acid-resistant plates. Gold is easily electroplated on other metals and is thus much used for jewelry, ornaments, and for chemical resistance, but the gold is so soft that the thin plates wear off easily. Hard gold plate is a Gold-indium plate. The process of the Indium Corp. of America is to plate the gold and indium successively and then alloy by diffusion at 330°F. Precipitation hardening takes place, giving a hard, wear-resistant coating.

South Africa is the most important producer of gold. Other important producers are Canada, the United States, and Western Australia, but gold is produced in 90 other countries. The ore of gold known as Calaverite, found in Colorado, California, and West Australia, is a Gold telluride,  $\text{AuTe}_2$ , containing theoretically 44% gold, found with the gold-silver telluride Sylvanite,  $(\text{AuAg})\text{Te}_2$ . It is a silvery-white granular mineral of specific gravity 9.35, and hardness 2.5, easily fusible.

**Granite.** A coarse-grained, igneous rock having an even texture, and consisting largely of quartz and feldspar with often small amounts of mica and other materials. There are many varieties. Granite is very hard, compact, and takes a fine polish, showing the beauty of the crystals. It is the most important building stone, and is also used as an ornamental stone. An important use is also for large rolls in pulp and paper mills. Granite surface plates, for machine-shop layout work, are made in sizes up to 30 by 72 in. and 10 in. thick, ground and highly polished to close accuracy. It is extremely durable, and since it does not absorb moisture like limestone or sandstone, it does not weather or crack like these stones. The colors are usually reddish, greenish, or gray. Rainbow granite may have a black or dark-green background with pink, yellowish, and reddish mottling, or it may have a pink or lavender background with dark mottling. The weight is 170 lb per cu ft, the specific gravity 2.72, and the crushing strength is from 23,000 to 32,000 psi. The most notable granite quarries are in northern New England. Mount Airy granite from North Carolina is light gray in color, and is a Biotite containing feldspar, quartz,

and mica. It is somewhat lighter in weight and of lower crushing strength than Maine granite. The hard composite igneous rock Diabase, called Black granite, is used by the Bahn Granite Surface Plate Co. for making precision parallels for machine-shop work. Unakite is a granite of Virginia and North Carolina with a mosaic of red, green, and other colors. It is used as an ornamental building stone. Balfour pink granite of North Carolina contains 72% silica, 14.1 alumina, 2 soda, 6 potash, 1.2 iron oxide, 0.12 titanium oxide, 0.20 manganese oxide, and 0.36 lime. The granite known as Pegmatite, of which there are vast quantities, contains beryllium in the form of beryl as a minor constituent.

**Grapeseed oil.** An oil obtained by pressing or extraction from grape seeds which are a by-product from the wine industry. The seeds contain 10 to 15% oil, highly valued in Europe as an edible oil and for soaps. The cold-pressed oil is almost colorless, sweetish, and is similar to olive oil. The hot-pressed oil is dark green and is not sweet. The refined oil has a delicate green color and a nutlike taste. Grapeseed oil contains about 32% oleic acid, 52 linoleic acid, and palmitic, stearic, and arachidic acids. In the United States it is used for paints and soaps.

**Graphite.** Also called Plumbago. It was formerly known as Black lead, and when first used for pencils was called Flanders' stone. A natural variety of elemental carbon having a grayish-black color and a metallic tinge. It occurs in two forms: foliated and amorphous. Foliated graphite is used principally for crucibles and lubricants, and amorphous for lead pencils, foundry facings, electric brush carbons, stove polish, and paint pigments. It is infusible, but oxidizes at 600 to 700°C. It is a good conductor of heat and electricity, is resistant to acids and alkalis, and is readily molded. The specific gravity is 2 to 2.5. The hardness is 1 to 2, sometimes less than 1, and it has a decidedly greasy feel. It is a good lubricant, especially when mixed with grease, but the natural graphite contains silica and other abrasive materials so that the artificial graphite is preferred for lubricants. Graphite powder made in the electric furnace is superior to natural graphite because of its purity. It is marketed in grades by purity, electrical resistance, and fineness. It is used for molded products such as arclight carbons, chemical equipment parts, and carbon

brushes, and also for graphited bearings, paints, and ink pigment, mold wash, covering molten steel to reduce piping, crucibles, and in rubber compounding. Mexacote is a colloidal graphite powder of the U.S. Graphite Co. to be mixed with water for spraying on sand molds to increase heat resistance. Colloidal graphite is also marketed in dispersions of alcohol and carbon tetrachloride for machine bearings. The alcohol evaporates, leaving an extremely thin coating of graphite on the bearing to act as a lubricant and as a wetting agent for the oil film. Artificial graphite is produced at very high temperatures, about  $3000^{\circ}\text{C}$ , and it will withstand this temperature indefinitely in inert atmospheres, but combines with oxygen in the air above  $600^{\circ}\text{C}$ .

Graphite is found in large deposits in Mexico, India, Ceylon, and in the United States in Alabama and New York. Of the imported, the amorphous comes from Mexico and the crystalline from Ceylon and Madagascar. A proportion of Ceylon crystalline lump graphite is used in mixes for crucibles. Natural graphite occurs in veins in rock and always contains some impurities. Some varieties containing as little as 35% graphitic carbon are used for paints. No. 1 Flake graphite should contain 90% graphitic carbon. Mexican Amorphous graphite carries 80%. The best Madagascar graphite contains 95% carbon, lower grades contain 85 to 87.5%, while the powders are as low as 75% carbon. Crystalline graphite and Flake graphite are really synonymous terms to describe material of high graphite content, as distinguished from amorphous. Molding graphite is natural amorphous impure graphite ground to extreme fineness, used in foundry work. This type of graphite is also used for lead pencils. The amorphous graphite is mixed with clay and fired, the amount of clay determining the hardness of the pencil. Indelible lead for pencils may be graphite with a dye.

Combination lead is a term for ground graphite used for foundry facings. Graphite carbon raiser is a term given to graphite powder of 90% or more purity used for adding to molten steel to raise the carbon content. The grades are according to particle size with the finest having 98% through a 20-mesh screen. Scrap carbon electrodes are also used for this purpose. Molded graphite brushes for motors and generators may have the graphite mixed with metal powders, and the electric-carrying capacity varies with the metal powder. The molded graphite of Falls Industries, Inc., known as

**Impervite**, used for chemical equipment parts, is impregnated with synthetic resin. **Delanium**, an English molded carbon impervious to liquids and gases and of high strength, used for pump parts, tubes, and chemical equipment, is a carbon and graphite mixture made by firing finely ground coking coal in a controlled atmosphere. Extremely fine particles of artificial colloidal graphite will remain in suspension indefinitely, and are marketed in distilled water, mineral oil, castor oil, glycerin, or resin varnish, under trade names. **Prodag** is a solution in water marketed by the Acheson Colloids Corp. for foundry facings. **Grafita** and **Grafene**, of the United States Graphite Co., are grease and oil solutions for lubricating purposes.

**Graphited metals.** Graphite and metal or metallic oxide mixtures sometimes erroneously referred to as alloys, used chiefly as bearing metals. There are two general classes, those called bronze and those of the white metal or babbitt type. In general, the materials are produced by diffusing or sintering the powdered materials that have been compressed in molds. Graphited bronze, of the Johnson Bronze Co., contains 40 to 45% graphite; the remainder is metal. A grade of this material is called **Ledaloyl**. **Genelite** is a spongy bronze made by heating the powdered oxides of copper, lead, and tin with an excess of graphite, shaping in steel molds under high pressure, and sintering in a furnace. The porosity due to the graphite permits the product to absorb about 20% by volume of oil. The tensile strength is 8,000 psi, and the compressive strength 50,000 psi. **Genelite** is a product of the General Electric Co., used for bearings and sealing rings. **Oilite**, marketed by the Amplex Division, Chrysler Corp., is an 88-10-2 type of bronze made by briquetting the finely powdered metals and graphite under high pressure, heat-treating, finishing to size, and impregnating with the lubricant. The oil content averages 35% by volume. It is used as a self-lubricating bearing metal for speeds up to 30,000 rpm, and pressures of 6,000 psi. **Graphalloy**, of the Graphite Metallizing Corp., is made with either bronze or babbitt metals, and the molten metal is forced into the graphite powder under high pressure. It is marketed in the form of bushings, rods, and tubes. **Durex bronze**, of the Moraine Products Div., General Motors Corp., is a diffused material made by sintering the partly reduced oxides of bronze metals with graphite under pressure. The

resulting Graphite bronze will take up 29% of its volume of lubricant by capillarity. Gramix, of the United States Graphite Co., is a similar material. Graphex is the name of a series of bronze and babbitt graphited bearing metals of the Neveroil Bearing Co. The bronze metals have compressive strengths of about 30,000 psi, and the white metals 16,000 psi. In the Boroto metal, produced by E. Siegrist, London, the graphite is in colloidal form, and the metal can be remelted without destroying its qualities. All of the graphited metals can be machined with sharp tools.

**Gravel.** A natural material composed of small, usually smooth, rounded stones or pebbles. It is distinguished from sand by the size of the grain, which is usually above  $\frac{1}{4}$  in., but gravel may contain large stones up to 3 in. in diameter, and some sand. It will also contain pieces of shale, sandstone, and other rock materials. Gravel is used in making concrete for construction, and as a loose paving material. Commercial gravel is washed to remove the clay and organic matter, and screened. Pea gravel is screened gravel between  $\frac{1}{4}$  and  $\frac{1}{2}$  in. in diameter. It is used for surfacing with asphalt, or for roofing. Gravel is sold by the cubic yard or by the ton, and is shipped by weight. Bank-run gravel, with both large and small material, weighs about 3,000 lb per cu yd.

**Greenheart.** The wood of the tree *Octotea rodioei* of British Guiana, especially valued for shipbuilding, dock timbers, planking, and lock gates because of its resistance to fungi and termites. It also goes under the name of Demerara greenheart, and under its native name of Bibiru. The tree grows to a height of 120 ft, with diameter of 2 to 3 ft, clear of branches for 50 to 70 ft. The wood is very strong and hard with good wearing qualities. The average weight is 62 lb per cu ft with 12% moisture. The specific gravity, oven-dried, is 0.80. The heartwood is light olive to nearly black, and the sapwood pale yellow to greenish.

Surinam greenheart is the wood Bethabara, from the tree *Tecoma leucoxylon* of Dutch and French Guianas. It is distinguished from greenheart by the yellow deposits in the pores, and is not as resistant as greenheart. Manbarklak, the wood of the tree *Eschweilera corrugata*, of Surinam, is reddish brown in color, weighs 76 lb per cu ft, is equal to greenheart for marine construction, but is scarcer. An-

gelique, the wood of the tree *Dicorynia paraensis* of the Guianas and lower Amazon, is very resistant to fungi and insect attack, and is used as a substitute for greenheart in marine construction. It is hard but not as heavy as greenheart, weighing 50 lb per cu ft. It has an olive-brown color with reddish patches. African greenheart is Dahoma, the wood of the large tree *Piptadena africana* of the west coast of Africa. It is yellowish brown in color, weighs 50 lb per cu ft, but is not as resistant to marine borers as greenheart. The wood of a species of tonka bean tree of Panama, known as Almendro, *Coumarouna panamensis*, is very resistant to marine borers and is used as a substitute for greenheart. It is yellowish brown in color and is very heavy. The almondlike seeds of the tree are used as a food.

**Grinding pebbles.** Hard and tough rounded small stones, usually of flint, employed in cylindrical mills for grinding ores, minerals, and cement. Pebbles from Greenland, marketed usually through Denmark and known as Danish pebbles, are of great hardness and toughness. Newfoundland also supplies these pebbles. Quantities of Flint pebbles also come from Denmark for use in tube mills. They are smooth, round pebbles formed by the washing of the sea on the chalk cliffs, and come from the islands off the Danish coast. Danish pebbles are graded in seven sizes, according to French standards from No. 0 which is 30 to 40 mm ( $1\frac{1}{2}$  to  $1\frac{3}{4}$  in.) to size E which is 100 to 130 mm (4 to 5 in.). Small pebbles,  $\frac{1}{2}$  in. in diameter, are used for polishing iron castings by tumbling. American grinding pebbles are chiefly from Minnesota, Ohio, Nevada, and from the beaches of California. Quartzite pebbles are produced in Nova Scotia and Saskatchewan. Quartz pebbles from Alabama are 99% silica and low in iron, but they do not wear as well as true flint pebbles. Granite, rhyolite, and andesite pebbles are also used for grinding. The Granite pebbles produced in North Carolina for feldspar and other mineral processing are broken into cubes and wet-milled to remove the edges and corners. They are graded in sizes from  $1\frac{1}{2}$  to 5 in. Porcelain grinding balls are made of high-grade resistant porcelain, and are marketed in stock sizes for use in tumbling barrels for grinding and polishing. They have the advantage over flint pebbles of greater uniformity. The Borundum of the U.S. Stoneware Co. is an aluminum oxide ball-mill abrasive in the form of short, white cylinders. The



material is dense, and is 80% heavier and 50% harder than flint pebbles.

**Grindstones.** Sandstones employed for grinding purposes. Grindstones are generally employed for the sharpening of edged tools, and do not compete with the hard emery, aluminum oxide, and silicon carbide abrasive wheels which are run at high speeds for rapid cutting. Grindstones are quarried from the sandstone deposits and made into wheels usually ranging from 1 to about 6 ft in diameter, and up to 16 in. in thickness. They are always operated at low speeds because of their inability to withstand high centrifugal stresses. The grades vary from coarse to fine. Good grindstones have sharp grains, without an excess of cementing material that will cause the stone to glaze in grinding. The texture must also be uniform so that the wheel will wear evenly. The hard silica grains are naturally cemented together by limonite, clay, calcite, quartz, or mixtures. Too much clay causes crumbling, while too much calcite results in disintegration in the atmosphere. An excess of silica results in a stone that is too hard.

**Guaiacum oil.** An essential oil distilled from the wood of the guayacan tree of Paraguay, is used in medicine, soaps, and perfumes. It is light gray in color, and is solid at temperatures below 45°C. The odor is that of a combination of tea leaves and roses. It is also called Guaiacwood oil. The wood yields 5 to 6% of the oil. Guaiac gum, also called Guaiacum, is the gum resin of the true *lignum vitae* trees used in varnishes, as a chemical indicator, and to prevent rancidity and loss of flavor in preserved and dehydrated foods. It is an effective antioxidant, although its chief use is in medicine as a stimulant and laxative. The resin comes in greenish-brown tears. Azulene is a blue dye extracted from guaiacum oil, from eucalyptus oil, and from some balsams. The azulenes derive names from the source, as Guaiazulene, but they all have the empirical formula  $C_{15}H_{18}$ , the molecule having two rings and five double bonds. The synthetic material is known as Vetivazulene. It comes in cobalt-blue crystals melting at 90°C.

**Guanidine nitrate.** A white granular powder of the composition  $(H_2N \cdot CNH \cdot NH_2) \cdot HNO_3$ , produced from cyanamide and ammonium nitrate, and employed in making flashless propellants and

pharmaceuticals, for coating blueprint paper to speed up development time, and in photographic fixing baths. It melts at 206 to 212°C and is strongly acid. Guanidine carbonate is a white nonhygroscopic granular powder of the composition  $(\text{H}_2\text{N}\cdot\text{CNH}\cdot\text{NH}_2)_2\cdot\text{H}_2\text{CO}_3$ . It decomposes at 198°C. It is soluble in water, and has an alkaline reaction. Guanidine carbonate is used in the manufacture of pharmaceuticals, as an emulsifier in soaps, and in photographic developing solutions. Other derivatives of guanidine, such as Diphenyl guanidine, are used as plasticizers and accelerators for rubber.

**Guava.** The fruit of the tree *Psidium guajava* of the myrtle family to which the clove, allspice, and eucalyptus belong. Because of its content of acids, sugars, pectin, and vitamins, it is valued in the food industries for blending in jellies and preserves. The pulp is also used in ice-cream manufacture. Vast quantities of guava are used for hard jellies in Latin America. The fruit has more than ten times the vitamin C content of the orange and retains it better. It also contains vitamins A and B<sub>1</sub> and 11.6% carbohydrates. The tree is native to America from Mexico to Peru and is also grown extensively in Brazil and the West Indies. It was one of the original Aztecan and Incan fruits, and is still known under the Carib name of Guayaba in Brazil and Argentina. There are about 150 varieties, and the large seedy fruit has a fragrant aroma and distinctive sweet flavor.

**Guayule.** A perennial plant, *Parthenium argentatum*, of the *Compositae* family, grown extensively in the semiarid regions of northern Mexico and southern California as a source of rubber. The plants are hardy woody shrubs that mature into the highest rubber content in 7 years. They contain in the dry state up to 22% guayule rubber, in all parts except the leaves. The plant is uprooted in 3 to 5 years and is crushed and pulverized in mills, and the rubber extracted by flotation. The guayule rubber contains from 20 to 25% resin so that it is suitable only for blending or for cements unless deresinated. Natural crude guayule is softer than hevea rubber, owing to the content of natural resins which act as plasticizers. In the low-sulphur compounds it remains permanently tacky, and is thus valued for use as a coating adhesive for the permanently tacky binding tape known as Scotch tape. When deresinated by extraction of the resin with acetone or other solvent, the rubber is suitable for all the uses of

hevea rubber. The by-product Guayule resin is used in plastics. From 400 to 1,000 lb of rubber are produced per acre under cultivation.

**Gum.** The wood of the tree *Liquidambar styraciflua*, of the United States and Mexico. It is also called Red gum and Sweet gum. In England it is known as California red gum although the gum wood of California is from a eucalyptus tree. In Europe, also, the term Satin walnut is used for the heartwood and Hazel pine for the sapwood. Gum has a reddish-brown color, is soft with a fine, close grain, and weighs about 40 lb per cu ft. It is used for furniture, veneer, inside trim, cooperage, and the making of pulp for book paper. The timber is cut mostly in the Southern states, especially in Louisiana, Mississippi, and Arkansas. The trees have a height 80 to 100 ft and average 1½ to 3 ft in diameter with a straight clear trunk. Red gum is from the heartwood of mature trees and is reddish brown, Sap gum comes from the outer portion of logs or from young trees and is white tinged with pink. Nearly 25% of all the hardwood used in the United States is red gum. It has an interlocking grain which gives a fine appearance in veneers, but has a tendency to warp.

Gum is graded according to standards of the National Hardwood Lumber Association from firsts through selects to No. 3B common. Local names for red gum are Southern gum, Sycamore gum, Bilsted, and Star-leafed gum. Cotton gum, or Tupelo, of Louisiana, is from the tree *Nyssa aquatica*. It is also known as Water tupelo, Tupelo gum, Swamp gum, Sour gum. Black gum, or Black tupelo, also of the Southern states, is *N. sylvatica*. Swamp tupelo, also called Water gum and Swamp black gum, is from the tree *N. biflora*. Ogeche tupelo is from the tree *N. ogecha*, and is not common. It is also called Gopher plum, Wild limetree, and Sour tupelo. Black tupelo grows from New Hampshire to central Texas, but water tupelo is found chiefly along the coasts and river valleys of the South. The shipments of woods are usually mixed. Tupelo woods from the various species of *Nyssa* are fine-textured but with large pores. The heartwood is brownish gray and the sapwood is grayish white. They are tough and difficult to split, having an interlocking grain, and find wide use for such articles as mallets, toilet seats, furniture, and bottle cases.

**Gum arabic.** Also called Acacia gum. The gum exudation of the small tree *Acacia arabica*, and various other species of acacia trees of

Africa. The chief area of cultivation is in the Egyptian Sudan. Kordofan gum, or Hashab gum, is a variety from the Red Sea area and forms the chief export of the Sudan. It is obtained by tapping the wild tree *A. vereke*, and is of high quality. Sennaar gum is gum arabic exported from Arabian ports on the Red Sea. Gum senegal, from the *A. senegal*, comes from the dry regions of French West Africa. Gum talha, Talco gum, or Talh gum, is a brittle and low grade of gum arabic from the North African acacia, *A. stenocarpa*. Gum arabic is used for adhesives, for thickening inks, as a binding and filling material for textiles, as a suspending medium in medicines, and for thickening rubber latex. It was the most ancient of adhesives. The trees are wounded and the sap allowed to run out, forming in yellowish, transparent lumps. It is soluble in water, but insoluble in alcohol. It is also marketed as a white powder of 120 mesh. For drug use the crude gum is selected, blended, and ground to powder of uniform characteristics. Various nontoxic emulsifiers are used as substitutes for gum arabic in pharmaceuticals and cosmetics, and also in food products to improve smoothness. Bemul, of the Beacon Co., used as a substitute, is a glyceryl monostearate. It is a white solid in bead form melting at 58°C, soluble in hot water and in alcohol, and edible. The Satinwood of the Near East, valued since ancient times for its great durability, is the wood of the gum arabic tree. It is light in weight, hard, close-grained, and has an orange-brown color that darkens with age. The satinwood from Brazil, however, is a yellow wood from the large tree *Aspidosperma eburneum*, used to replace boxwood and for inlays. It is called Setim.

**Gumwood.** The wood of several species of Eucalyptus trees native to Australia and Tasmania, but now grown in many parts of the world. The wood is used in construction and for inferior furniture. There is a large production of eucalyptus lumber in Peru for railroad and mining timbers. The wood known as gum in Southern United States is from the tupelo and species of *Liquidambar*. The Blue gum is *Eucalyptus globulus*, which attains a height of 300 ft and is grown on the West Coast of the United States. The wood has a pale straw color and is hard and tough. It has a twisted grain, shrinks and warps easily, but is very durable. The weight is about 50 lb per cu ft, being heavier than southern gum. Salmon gum, from *E. salmono-*

*phloria*, has a salmon-red color, is dense and hard, and has a fine, open grain. It is superior and has a great variety of uses. The weight is about 60 lb per cu ft. Red gum, from *E. calophylla*, has a yellowish-red color, is strong, tough, and weighs about 45 lb per cu ft. The grain is fine, but has gum veins intersecting. Other species of gumwood are marketed under the names of York gum, Blackbutt, Tuart, and Australian red mahogany. Jarrah, from the *E. marginata*, and Ironbark, from the *E. paniculata*, are hardwoods commonly used for flooring and cabinetwork. They have a reddish color, an interlocking grain, are very hard, and weigh about 55 lb per cu ft. Karri, from *E. diversicolor*, is quite similar to jarrah. The Wandoo tree, *E. redunca*, of Western Australia, the wood of which is known as Redunca wood, has a high percentage of pyrogallol tannin. The solid extract is called Myrtan, and it produces a solid, firm sole leather lighter in color than that from chestnut.

Eucalyptus trees are believed in some countries to aid in eradicating malaria, and eucalyptus wood is burned by some to cure colds from the smoke. Eucalyptus oil, obtained from the dried leaves of the *E. globulus*, is used in pharmaceutical preparations for nose and throat treatment. It is the source of Cineole also called Eucalyptole. From 3 to 4% oil is obtained from the leaves. It is a pungent yellowish oil. This type of eucalyptus oil contains Phellandrine used in Australia as an antiknock agent in gasoline. Eucalyptus dives oil, from the leaves of the Australian tree *E. dives*, contains 92 to 94% Piperitone, and is used in the manufacture of menthol. The yield is about 50% Levo menthol with a melting point of 33 to 35°C. It lacks the odor of USP menthol of which only 15% can be produced from this oil. Much eucalyptus oil is produced in Chile. More than 300 species of eucalyptus trees are known, and each produces a different oil.

✓ **Gunmetal.** The common name for a casting bronze containing on an average 88% copper, 10 tin, and 2 zinc. It casts and machines well, and is suitable for making steam and hydraulic castings, valves, and gears. It has a tensile strength of 32,000 to 45,000 psi, elongation 15 to 30%, with reduction of area 12 to 25%. The specific gravity is 8.7, weight 0.315 lb per cu in., Brinell hardness 65 to 74. This alloy is the same as the G bronze of the U.S. Navy. In England

it is called Admiralty gunmetal, and is specified as BES No. 383 for sand castings. Gunmetal ingot, marketed by H. Kramer & Co., may have the zinc replaced by 2% lead. Such an alloy is easier to machine but has less strength. Modified gunmetal contains lead in addition to the zinc. It is used for gears and for bearings. A typical modified gunmetal by William H. Barr, Inc., contains 86% copper, 9.5 tin, 2.5 lead, and 2 zinc. It has a tensile strength up to 40,000 psi, elongation 15 to 25%, Brinell hardness 63 to 72, and weight 0.31 lb per cu in. Federal specifications for Leaded gunmetal call for up to 1% lead and 1 nickel.

**Gunpowder.** Also known as Black powder. An explosive extensively used for blasting purposes and for fireworks. It was introduced into Europe prior to 1250, and was the only propellant used in guns until 1870. It is now superseded for military uses by high explosives. Black powder also has the disadvantage of deteriorating in the air or moisture. Gunpowder is a mechanical mixture of potassium nitrate, charcoal, and sulphur, in the proportions of 75, 15, and 10. More saltpeter increases the rate of burning; additional charcoal decreases the rate. A slow-burning powder for fireworks rockets may have only 54% saltpeter and 32 charcoal. Commercial black powder comes in grains of graded sizes and is glazed with graphite. The grain sizes are known as pebble powder, large-grain, fine-grain, sporting powder, mining powder, Spanish spherical powder, and cocoa powder. The potential energy of gunpowder is estimated at 500 ft-tons per lb, but the actual gun efficiency is less than 10% of this. A temperature of about 2100°C is produced by the explosion. Gunpowder is the slowest acting of all the explosives, and has a heaving, not a shattering effect. Hence, it is effective for blasting and breaking up stone. Blasting powder is divided by du Pont into two grades: A and B. The A powder contains saltpeter; the B powder contains nitrate of soda. The other ingredients are the usual sulphur and charcoal. B powder is not so strong or water-resistant as A powder, but is cheaper and is extensively used. Pellet powder is blasting powder made up in cylindrical cartridges for easier use in mining. White gunpowder is a powder in which the saltpeter is replaced by potassium chlorate. It is very sensitive and explodes with violence. It is used only for percussion caps and for fireworks.

**Gurjun balsam.** Also known as Wood oil, and sometimes called East Indian copaiba. An oleoresin obtained from various species of the *Dipterocarpus* tree, about 50 varieties of which grow in India, Burma, Ceylon, and the Malay Peninsula. It is a clear liquid with a greenish fluorescence. The specific gravity is 0.955 to 0.965. It is soluble in benzene. Gurjun balsam is used in lacquers and varnishes that are capable of resisting elevated temperatures. The Burmese trees form two groups yielding products known as Kanyin and In. Kanyin oils are brown in color, while the In oils are whitish and heavier. Gurjun balsam may consist of either or both of these products. Commercial Gurjun oil is obtained by steam distillation of the balsam, and has a specific gravity of 0.900 to 0.930. It is soluble in alcohol. Copaiba balsam is a resin obtained from the *Copaifera* tree, a species of *Dipterocarpus*, of South America. Maracaibo copaiba and Para copaiba are the principal varieties. They are dark yellow or brown in color, and are soluble in alcohol. The resin is used as a plasticizer, in varnishes, tracing paper, and in pharmacy. The specific gravity is 0.940 to 0.990.

**Gutta percha.** A gum obtained by boiling the sap of species of trees of the order *Sapotaceae*, chiefly *Palaquium gutta* and *P. oblongifolia*, native to Borneo, New Guinea, and Malaya. It is grayish white, very pliable, but not elastic like rubber. It is harder and a better insulator than rubber. Gutta percha, like rubber, will vulcanize with sulphur and form a hard material. It is used for mixing with rubber, but its chief use is in the covering of electric cables. It has a greater pliability than rubber for the given hardness required in cable insulation. This property with its greater resistance to water makes it valuable for golf balls and dental fillings. It molds easily at 180°F. It is also employed like balata for impregnating driving belts, and for washers and valve seats, and in adhesives. Gutta percha is often imported as mixtures with inferior guttas from other trees. Gutta soh, for example, is a mixture from Singapore often colored red artificially. Gutta siak is a low-grade gutta from Sumatra. It has a reddish color, and is slightly elastic. Gutta sundik is from the tree *Payena leerii* of Malaya and the East Indies. It is white in color, and is mixed with gutta percha. Another gutta used to adulterate gutta percha is Gutta hangkang, from the *Palaquium leiocarpum* of Borneo. It is slightly

reddish. Gutta jangkar is a low-grade red gutta from Sarawak. Gutta susu of the East Indies is a gray-colored material slightly elastic.

**Gypsum.** A widely distributed mineral which is a hydrated Calcium sulphate,  $\text{CaSO}_4 \cdot 2\text{H}_2\text{O}$ , used for making building plaster, wall-board, tiles, as an absorbent for chemicals, as a paint pigment and extender, and for coating papers. In Germany it was used for producing sulphuric acid. The ground mineral is used for fertilizer. Raw gypsum is also used to mix with portland cement to retard the set. Compact massive types of the mineral are used as building stones. The color is naturally white, but may be colored by impurities to gray, brown, or red. The specific gravity is 2.28 to 2.33, and the hardness 1.5 to 2. It dehydrates when heated to about  $190^\circ\text{C}$ , forming the hemihydrate  $2\text{CaSO}_4 \cdot \text{H}_2\text{O}$ , which is the basis of most gypsum plasters. It is called Calcined gypsum, or when used for making ornaments or casts is called Plaster of paris. When mixed with water, it again forms the hydrated sulphate that will solidify and set firmly owing to interlocking crystallization. Theoretically, 18% of water is needed for mixing, but actually more is necessary. Insufficient water causes cracking. Water solutions of synthetic resins are mixed with gypsum for casting strong waterproof articles. Palestic, of the Palestic Corp., is gypsum mixed with a urea-formaldehyde resin and a catalyst. It expands slightly on hardening, and thus gives a good impression of the mold. Tensile strength of the molded material is 1,100 psi, and compressive strength is 12,000 psi.

Calcium sulphate without any water of crystallization is used for paper filler under the name of Pearl filler. It is not as white as the hydrated calcium sulphate, which, when used for fine writing papers, is called Crown filler. The paint pigment known as Satin spar is calcium sulphate finely ground and having a satiny luster. It is distinct from the pigment called Satin white, which is made by the precipitation of aluminum sulphate with lime and contains calcium sulphate, aluminum hydroxide, and some lime. Terra alba is an old name for ground gypsum as a paint filler. The anhydrous calcium sulphate in powder and granular forms will absorb 12 to 14% of its weight of water, and is used as a drying agent for gases and chemicals. It can then be regenerated for reuse by heating. Drierite, of the W. A. Hammond Drierite Co., is this material. Much calcined gypsum, or plaster of



paris, is used as Gypsum plaster for wall finish. For such use it may be mixed in lime water or glue water, and with sand. Because of its solubility in water it cannot be used for outside work. Neat plaster, for walls, is the plaster without sand. When the term Plaster alone is used, it generally refers to gypsum plasters, but the Calcium plaster made from spent fuller's earth has greater workability and better water resistance than gypsum plaster.

Plaster board, or Gypsum wallboard, consists of sheets or slabs of gypsum mixed with up to 15% of fibers, employed as a fire-resistant material for walls, ceilings, or partitions, but gypsum board is also made with a layer of gypsum plaster between two sheets of absorbent, fibrous paper. Standard specifications for gypsum boards call for thicknesses of  $\frac{1}{4}$ ,  $\frac{5}{16}$ ,  $\frac{3}{8}$ , and  $\frac{1}{2}$  in., with usual surface dimensions of 24 by 32 in. The weight of gypsum board  $\frac{1}{4}$  in. thick is 1.2 lb per sq ft. Macoustic, of the National Gypsum Co., is a lightweight gypsum acoustical plaster. Grain board is a fireproof gypsum board with an imitation wood-grain surface used for walls. The hard-finish plasters for Flooring plaster may contain alum or other materials. Scott's cement is a plaster made by grinding lime with calcined gypsum. It sets rapidly. Mack's cement is a hard cement made of dehydrated gypsum to which is added a small percentage of calcined sodium sulphate and potassium sulphate. It sets quickly and has good adhesion. It is used for walls, and for floors when mixed with sand.

Patterns, models, and molds of plaster of paris have their strength raised and are made water-resistant by impregnating the dried and hardened plaster with a synthetic resin, particularly the furane resins which cure at low temperatures without pressure. The ordinary casting plaster of 100 parts solids and 60 parts water, called Hydrocal, is slightly acid, and must be treated with an acid-catalyzing resin, while the low-expansion plaster of 100 parts solids and 45 water, called Hydrostone, is alkaline and is treated with alkaline-catalyzed resin. Impregnation of plaster-of-paris castings with resin raises the compressive strength from 2,000 up to 9,000 psi, and the flexural strength from 700 to 3,500 psi. Special liquid resins are marketed for this purpose. The Plaspreg of the Furane Plastics & Chemicals Co. is a furane solution to which a catalyst is added before use. Dry plaster castings absorb the resin in a short immersion, and are cured in an oven at 160°F.

A crystalline variety of gypsum, known as Selenite, occurs in transparent crystals and usually splits in thin laminations. A fine-grained, marblelike variety, called Alabaster, is employed in ornamental building work, and for lamps, vases, and novelties. Much alabaster is produced in Colorado. Travertine, which resembles alabaster but is grained like wood, is a water-deposited calcium carbonate. The Italian travertine is notable as a decorative building stone, but is also found in Georgia, Montana, and California. It is an ancient building material, and the great Coliseum at Rome was built of this stone.

**Hafnium.** An elementary metal, symbol Hf. It is present in the earth in about the same amount as copper, but has little commercial application. The atomic weight is 178.6. All zirconium minerals contain several per cent of hafnium, but it is so similar chemically and so difficult to separate the two metals that all zirconium chemicals and alloys may contain some of it. The hafnium metal marketed by the Union Carbide & Carbon Corp. in pound quantities contains about 2% zirconium and not more than 0.2% other impurities.

**Hair.** The fibrous covering of the skins of various animals, used for making coarse fabrics and for stuffing purposes. It is distinguished from wool in having no epidermal scales. It cannot be spun readily, although certain hairs, such as camel hair, are noted for great softness and can be made into fine fabrics. Horsehair is from the manes and tails, and is used as a brush fiber and for making haircloth. It is largely imported from China and Argentina, cleaned and sorted. The imported hair from live animals is more resilient than domestic hair from dead animals. Brush hair is usually cut 3 to 5½ in. long, but tail hair for making Curled hair for weaving comes in lengths up to 30 in. Cattle hair is taken from slaughtered animals in packing plants. The body hair is used as a binder in plaster and cements, for hair felt, and for stuffing. The tail hair is used for upholstery, filter cloth, and stuffing. The Ear hair is used for brushes.

Artificial horsehair, or Monofil, is a single-filament cellulose-acetate fiber. It is used for braids, laces, hair nets, rugs, and pile fabrics. Crinex is a German artificial horsehair made of cuproammonium filament and used as a brush fiber. Haircloth is a stiff, wiry fabric with a cotton or linen warp and a filling of horsehair. It is elastic and firm,

and is used as a stiffening and interlining material. The colors are black, gray, and white. The fabric is difficult to weave and disintegrates easily, as the hairs cannot be made into a single strand and must be woven separately. Press cloth, used for filtering oils, is made from human hair, which has high tensile strength, resiliency, and resistance to heat. The hair comes from China, usually 6 in. long. Camel hair is sometimes substituted for this use, or synthetic resin filaments are used. Rabbit hair from Europe and Australia is used for making felt hats and is referred to as Rabbit fur, although it does not felt like wool. The white rabbit hair known as Angora wool is from the Angora rabbit of France and Belgium, called Belgian hare. The hairs are clipped or plucked four times a year when they are up to 3 in. long. They are soft and lustrous, dye easily to delicate shades, and are used for baby caps and soft wearing apparel. Because of its fluffiness and hairy characteristics, the wool is difficult to spin, and is usually employed in mixtures.

**Heat insulators.** Materials employed for retarding the passage of heat. All substances offer some resistance to the passage of heat, but the term refers to materials having high resistance to heat rays, or low conductivity. Heat insulators may be such materials as felt, fiberboard, cork, or mineral wool, used for insulating partitions in buildings, and their efficiency may partly depend upon dead-air spaces or cellular construction. High-heat insulators, for insulating boilers or furnaces, may be highly refractory substances such as chromite, magnesia, fireclay, or asbestos. Hot pipe lines are usually insulated with 85% magnesia block and asbestos cement. Cold lines usually have a hair-felt covering finished with asbestos cement or asphalted felt.

Metals that are good conductors of heat can be good heat insulators if they have a bright surface to reflect back the radiant heat waves, which are normally about 95% of the total heat loss. These are called Reflective insulators. Aluminum foil is used in this way as a wall insulator. Ferro-Therm, of the American Flange & Mfg. Co., Inc., is a steel sheet, 0.006 in. thick, coated with a white-metal alloy, used for house and refrigerator insulation. Ludlite board, of the Allegheny Ludlum Steel Co., is a panel having thin stainless steel backed with a fireproof composition of cement, magnesite, and asbestos fibers.

Asbestos sheathing, felt pads, and special fiberboards are often marketed under trade names. Roofinsul is a lightweight insulation board composed of wood fibers compressed into board form, marketed by Johns-Manville for roof decks. Ceilinite, of the same company, is an asbestos felt reinforced on one side with asbestos cloth, made in thicknesses from  $\frac{3}{32}$  to  $\frac{1}{4}$  in. and used for interlining in steel cars and for fireproofing electrical switch boxes. Insulite is a wood-fiber insulation board of the Insulite Co. Isotela is a French insulation for cold-storage walls consisting of pads of matted coir. Dry-Zero, of the Dry-Zero Co., consists of carded kapok batts encased in fiberboard for use in refrigerated cabinets. Balsam wool, of the Wood Conversion Co., is an insulating material consisting of wood fibers chemically treated and cemented together into fleecy wool form.

A lightweight cellular glass for use as an insulator in cold-storage chambers to replace cork, magnesia, or diatomite, is Foamglas of the Pittsburgh-Corning Corp. It is a glass expanded or cellulated by the evolution of gas while in a molten condition. It is a mass of tiny sealed air chambers, about 3,000 per cu in., and has low heat conductivity, 45 Btu per hr per sq ft per deg F per in. The strength and rigidity are greater than that of cork, and it will withstand temperatures up to 1000°F. The crushing strength of the blocks is 150 psi. Alumino-Hi Temp, of the Philip Carey Co., is alumina reinforced with asbestos fibers, made in the form of blocks and bricks. Fibrox is a patented soft fibrous material used as a heat-insulating filler. It is a Silicon oxycarbide, SiCO, prepared by diffusing carbon monoxide and carbon dioxide through molten silicon. The fibers are light and fluffy.

**Heat-resistant alloys.** Nickel-chromium-iron alloys containing usually from 5 to 80% nickel, 13 to 25 chromium, and the balance iron, which will not scale when exposed to high temperatures. Some of the alloys may contain only nickel and chromium, but more frequently all three metals are used, and some of the alloys may also contain aluminum, silicon, or other elements. They are used for heat-treating boxes, furnace parts, and machine parts exposed to high heats. The alloys will also resist oxidation and the action of many acids, and are used for chemical equipment. The resistance alloys for electric heaters are also heat-resistant, and some of the stainless steels and other high

alloys are oxidation-resistant and will retain good strength at high temperatures. But when the term is used alone, it usually refers to alloys primarily intended to resist oxidation at very high heats.

Cromax, of the Driver-Harris Co., contains 35% nickel, 15 chromium, and the balance iron. It has a tensile strength of 60,000 psi. It is used for temperatures up to 1900°F. Veriloy, of the same company, is a grade of nickel-chromium alloy for medium temperatures. Nichrome, of this company, is the trade name of a group of alloys for various uses. The standard grade for castings contains 67% nickel, 16 chromium, 12 iron, and 1 manganese. It has a tensile strength of 64,000 psi at 20°C and of 30,000 psi at 800°C, and will resist oxidation up to 1800°F for long periods. Such an alloy is tough but will machine readily. Q-Alloy, of the General Alloys Co., is the name of a large group of nickel-chromium-iron heat-resistant and chemical-resistant alloys of various grades. X-ite, of this company, contains 37 to 39% nickel and 17 to 19 chromium, and is used for carburizing boxes. Duraloy A, of the Duraloy Co., is a chromium-iron alloy with 27 to 30% chromium, used for hot-oil resistant castings. Calite, of the Calorizing Co., is the name of a series of high-chromium and high-nickel alloys. The alloy known as Nimonic 75, used in combustion chambers of early jet engines, was an 80–20 nickel-chromium alloy intended to withstand temperatures of 750°C. Nimonic 80, with better creep resistance, was this alloy modified with aluminum. Haynes 25 alloy, of the Haynes Stellite Co., is a wrought metal in sheet form for gas turbine parts. It can be deep-drawn or spun, and the alloy will retain its strength up to 1800°F and resist oxidation to higher temperatures. It contains 50% cobalt with the balance chromium, nickel, and tungsten.

Hoskins alloy 502, of the Hoskins Mfg. Co., has 35% nickel, 18.5 chromium, and the balance iron. It is recommended for continuous temperatures above 1400°F. This material also comes in the form of cast welding rods. Utaloy, of the A. F. Holden Co., used for pots for heat-treating salts, contains 35% nickel, 12 chromium, 0.20 max carbon, and the balance iron. It gives long life at heats to 1550°F. Accoloy is the trade name of the Alloy Casting Co. for a series of heat-resistant and corrosion-resistant alloys varying from the 18–8 stainless steel to an alloy with 68% nickel and 18 chromium. Some of the grades contain selenium to give machinability, columbium or

titanium for carbide stabilization, or molybdenum for hot oil resistance.

Amsco alloy is a series of nickel-chromium and nickel-chromium-iron alloys of the American Manganese Steel Co. Mackenite metal is a similar series of the Duncan Mackenzie Sons Co. Cyclops No. 17, of the Cyclops Steel Co., contains 20% nickel, 8 chromium, 0.75 manganese, 1.5 silicon, and 0.45 carbon. At a temperature of 1200°F it has a tensile strength of 75,000 psi. For high load-carrying ability at high temperatures as much as 30% chromium is used. Lebanon No. 48 contains 30% chromium, 30 nickel, 0.40 carbon, and the balance iron. Allegheny 55, of the Allegheny Ludlum Steel Corp., has 23 to 30% chromium, 1 manganese, and 0.25 carbon. Castings have a tensile strength of 80,000 psi. Nichroloy, of the Walker Metal Products, Ltd., contains 23% nickel, 20 chromium, 1 manganese, 1 vanadium, and 0.50 aluminum. It will withstand continuous temperatures up to 2000°F. Zorite, of the Michigan Products Corp., contains 35% nickel, 15 chromium, 1.75 manganese, and 0.50 carbon. The alloys with manganese have low coefficients of expansion.

Firearmor is the name of the Michigan Products Corp. for heat-resistant alloys. A typical grade contains 60% nickel, 20 chromium, 1.75 manganese, and 0.50 carbon. Fahr alloy, of the Southern Manganese Steel Co., is the name of chromium-nickel-iron alloys in various grades to withstand temperatures up to 2200°F. Fahrte, of the Ohio Steel Foundry Co., and Hybnickel, of the Pusey & Jones Corp., are heat-resistant alloys in various grades. A heat-resisting alloy containing silicon is PyraSteel, of the Chicago Steel Foundry Co. It has 25% nickel, 14 chromium, and 2.5 to 3 silicon, and will withstand temperatures up to 2000°F. Acipco steel, of the American Cast Iron Pipe Co., is a series of high-alloy heat-resistant steels cast centrifugally into 16-ft tubes of standard sizes for chemical plants. K42B alloy, of the Westinghouse Electric Corp., is a chromium-nickel cobalt alloy with high strength and creep resistance at high temperatures. At red heat, 1350°F, it is stronger than ordinary carbon steel at normal room temperature. The Discaloy of this company, designed for aviation gas turbine blades but also used for hot-extrusion dies and springs requiring heat resistance, contains 26% nickel, 13.5 chromium, 3.2 molybdenum, 1.6 titanium, 0.8 silicon, 0.7 man-

ganese, 0.1 aluminum, 0.03 carbon, and the balance iron. The alloy is austenitic, with a tensile strength of 145,000 psi and elongation of 20% at a hardness of 290 Brinell. At a temperature of 1200°F the tensile strength is 100,000 psi.

Chromium-silicon steels of higher chromium and silicon contents are in the class of heat-resistant alloys, and are used for valves for internal-combustion engines. Delhi A, produced by the Associated Alloy Steel Co., Inc., contains 17 to 19% chromium, 0.75 silicon, and 0.1 carbon. Delhi hard contains higher carbon, up to 1.1%. Silcrome RA, of the Allegheny Ludlum Steel Corp., has 16% chromium, 1 silicon, 1 copper, and 0.12 carbon. It is corrosion-resistant, ductile, and has a tensile strength up to 110,000 psi, and elongation 25%. Delhi rustless iron, of this company, contains 18% chromium, 1.5 silicon, and 0.08 carbon. It will withstand temperatures to 1600°F without scaling, and has a tensile strength up to 110,000 psi. Elcomet, of the La Bour Co., Inc., is a chromium-nickel-silicon-iron alloy for valves. Tungsten and aluminum iron heat-resisting alloys are also used for engine valves. Clebrium was an old alloy containing 13% chromium, 3.5 molybdenum, 2 nickel, 1.5 silicon, and 0.75 manganese. Chromized steel is steel that has been surface-alloyed with chromium by diffusion. The steel is packed with a ferrochrome-kaolin powder to which an iodine salt is added. When subjected to a temperature of about 2000°F in a retort, a chromous iodide is formed which reacts with the steel, producing an alloyed surface containing 40% chromium. The surface is very corrosion-resistant at high temperatures, and is also abrasion-resistant. A chromous surface can also be made on steel by immersion in a fused bath of chromous chloride.

**Heavy alloy.** A name applied to Tungsten-nickel alloy produced by pressing and sintering the metallic powders. It is used for screens for X-ray tubes and radioactivity units, for contact surfaces for circuit breakers, and for balances for high-speed machinery. The original composition was 90% tungsten and 10 nickel, but a proportion of copper is used to give a lower sintering temperature and to give better binding as the copper wets the tungsten. Too large a proportion of copper makes the product porous. An alloy of 90% tungsten, 7.5 nickel, and 2.5 copper has a tensile strength of 90,000 psi, elonga-

tion 4%, Brinell hardness 250 to 290, and specific gravity 16.3 to 17. It is resistant to corrosion, and can be machined. Hevimet, of the General Electric Co., is a heavy metal of tungsten, copper, and nickel, weighing 50% more than lead and as strong as a high-grade steel, about 100,000 psi. It is used as a gamma ray absorber, and also for balances. Mallory 1000 metal, of P. R. Mallory & Co., Inc., is a similar heavy alloy made by powder metallurgy. It has a specific gravity of 16.8, and an electrical conductivity about 15% that of copper.

**Helium.** A colorless, odorless, elementary gas of extreme lightness, symbol He. The specific gravity is 0.1368, and liquefying point  $-269^{\circ}\text{C}$ . The lifting power is only 92% that of hydrogen, but it is preferred for balloons because of its noninflammable character. It is also chemically inert. It is used for lighter-than-air aircraft and for weather-station balloons for radiosonde observations. It is employed in radio tubes and electric lamps because of its high heat conductivity, which is six times that of air. For use in advertising signs it gives a pinkish-violet light when an electric current is passed through it. It is also used to inflate the large tires of cargo planes, saving about 150 lb in weight of plane compared to air inflation. Helium of 99.8% purity is used for gas-shielding electric welding on magnesium alloys to prevent oxidation. In medicine it is used in the treatment of asthma and respiratory diseases. Helium can be obtained from atmospheric nitrogen, but comes chiefly from natural gas, the gas of Texas yielding 0.94%. It also occurs in the mineral Cleveite where it was first discovered in 1895. Helium is always associated with radioactive materials, and the alpha rays are helium nuclei. It has a valency of zero and forms no known compounds, but the atomic nucleus of helium is supposed to be a constituent of all other elements.

**Hemlock.** The wood of the coniferous tree *Tsuga mertensiana*, of Northeastern United States. This species is also called Mountain hemlock, and is now scarce. Eastern hemlock, *T. canadensis*, was formerly a tree common from eastern Canada to northern Alabama. In the southern area it is called Spruce pine, and in the northern area Hemlock spruce. The wood is coarse with an uneven texture, splintering easily. The trees are up to 80 ft in height and up to 3 ft in diameter. It is used for paper pulp, boxes and crates, and for inferior



lumber. Western hemlock, *T. heterophylla*, is a wood produced in abundance from Alaska to northern California. It is known also as West Coast hemlock, Hemlock spruce, Prince Albert fir, Gray fir, Alaskan pine, and Western hemlock fir. Trees 100 years old are about 20 in. in diameter and 140 ft high. The stand of the tree is estimated at more than 140 billion board feet in the United States, of which 85 billion is in Washington and Oregon. The wood is light in color, with a pinkish tinge, light in weight, moderately soft, and straight-grained. It is nonresinous and is free from resin ducts, but black knots are frequent. The select grades of the lumber are free from knots and suitable for natural and paint finishes. The wood is used for general construction, boxes, woodenware, and pulpwood. The lumber often comes mixed with Douglas fir. It is easy to work but does not plane smooth like pine. It has frequent dark streaks from heart rot, common in old trees. Hemlock-bark extract is obtained from the bark of the eastern hemlock, and is an important tanning material. Western hemlock bark is not in general use for tanning, but the bark contains 22% tannin.

**Hemp.** A fiber from the stalk of the plant *Cannabis sativa*, valued chiefly for cordage, sacking, packings, and as a fiber for plastic filler. In normal times it is grown principally in southern Russia, central Europe, the Mediterranean countries, and Asia, but during the war was extensively cultivated in the United States. The fiber, which is obtained by retting, is longer than that of the flax plant, up to 75 in., but is coarser and not suitable for fine fabrics, although the finest and whitest fibers are sorted out in Europe and used in linen fabrics. It is also more difficult to separate the fiber and to bleach. It is stronger, more glossy, and more durable than cotton, and has been used for toweling and coarse fabrics to replace the heavy linen fabrics. Hemp rope was once the chief marine cordage, but it has been replaced largely by rope of abaca which is lighter and more water-resistant. Hemp contains a toxic alkaloid, and in India the stalks are chewed for the narcotic effect. The dried flowering tops, known in medicine as *Cannabis*, are called Marijuana when smoked in cigarettes. The material is shipped from Arabia under the name of Hashish, and from India as Ganja. *Cannabis* is an exhilarator and painkiller, and is used in medicine as a depressive antidote, but in excess the drug causes

hallucinations. Synthetic cannabis, or Synhexyl, is a pyrahexyl more powerful in action than the natural material. Hempseed oil, used in paints and varnishes, is made by pressing the seeds of the hemp plant. It has a specific gravity of 0.926, iodine value of 148.

**Herring oil.** A fish oil obtained by extraction from several species of fish of the herring family, *Clupeidae*. The Sardine is the smaller fish of this family. The Norwegian herring, *Clupea harengus*, or Sea herring, is the sardine of Maine, eastern Canada, and the North Sea. In California and western Canada the sardine is a much larger fish, the Pilchard, *Sardinia coerulea*, usually about 8 in. long. The pilchard, or California sardine, constitutes about 25% of the entire fish catch of the United States by weight. The oil yield is about 30 gal per ton of fish, but much of the sardine oil is a by-product of the canning industry. Much of the fish oil of South Africa is from the pilchard, *C. sagax*. In France, Spain, and Portugal the European pilchard, *C. pilchardus*, and the *C. sardinus*, are used. The oil from the latter has a high iodine value. In Norway, the Sprat, *C. sprattus*, is also used. The Japanese herring is the *C. pallasii*. Herring oil, or Sardine oil, is employed as a quenching oil in heat-treating, either alone or mixed with other oils, in soaps, printing inks, lubricants, and for finishing leather. It is also fractionated to use in blends for paint oils. The oil contains a high percentage of palmitic acid and also linoleic and oleic acids. The specific gravity is 0.920 to 0.933, iodine value 130 to 180, and saponification value 179 to 194. Herring oil is made clear and odorless by hydrogenation.

**Hexamine.** A white, crystalline powder used chiefly for the manufacture of synthetic resins in place of formalin and its sodium-hydroxide catalyst. It is formed by the action of formaldehyde and ammonia. It is hexamethylenetetramine, having the formula  $(\text{CH}_2)_6\text{N}_4$ , melting at  $263^\circ\text{C}$ , and is very stable when dry. It is readily soluble in water and in alcohol. It is also known as Formin, Crystogen, Aminoform, and Cystamine. In pharmacy it is called Methenamine. In the presence of an acid it yields formaldehyde and is used in medicine as an internal antiseptic. It is also used as an accelerator for rubber. Condensite, a molding resin of the Continental-Diamond Fibre Co., is a reaction product of phenol and hexamine.

**Hickory.** The wood of the Shagbark hickory tree, *Carya ovata*, and other species of the walnut order. It is prized as a wood for ax, pick, and other tool handles, and also for wheel spokes, carriage shafts, and golf clubs. The color of the thick sapwood is white, and the heartwood is reddish brown. It has a fine, even, and straight grain, and is tough and elastic, having 30% greater strength than white oak and twice the shock resistance, although not as durable. The weight is 45 to 52 lb per cu ft. The chief producing states are Arkansas, Louisiana, Mississippi, Tennessee, and Kentucky, but the trees grow from New Hampshire to Texas. A mature shagbark tree 200 to 300 years old averages 100 ft high and over 2 ft in diameter. For handle manufacture the white wood and the red wood are considered equal in physical properties, and both possess the smooth feel required for handles. The average specific gravity when kiln-dried is 0.79, compressive strength perpendicular to the grain 3,100 psi, and shearing strength parallel to the grain 1,440 psi. There are more than 30 species of hickory, including the pecan trees. Besides the *C. ovata* three other species are important for the commercial wood: the Shellbark hickory, *C. laciniosa*, also called Kingnut; the Pignut hickory, *C. glabra*, also called Black hickory and Bitternut; and the Mockernut hickory, *C. alba*, also called Ballnut, Hognut, and White hickory. The kernels of the nuts of all species are edible, although some are bitter and astringent. The pecan hickories include the Pecan, *C. illinoensis*, the Water hickory, *C. aquatica*, and Nutmeg hickory, *C. myristicaeformis*. The pecan trees are cultivated widely in the Southern states for the nuts.

**Hides.** A commercial name generally signifying the skins of full-grown beef cattle. Kip skins and Calfskins are the names given to the hides of the younger animals. Calfskins, from animals that have not eaten grass, produce a softer leather than Cattle hides. Hides of other animals besides the beef cattle, *Bos taurus*, are usually designated with the name of the animal, as Horsehide. The hides of smaller animals are designated as Skins, either tanned or untanned, as Pigskin. Quantities of wild pigskins, known as Capivara skins, are imported from Colombia. Cattle hides are shipped in immense quantities from India, Argentina, Uruguay, and other pastoral countries, for making into leather. They are shipped either dried or salted,

and are distinguished by numerous grades, depending upon the class of animal, weight, method of skinning, and the preparation. Packing-house hides, well skinned, and packed in brine, are the best. The poorest grade is the country hides, taken off by inept knives and dried in the sun. The texture of the steer hides is more uniform than cow or bull hides, and the area is greater, permitting more economic cutting. Buffalo hides are from the domesticated Water buffalo of southern Asia and the Philippines. They are heavy, with a coarse grain, and are used to make a heavy, rough leather for buffing wheels and heavy boots, and also for Rawhide mallets and gears. Rawhide is a treated but untanned form of leather. About 45% of the cattle hides used in the United States go into sole leather, 43% into shoe uppers, and 4% into belting and luggage.

**High brass.** Sometimes called Common brass, and formerly known as Market brass. The most common of all the commercial wrought brasses. The usual mill standard is 65% copper and 35 zinc, and grades containing from 66 to 70% copper are referred to as Deep-drawing brass. High brass is marketed in sheets, rolls, and strips, and is used largely for drawing, forming, and spinning. In the hard tempers it is used for parts made by blanking, forming, and bending. It is a cold-working material and is not suitable for hot working. The 65-35 brass marketed by the American Brass Co. under the name of Yellow brass has a tensile strength of 45,000 psi and elongation 60% when soft, and a strength of 76,000 psi and elongation 5% when hard-rolled. The weight is 0.306 lb per cu in., melting point 930°C, and coefficient of expansion 0.0000106. Bar stock of high brass, for turned parts, called High-brass bar, invariably contains some lead, up to about 3%, as the unleaded brass is tough and the turned chips do not break easily.

The alloy listed in Federal specifications as Commercial brass for wrought shapes actually covers the brasses from muntz metal to high brass, and is leaded. It contains 60 to 65% copper, with lead permissible up to 3.75%. The government specifications for commercial brass for castings are equally broad. Butt brass, for hinges, has 64% copper, 35 zinc, and 1 lead. The term Etching brass refers to the temper rather than to the composition. It is a high brass sheet in quarter-hard or half-hard temper used for name plates and dials.

Bobbierre's metal is an old name for 63-37 high brass. This alloy is called in England Basis brass, and is BES No. 265. Bristol brass and Prince's metal are old names for high brass. Spring brass is usually a high brass with 66 to 72% copper rolled 8 numbers hard. The tensile strength, hard-rolled, is about 68,000 psi, and elongation 11%; spring wire may be 100,000 psi. SAE specifications require that a spring wire be capable of bending 180 deg around a wire of its own diameter without cracking. Spring bronze is usually a high brass with a small amount of tin to add hardness. Pin metal, for common pins, has 62% copper and 38 zinc, and is not annealed from the working. Shim stock is usually a soft high brass in thicknesses of 0.001 and 0.002 in. for shims and gaskets.

**High-lead bronze.** Bronze alloys containing high percentages of lead to give a soft matrix metal for bearing use, as distinct from bronzes containing small amounts of lead to make them free machining. The first high-lead bronze was invented in England in 1870 under the name of Dick's bronze, and was used on British railways. In 1892 C. B. Dudley in the United States produced ExB metal containing 77% copper, 15 lead, and 8 tin. It is still used as a car bearing metal and called Car brass. A common type of Leaded bronze used for bearings is the 80-10-10 mixture, and this alloy is also known as Ordnance bronze. It has a Brinell hardness of 58, a tensile strength of 30,000 psi, and when deoxidized with phosphorus has a dense structure. Lead does not alloy well with copper unless a catalyzer is present, the copper absorbing only about 3.5% lead. It also tends to sweat out at a temperature of 327°C. High-lead bronze is now invariably deoxidized with phosphorus, or contains small amounts of nickel, arsenic, or some other element to aid in holding up the lead.

The alloys containing tin are true bronzes, and are not as difficult to cast as the copper-lead alloys. Some lead bronzes also contain antimony, which gives them a good crystalline structure useful for bearings. They are easy to cast. Retz alloy and Reith alloy contained about 75% copper, 10 each of tin and lead, and 5 antimony. Cyprus bronze contained 65% copper, 30 lead, and 5 tin. Allen red metal is a copper-lead alloy with 50% lead and a small amount of sulphur to hold the lead in solution. Allen's metal was an early alloy con-

taining 40% lead, 55 copper, and 5 tin. Part of the lead was put in in the form of galena ore or lead sulphide. Johnson bronze No. 25, used for high-speed bearings, contains 75% copper, 19 lead, 5 tin, and 1 nickel. High-lead bronzes are resistant to acids and, when used for casting chemical machine parts, are called Anti-acid bronze. The name Lead bronze is used in England for an alloy of 75% copper, 1 to 2 tin, and the balance lead.

A typical leaded bronze is alloy No. 6, of William H. Barr, Inc. It contains an average of 78% copper, 8 tin, and 14 lead. The tensile strength is 28,000 to 32,000 psi, compressive strength up to 100,000 psi, and Brinell hardness 54 to 70. The weight is 0.335 lb per cu in. Johnson Alloy No. 29, of the Johnson Bronze Co., for electric-motor bearings, is the same as SAE 67, and contains 78% copper, 15 lead, and 7 tin. Lubrico, of the Buckeye Brass Mfg. Co., contains 75% copper, 20 lead, and 5 tin. Sabeco metal, of the Fredericksen Co., has 21% lead and 9 tin. Sumet bronze, of the Sumet Corp., is the trade name of a group of bearing bronzes in grades from the softest with 28% lead and Brinell hardness 30 to 33. to the hardest with 17.5% lead and hardness of 58 to 62 Brinell. Arctic bronze, of the National Bearing Metals Corp., is the name of leaded bearing bronzes chill-cast in metal molds to give fine grain structure. Bearium, of the Bearium Metals Corp., refers to a group of high-lead bronzes containing 17.5 to 28% lead and about 10 tin. The softest grade, with a hardness of 35 Brinell, has a compressive limit of 7,800 psi. Durbar bronze, of the Buffalo Die Casting Corp., has 24% lead and 4 tin. Durbar hard bronze has 10% tin and 20 lead. Monarch metal, of the Monarch Alloy Co., is a high-lead bearing bronze in various compositions. It is melted in sealed crucibles and water-cooled in pouring, resulting in a fine dispersion of the lead. Tri-Alloy, of the Ford Motor Co., is a high-lead alloy for crankshaft bearings for heavy loads and high speeds. It contains 35 to 40% lead, 4.5 to 5 silver, and the balance copper. The alloy is cast on strip steel and formed into bearings. Copper-lead alloys are now made also by sintering together copper powder and copperplated lead powder. They can thus be made in any proportion of lead.

**High-speed steel.** A general name for high-alloy steels which retain their hardness at very high temperatures and are used for metal-

cutting tools. They are now divided into three general classes. The tungsten steels form the oldest class and are an outgrowth of the older mushet steels. The Mushet steel, or Air-hardening steel, was invented in England in 1868. It contained 5 to 8% tungsten, 2.5 manganese, 1.5 silicon, and very high carbon. From 1893 to 1898 F. W. Taylor experimented with cutting tools made with a substitution of chromium for the high manganese and with less carbon, and the Taylor-White steel marketed in 1900 contained 8% tungsten, 1.8 chromium, 1.15 carbon, 0.18 manganese, and 0.25 silicon. In 1900 the Bethlehem Steel Co. brought out the tungsten-chromium-vanadium steel now known as the 18-4-1.

The property of red-hardness is described as the ability of the steel to retain the hard carbides up to a temperature of about 1750°F. The cobalt alloys that have this property but contain little or no iron are not classed as high-speed steel. The tungsten steels are divided into two general grades according to tungsten content, with 18 and 14% tungsten, respectively. The Super high-speed steels, or Cobalt steels, are high in tungsten but contain considerable quantities of cobalt. They have added red-hardness but are inclined to be brittle. The third class of Molybdenum high-speed steels are an outgrowth of an early attempt by the U.S. Ordnance Dept. to substitute molybdenum for the imported metal tungsten. The first molybdenum steel was the Mo. S. H., or Self-hardening steel, of the Sanderson Steel Co., marketed in 1898. The first Watertown Arsenal steel contained about 9.5% molybdenum, 4 chromium, 1.25 to 2 tungsten, 0.90 to 1.5 vanadium, 0.80 carbon, 0.20 to 0.40 manganese, and 0.25 to 0.50 silicon. Molybdenum has a more pronounced effect than tungsten in a ratio of 2:1, but it makes the steel more brittle and also makes it subject to decarburization. The standard tungsten steels are therefore sometimes modified with very small amounts of molybdenum. ML steel, of the Allegheny Ludlum Steel Co., has 18% tungsten, 4 chromium, 1.85 vanadium, and 0.50 molybdenum. It gives a keener edge than the standard 18% tungsten steel.

The standard for tungsten high-speed steels is the 18-4-1 containing 18% tungsten, 4 chromium, and 1 vanadium. This steel gives a balance of red-hardness, toughness, and cutting edge; in England preference is for the 14-4-2, which gives higher hardness and resistance to wear. Tungsten adds red-hardness to steel; chro-

mium gives deep hardening and increases toughness; and vanadium gives hardness and improves the ability to keep an edge. Cobalt gives added red-hardness, but the steels are more difficult to forge and are more brittle. Congo steel, of the Braeburn Alloy Steel Corp., used for tool bits and cutoff blades, and for cutting hard materials, contains 4% chromium, 4 tungsten, 5 molybdenum, 12 cobalt, 1.4 vanadium and 0.78 carbon.

High-speed steels are marketed in rods, bars, flats, and tool shapes. They are sold under many trade names, such as Supremus and Jessco, of the Jessop Steel Co.; Clarite, of the Columbia Tool Steel Co.; Rex, Champion, and Peerless, of the Crucible Steel Co.; Colonial, of the Colonial Steel Co.; Blue Chip, of the Firth-Sterling Steel Co.; Panther, of the Allegheny Ludlum Steel Co.; and Kutkwik, of Henry Disston & Sons, Inc. Electrite uranium was a special brand of Electrite steel of the Latrobe Electric Steel Co. containing some uranium, which is a more powerful deoxidizer and hardener than vanadium. Star-Zenith, of the Carpenter Steel Co., is an 18-4-1 steel with elements in slight excess of standards. Vasco Supreme steel, of the Vanadium-Alloys Steel Co., contains 5% vanadium instead of the usual 1%, with 5% cobalt, 4.75 chromium, 12.5 tungsten, 0.25 manganese, and 1.5 carbon. It has high hardness at red heat, and can be used at cutting speeds double those for standard 18-4-1 steel.

Motung steel, patented by the Cleveland Twist Drill Co., contains 7.5 to 8.5% molybdenum, 1.25 to 2 tungsten, 3.5 to 4.5 chromium, 0.90 to 1.5 vanadium, 0.65 to 0.85 carbon, 0.20 to 0.40 manganese, and 0.25 to 0.50 silicon. It weighs less than the 18-4-1 steel. The name Mo.-Tung is used by the Universal-Cyclops Steel Corp. for this steel. The lower carbon contents are tough, while those with higher carbon have great hardness. It forges and hardens at lower temperatures than 18-4-1 but must be carefully controlled in heat-treating to prevent decarburization. Other trade names for the steel when manufactured by other companies are Mogul, Tatmo, Mo-Cut, Vul-Mo, Mohican, LMW, Rex T-Mo, HM steel, and Di-mol. Van Lom steel, of the Vanadium-Alloys Steel Co., has 8.25 to 10% molybdenum, 3.75 to 4.75 chromium, 2 to 4.25 vanadium, and 0.75 to 1.2 carbon. Bethlehem 66 steel, of the Bethlehem Steel Co., is a low-tungsten steel that will heat-treat without decarburization. It contains 5 to 5.75% tungsten, 4.5 to 5.5 molybdenum, 3.75 to 4.25



chromium, 1.4 to 1.75 vanadium, and 0.80 carbon. Unicut steel, of the Universal-Cyclops Steel Corp., has 4% chromium, 6.25 molybdenum, 6.25 tungsten, 2.4 vanadium, and 1 carbon. It is a general-purpose high-speed steel.

Twin Mo steel is a 6-6-2 tungsten-molybdenum steel of H. Boker & Co., Inc. Speed star steel of the Carpenter Steel Co. contains 5.5% tungsten, 4.25 molybdenum, 4 chromium, 1.5 vanadium, and 0.80 carbon. If hardened in a reducing atmosphere, it will produce a fine-grained steel with a surface hardness of Rockwell 65. It is a general-use high-speed steel. Circle C steel, of the Firth-Sterling Steel Co., contains 9% cobalt, 18.5 tungsten, 1.75 vanadium, 1 molybdenum, and 0.77 carbon. Gray Cut Cobalt steel, of the Vanadium-Alloys Steel Co., has 20.5% tungsten, 4.25 chromium, 1.3 vanadium, 12.25 cobalt, 0.60 molybdenum, and 0.80 carbon. Red Cut Cobalt, of this company, and Co-Co steel, of the Colonial Steel Co., are 18-4-1 steels with the addition of 4.5% cobalt and a small amount of molybdenum. Imperial major, of A. Milne & Co., has 12 to 13% cobalt and 22 tungsten. It has high wear resistance when cutting at red heats. Maxite, of the Columbia Tool Steel Co., is an 18-4-1 type modified with 4% cobalt. D-6Co steel of Henry Disston & Sons, Inc., contains 19% tungsten, 6 cobalt, 2 vanadium, 4 chromium, and 0.80 carbon. It cuts hard steels at high speed, but is difficult to forge and requires care in heat-treatment to prevent decarburization. Rex AA steel, of the Crucible Steel Co., is an 18-4-1 steel, while Rex AAA is this steel with 5% cobalt and 0.50 molybdenum. Rex 95 contains 14% tungsten, 4 chromium, 2 vanadium, and 0.50 molybdenum.

Some of the molybdenum high-speed steels developed to conserve tungsten also contain cobalt. STM steel, of the Simonds Saw & Steel Co., contains 5.75 to 9.5% molybdenum, 1 to 1.5 tungsten, 3 to 8 cobalt, 3.5 to 3.75 chromium, 0.75 to 2 vanadium, and 0.80 to 1 carbon. CN-6 steel of this company contains 6% each of tungsten and molybdenum, 4 chromium, 1 vanadium, 0.50 copper, and 0.80 carbon. It is tough and fatigue-resistant and is used for saws, planer knives, and chisels. A steel containing no tungsten is Rex VM of the Crucible Steel Co. It contains 8% molybdenum, 4 chromium, 2 vanadium, and 0.85 carbon. It is used for drills, taps, hack saws, and milling cutters. Amotun steel, of the Atlantic Steel Co., used for

threading dies, taps, and countersinks, contains 0.85% carbon, 4 chromium, 6 cobalt, 1.75 vanadium, 1.5 tungsten, and 8 molybdenum. DBL steel, of the Allegheny Ludlum Steel Co., contains 0.80% carbon, 5.25 tungsten, 4 chromium, 4 molybdenum, and 1.5 vanadium. Milvan steel, of A. Milne & Co., has 19% tungsten, 4 chromium, and 2 vanadium.

**Holly.** The wood of the tree *Ilex aquifolium*, and several other species of *Ilex*, or holly tree, native to Europe, and the tree *I. opaca*, of southeastern United States. It is valued as a wood for inlaying because of its white color, its fine, close grain, and its ease of staining to imitate ebony. It is hard, and the weight is 47 lb per cu ft. It is also used for scientific and musical instruments, model boats, and sporting goods, and is sometimes called boxwood.

**Horn.** The excrescent growth, or horns, from the heads of certain animals, notably beef cattle. Horn is used for making handles and various articles. The quality depends largely upon the size and age of the animal from which it comes, the No. 1 grade being the large steer horns, and the No. 2 those below 40 lb per hundred. Horns occur on the head in pairs and are hollow, growing on a core of pithy bone. The horns are split by saws, soaked to make them flexible, and then flattened under pressure. Horn meal, made from the bone refuse, is sold largely as fertilizer. Horn pith, extracted by boiling the horns, is used for glue and for gelatin.

**Hot-die steels.** A general name for alloy steels that will resist shock and retain their hardness when operating in forging machines at high temperature. When used in hot-heading machines, they are also called Hot-work steels. Two types of these steels are commonly employed: one being a chromium steel with 3 to 4% chromium, or in another grade with about 8 to 10%; and the other type being a tungsten steel with 8 to 10% tungsten. The molybdenum high-speed steels are also used for hot-die work, or the standard tool steels may be modified with molybdenum. The chromium steels are oil-hardening and develop a high hardness. They are deep hardening but will withstand shock. The tungsten steels have higher impact value, and are superior for severe service at high heats such as for hot punching or for brass extrusion, but they are more expensive. The chromium

steels are used for dies for compressive action, as for header machines. The higher tungsten steels give full red-hardness, but they are not hard enough for cutting dies. Nickel and vanadium may also be added to hot-die steels, giving increased hardness and toughness. The self-hardening high-tungsten steels containing high manganese and carbon are not classed as hot-work steels.

Mohawk steel, of the Allegheny Ludlum Steel Co., is a hot-die steel with tungsten and chromium. It has 14% tungsten, 3.5 chromium, 0.70 vanadium, and 0.50 carbon. Atlas steel, of this company, contains 9 to 11% tungsten, 3.5 chromium, 0.45 vanadium, and 0.35 carbon. Hot-work steel B-47 of this company contains 4.25% each of chromium, cobalt, and tungsten, 2.25 vanadium, 0.40 molybdenum, 0.35 manganese, 0.25 silicon, and 0.40 carbon. At a temperature of 800°F it has a tensile strength of 178,000 psi with elongation 9%. It is used for extrusion and forging dies and hot punch tools. Crescent steel, of the Crucible Steel Co., has 3.75% chromium and 0.95 carbon. Peerless A, of this company, has 9% tungsten, 3.25 chromium, and 0.25 vanadium, and is used for die-casting dies, extrusion dies, and gripper dies. A Die-casting die steel especially suited for aluminum casting dies is Potomac M of the Allegheny Ludlum Steel Corp. It contains 5.25% chromium, 1.15 molybdenum, 1 vanadium, 1 silicon, and 0.40 carbon. It is hardened by air or oil quench and drawn to 440 to 490 Brinell. At a temperature of 1200°F it has a tensile strength of 118,000 psi with elongation 22%. C.Y.W. steel, of the Firth-Sterling Steel Co., has 3.5% chromium, 0.50 manganese, and 1 carbon. It is used for dies and tools for heavy pressures. D.Y.O. steel, of the Carpenter Steel Co., has 14.5% tungsten, 4 chromium, and 0.50 vanadium. Excelo, of this company, has 2.5% tungsten, 1.5 chromium, 0.35 vanadium, and 0.55 carbon. It is used for hot shears. T-K steel, of this company, used for tools that require high red-hardness and resistance to abrasion such as swaging dies, contains 9% tungsten, 3.5 chromium, 0.40 vanadium, 0.30 silicon, 0.30 manganese, and 0.35 carbon. Vasco Marvel steel, of the Vanadium Alloys Steel Co., has 9.25% tungsten, 3.5 chromium, and 0.45 vanadium. Vasco Extrude Die is a combination of the two types. It has 15.5% tungsten, 3 molybdenum, 4 chromium, and 2 nickel.

The hot-die steel, or die block steel, produced by the Heppenstall

Co. under the name of Hardtem, is a nickel-chromium steel with molybdenum and vanadium. Another die block steel of the same company is C55 steel. It is an oil-hardening steel containing 0.50% carbon, 0.75 chromium, 1.25 nickel, and 0.30 silicon. Hot-work 8 steel, of the Bethlehem Steel Co., contains 8.5% molybdenum and 1.5 vanadium. It is tough, shock-resistant, abrasion-resistant and resists heat checking. E.H.W. steel is a tungsten hot-work steel of the Latrobe Electric Steel Co. Peerless steel, of the Crucible Steel Co., is in several grades of tungsten-chromium-vanadium. Such steels as Tungo, of the Colonial Steel Co., and Par-Exc, of the Vanadium Alloys Steel Co., with lower tungsten and chromium and some vanadium, are not high heat-resistant but are suitable for die-casting dies. Because of their resistance to shock they are used for hot upsetting dies.

**Hydrochloric acid.** Also called Muriatic acid, and originally called Spirits of salt. An inorganic acid used for pickling and cleaning metal parts, production of glues and gelatin from bones, manufacture of chlorine, pharmaceuticals, dyes, pyrotechnics, and for tanning, etching, reclaiming rubber, and treating oils and fats. It is a water solution of Hydrogen chloride,  $\text{HCl}$ , and is a colorless or yellowish fuming liquid, with pungent, poisonous fumes. The specific gravity of the gas is 1.269, the solidifying point  $-112^{\circ}\text{C}$ , and boiling point  $-83^{\circ}\text{C}$ . It is made by the action of sulphuric acid on sodium chloride, or common salt. The commercial acid is usually  $20^{\circ}\text{Bé}$ , equaling 31.45%  $\text{HCl}$  gas, and has a specific gravity of 1.16. Other grades are 18 and  $22^{\circ}\text{Bé}$ . Fuming hydrochloric acid has a specific gravity of 1.194, and contains about 37% hydrogen chloride gas. Hydrochloric acid is shipped in glass carboys. Anhydrous hydrogen chloride gas is also marketed in steel cylinders under a pressure of 1,000 psi for use as a catalyst. The boiling point is  $85.03^{\circ}\text{C}$ . The acid known as Aqua regia, used for dissolving or testing gold and platinum, is a mixture of 3 parts hydrochloric acid and 1 nitric acid. It is a yellow liquid with suffocating fumes.

**Hydrocyanic acid.** Also called Prussic acid, Formonitrile, and Hydrogen cyanide. A colorless, highly poisonous gas of the composition  $\text{HCN}$ . The specific gravity is 0.697, liquefying point  $26^{\circ}\text{C}$ , and it is soluble in water and in alcohol. It is usually marketed in

water solutions of 2 to 10%, and is used as a disinfectant and fumigant, as a military poison gas, and in mining and metallurgy in the cyanide process. It is so poisonous that death may result within a few seconds after it is taken into the body. It was used as a poison by the Egyptians and Romans, who obtained it by crushing and moistening peach kernels. It is obtained by distilling a solution of potassium cyanide and sulphuric acid. The French war gas known as Vincennite was hydrocyanic acid mixed with stannic chloride. Manganite was a mixture with arsenic trichloride. HCN discoids, of the American Cyanamid Co., are cellulose disks impregnated with 98% hydrocyanic acid, used for fumigating closed warehouses.

**Hydrofluoric acid.** A water solution of Hydrogen fluoride, HF. It is a colorless, fuming liquid, highly corrosive and caustic. It dissolves most metals except gold and platinum, and also glass, stoneware, and organic material. The choking fumes are highly injurious. It is widely used in the chemical industry, for etching glass, and for cleaning metals. In cleaning iron castings it dissolves the sand from the castings. The specific gravity of the gas is 0.713, and liquefying point  $-19^{\circ}\text{C}$ . Hydrofluoric acid is made by treating calcium fluoride or fluor spar with sulphuric acid. It is marketed in solution strengths of 30, 52, 60, and 80%. The anhydrous material, HF, is used as an alkylation catalyst.

**Hydrogen.** A colorless and highly inflammable gaseous element, symbol H. It is used for the oxy-hydrogen flame for welding, and also to produce a nonoxidizing atmosphere for heat-treating steels. It is also employed for the hydrogenation of oils and for the production of ammonia. Oils and gasoline can be produced from coal by treatment with hydrogen. Hydrogen liquefies at  $-252^{\circ}\text{C}$ . The specific gravity is 0.0695. Its lightness makes it useful for filling balloons, but it is largely replaced for this purpose by the noncombustible helium gas except for emergency signal balloons. For this use the hydrogen is produced easily and quickly from lithium hydride. Hydrogen is a powerful fuel for such uses as rockets. When liquid hydrogen is used with liquid oxygen as the oxidizing agent, the jet nozzle gases have a speed of 15,000 mph. Hydrogen is produced commercially by the electrolytic dissociation of water, or 100% pure hydrogen may be produced by reacting propane with steam. The

element comprises about one-ninth of all water, and is found in all organic material. Double-weight hydrogen is called Deuterium, and Deuterium oxide is known as Heavy water. The formula is  $H_2O$ , but with the double-weight hydrogen the molecular weight is 20 instead of the 18 for ordinary water. Heavy water is used to slow down fast neutrons in atomic work. Triple-weight hydrogen, called Tritium, is made in the uranium reactor by bombarding lithium. It is a solid at very low temperatures, and is the material of the hydrogen bomb.

**Hydrogenated oils.** Vegetable or fish oils that have been hardened or solidified by the action of hydrogen in the presence of a catalyst. Partial hydrogenation also clarifies and makes odorless some oils. Finely divided nickel is generally used as the catalyst. The solidifying process is carried on to any desired extent, and these oils have a variety of uses. For mechanical uses they are employed in cutting oils, and in place of palm oil in tinplate manufacture. By hydrogenation the fatty acids, such as oleic acid, are converted into stearic acid. Peanut oil, coconut oil, and cottonseed oil can thus be made to have the appearance, taste, and odor of lard, or they can be made like tallow, though they do not have the food value of lard. Lard compound, previous to the passage of the Food and Drugs Act of 1906, was cottonseed oil mixed with oleostearin from beef tallow. It was later sold under trade names, but has now been replaced by hydrogenated oils under the general name of Shortenings, and under trade names. Hydrogenated oils have lower iodine values and higher melting points than the original oils.

**Indigo.** Once the most important of all vegetable dyestuffs and valued for the beauty and permanence of its color. Commercial blue indigo is obtained from the plants *Indigofera tinctoria*, and several other species, of India and Java, and the plant *Isatis tinctoria*, of Europe, by steeping the freshly cut plants in water, and after decomposition of the glucoside Indican,  $C_{14}H_{17}O_6N$ , the liquid is run into beating vats where the indigo separates out in flakes which are pressed into cakes. About 4 oz of indigo are produced from 100 lb of plants. Indigo red, or Indirubin,  $C_{16}H_{10}N_2O_2$ , is a crimson dyestuff obtained in the proportion of 1 to 5% in the manufacture of indigo. Indigo white is obtained by reducing agents and an alkali. Another product obtained in the manufacture of synthetic indigo is

**Indol**, a white crystalline product with melting point of 52°C. In concentrations it has a powerful disagreeable odor, but in extreme dilution has a pleasant floral odor and is used in many perfumes. It occurs naturally in oils of jasmin, neroli, orange blossom, and others.

**Indium.** A metallic element, symbol In, discovered first in zinc blende in 1863. It is more silvery-white than tin with a bluish luster, and is valued as a plating metal for jewelry and novelties because of its fine color and corrosion resistance. Although the plate is originally soft, a lustrous hard surface is produced by heating the article to diffuse the metal. Indium-plated light reflectors are highly efficient. Indium is softer than lead, malleable and ductile. It is not easily oxidized as a metal, but above its melting point it oxidizes easily and burns with a brilliant violet flame. The melting point is 155°C, specific gravity 7.31, and Brinell hardness 1. In spite of its softness small amounts of indium will harden copper and lead alloys and increase the tensile strength. It is used in aviation-engine bearing alloys. In solders it improves wetting and lowers the melting point. In gold and silver dental alloys it increases the hardness, strength, and smoothness. The metal usually remains alloyed with the zinc in the reduction of zinc from its ores. Indium oxide, an amorphous yellow powder of the composition  $\text{In}_2\text{O}_3$ , and specific gravity 7.179, is used to give a beautiful yellow color to glass. This color may be varied from light canary to dark tangerine orange. The monoxide,  $\text{InO}$ , is black, and is not stable. Lead-indium alloys are highly resistant to corrosion, and are useful for chemical-processing equipment. As little as 1% indium added to lead increases the Brinell hardness from 3.11 to 4.32, and nearly doubles the tensile strength. Silver-indium alloys are noted for high hardness without change in the color of the silver.

**Industrial jewels.** Hard stones, usually ruby and sapphire, used for bearings and impulse pins in instruments and for phonograph needles. Ring jewels are divided into large and small. The large rings are above 0.050 in. in diameter and 0.012 in. in thickness with holes above 0.006 in. in diameter. Ring jewels are used as pivot bearings in instruments, timepieces, and dial indicators. From 2 to 14 are used in a watch. Vee jewels are used in electrical instruments and in compasses. Cup jewels are used for electric meters and compasses.

End stones are flat undrilled stones with polished faces to serve as end bearings. Pallet stones are rectangular impulse stones for watch escapements. Jewel pins are cylindrical impulse stones for the escapement of a timepiece. In the production of bearing jewels the synthetic sapphire boules are split in half, secured to wooden blocks, and then sawed to square blanks. These are then rounded on special centerless grinding machines, and flat-ground to thickness by means of copper wheels with diamond powder. Quartz bearings are made from fused quartz rods. A notch is ground in the end of the rod, then polished and cut off, repeating the process for each bearing. Quartz has a hardness of only 7 Moh, while the synthetic ruby and sapphire have a hardness of 8.8, but quartz has the advantage of low thermal expansion.

**Ingot iron.** Nearly chemically pure iron made by the basic open-hearth process and highly refined, remaining in the furnace 1 to 4 hr longer than the ordinary time, and maintained at a temperature of 2900 to 3100°F. In England, it is referred to as Mild steel, but in the United States the line between iron and steel is placed arbitrarily at about 0.15% content of carbon. Ingot iron has as low as 0.02% carbon. It is obtainable regularly in grades 99.8 to 99.9% pure iron. Ingot iron is cast into ingots and then rolled into plates or shapes and bars. It is used for construction work where a ductile, rust-resistant metal is required, especially for tanks, boilers, enameled ware, and for galvanized culvert sheets. The tensile strength, hot-rolled, is 48,000 psi, elongation 30%, and Brinell hardness 82 to 100. Dead soft, the tensile strength is 38,500 psi, elongation 45%, and Brinell hardness 67. Armco ingot iron, of the American Rolling Mills Co., is 99.94% pure, with the carbon 0.013 and the manganese 0.017%. It is used as a rust-resistant construction material, for electromagnetic cores, and as a raw material in making special steels. The specific gravity is 7.858, and melting point 1530°C. Enamelite is a sheet iron especially suited for vitreous enameling, produced by the Sharon Steel Hoop Co. Ingot iron may also be obtained in grades containing 0.25 to 0.30% copper, which increases the corrosion resistance. Plastiron, of Henry Disston & Sons, Inc., is a very low-carbon iron used for molds and dies which are to be hobbled. The iron is quite plastic under the hob and is then hardened by carburizing.



**Ink.** Colored liquids or pastes used for writing, drawing, marking, and printing. Black writing inks usually contain tannogallate of iron which is obtained by adding an infusion of nutgalls to a solution of ferrous sulphate. Good Writing ink is a clear, filterable solution, not a suspension. It must flow easily from the pen without clogging, give a smooth, varnishlike coating, and it must adhere to inner fibers of the paper without penetrating through the paper. It must have an intense color that does not bleach out. Ink is essentially a pigment in a liquefying and adhesive medium, but the iron-gallotannate writing inks develop their full color by chemical action and become insoluble in the outer fibers of the paper. For the proper development of the black color in gallotannate inks a high percentage of iron is needed, and this requires a liberal use of acid which will tend to injure the paper. It is thus usually the practice to reduce the amount of iron and bring up the color with dyes or pigments. Gums or adhesive materials may also be added.

Carbon inks are composed of lampblack or carbon black in solutions of gums or glutenous materials. India ink is a heavy-bodied drawing ink. The original India ink, or Chinese ink, was made with a jet-black carbon pigment produced by burning tung oil with insufficient air. The pigment was imported into Europe in compressed sticks known as Indicum. India ink was originally only black ink, but the name is now used also for colored heavy drawing inks made with various mineral pigments. Marking inks are usually solutions of dyes that are fast to laundering, but they may also be made with silver salts which develop full color and stability by application of heat. Fountain-pen ink is not a special composition ink, but is a writing ink free of sediment and tendency to gum. An Encaustic ink is a special writing ink that will penetrate the fibers of the paper and set chemically to make erasure difficult, but an Indelible ink for textiles is a marking ink. Invisible-writing inks, or Sympathetic inks, are inks that remain invisible until the writing is brought out by the application of heat or with another chemical which develops the color. They are made with sal ammoniac or salts of metals.

Printing inks are in general made with carbon black, lampblack, or other pigments suspended in linseed oil and with an adhesive agent, but there are innumerable modifications of printing inks to meet different conditions of printing and varieties of surfaces. Vari-

ous types of oils may be used to dry by oxidation, polymerization, absorption, or solvent evaporation, and these may be modified with driers or tackifiers. Synthetic resins may be added to give gloss or hardness, or to increase the speed of drying. Printing inks are not normally purchased on composition specifications, but on ability to meet the requirements of the printing.

**Insecticides.** Chemical products, or natural products with definite chemical properties, used to kill or to control insects, particularly agricultural pests. Chemicals used against fungi are sometimes classed with insecticides; they are more properly Fungicides and are usually organic mercury compounds. Not more than 1% of the insecticides marketed in the United States are of this class. A Larvicide is a chemical, such as chloropicrin, used to destroy fungi and nematodes in soils, and eggs and organisms in warehouses. Insecticides are classed as Stomach poisons or as Contact poisons. Stomach poisons include Calcium arsenate, a white powder of the composition  $\text{Ca}_3(\text{AsO}_4)_2$ , which comprises more than half of all insecticides used, and also paris green, lead arsenate, and white arsenic. Contact poisons include rotenone dust, sulphur dust, and nicotine sulphate solutions.

More than 10% of all agricultural crops are lost annually from attacks of insects which, though they may not destroy the plant completely, reduce the yield. Of about 800,000 known species of insects, half feed directly on plant tissues, retarding growth of the plant and causing inferior crops. But indiscriminate spraying of insecticides over large areas may kill insects that are necessary for the life of birds and for the fertilization of flowers and crops. Some insecticides, especially those with active chlorine, may be injurious to some plants, causing abnormal growth, tumors, or other deformities. This type of insecticide, when used for destroying insects in libraries or archives, may yellow and deteriorate the papers and books. The production of insecticides is now one of the important branches of the chemical industry, and the use of insecticides is an art requiring much skill.

Insecticides may also be classed as solids and liquids. Among the solids are pyrethrum, rotenone, sodium fluoride, sodium arsenite, lead arsenate, boric acid, white arsenic, sodium arsenate, beta naphthol, and thallium sulphate. Sodium fluosilicate, a white, easily soluble powder of the composition  $\text{Na}_2\text{SiF}_6$ , is also used extensively. Usually

the poison is mixed with a mineral powder in the proportion of 2 to 5%. The mineral carrier should be gritless and inert to the insecticide. Dusting clay for this purpose is a light, fluffy, airfloated kaolin. For some dust sprays finely ground soft limestone is preferred. Liquids are kerosene or other petroleum hydrocarbons in combination with materials such as rotenone. Some essential oils such as citronella oil have limited use as insecticides but not for agricultural purposes. Bordeaux mixture is basic copper sulphate made by reacting copper sulphate with lime, resulting in a product with an excess of hydrated lime. It is used dry or in liquid sprays.

Dimethyl phthalate, a liquid of the composition  $C_6H_4(CO_2CH_3)_2$ , is a mosquito repellent with an effect lasting  $1\frac{1}{2}$  hr in the open air. Thiourea is used to kill mosquito larvae in water and is harmless to fish. Sabadilla is used in cotton sprays. It is also known as Cevadilla or Indian barley, and consists of the dried ripe poisonous seeds of the plant *Veratrum sabadilla* of the lily family growing in Central America, of which there are about 20 known species in Central and South America. The seeds contain Veratric acid from which is derived Veratraldehyde, or Vetraldehyde, a crystalline solid of the composition  $(CH_3O)_2C_6H_3 \cdot CHO$ , which gives the heliotrope flavor to the vanilla of Samoa and to some synthetic vanilla from coniferin. The alkaloid poison is extracted with a hydrocarbon solvent, and when the extract is used as an insecticide in combination with a synthetic, it gives greatly increased toxicity. The powdered seeds are also used as an agricultural insecticide dust which has greater staying power than pyrethrum. Anabasine,  $C_{10}H_{14}N_2$ , is derived from the plant *Anabasis aphylla* of Russia. The commercial insecticide is sold in the sulphate form as a sirupy liquid having the same odor and toxic effects as nicotine. The plant contains 2.3% alkaloids. The cresols in various forms are also used as insecticides. Dinitro ortho cresol, a yellow crystalline material melting at  $83.5^\circ C$ , is used in fruit-tree sprays. Thanite, of the Hercules Powder Co., is a terpene product derived from naval stores, used in insecticides and cattle sprays. Sodium antimony lacto phenate, known as Salp, is an effective insecticide against chewing insects.

CPR dust base, of U.S. Chemicals, Inc., used as a general agricultural insecticide, contains rotenone, pyrethrin, and piperonyl cyclono-

nene. The Pyrenones of this company are mixtures of pyrethrum with piperonyl cyclononene or piperonyl butoxide. Pyrenone Aerosol has 5% pyrethrin and 40 piperonyl butoxide. The Aerosol bomb used by the Army as an insecticide contained 3% DDT, 2 to 20 pyrethrum concentrate, 5 cyclohexanone, 5 mineral oil, and the balance Freon gas as a carrier. Acrylon, of the American Cyanamid Co., used for insect control, is a 50-50 mixture of acrylonitrile and carbon tetrachloride. Pencal, of the Pennsylvania Salt Mfg. Co., is a neutral calcium arsenate intended for combination with DDT and other insecticides. Wood preservatives are not usually classed as insecticides though their chief purpose is to kill insects and fungi. The most widely used wood preservative is coal-tar creosote or its derivatives. Wood treated with pyridine and acetic anhydride is given dimensional stability as well as resistance to insect and fungi attack.

The insecticide known as DDT is Dichloro diphenyl trichlorethane,  $C_6H_8Cl_2(C_6H_4 \cdot CH_2CCl_3)$ , used effectively during the war against flies, mosquitoes, body lice, and agricultural pests. It has no noxious odor, but in concentration is toxic to man and to other warm-blooded animals. Oil paint containing 0.5 to 5% DDT kills flies on walls painted with it. Deenate, of E. I. du Pont de Nemours & Co., Inc., is DDT combined with a carrier for use as an agricultural insecticide. Monoxychlor, of this company, is a trichloroethane analog of DDT, more effective than DDT and less toxic to warm-blooded animals. Methoxychlor, called Marlate by this company, is a methoxyphenyl trichloroethane and has higher killing power than DDT. Chlordane is a liquid of the composition  $C_{10}H_6Cl_8$ . It is a powerful insecticide. Velsicol 1068, of the Velsicol Corp., and Octa-Klor, of Julius Hyman & Co., is this material. Santobane, of the Monsanto Chemical Co., is formulated DDT. Gix is a German variant of DDT. It is Difluoro diphenyl trichlorethane, and is more effective but more expensive. The German insecticide Bladen is Hexaethyl tetraphosphate. A more powerful improvement on this material is Tetraethyl pyrophosphate,  $(C_2H_5)_4P_2O_7$ , produced as Nifos-T by the Monsanto Chemical Co. It is soluble in aromatic solvents, but loses its activity in water.

The insecticide 666, of the Imperial Chemical Industries, is Hexachlorocyclohexane.  $C_6H_6Cl_6$ , has four isomers, and is made by passing chlorine into benzol with ultraviolet light as a catalyst. The gamma

isomer, called Gammexane, which has a melting point of  $112.5^{\circ}\text{C}$ , is separated out as it is the most active poison. It is soluble in naphtha, benzene, and in alcohol. It is a hundred times more toxic against roaches than DDT, but nearly parallels that chemical for other uses. Both kill insects and larvae, but do not have the quick kill of pyrethrum. The Fungicide known as Dowicide 7, of the Dow Chemical Co., is Pentachlorophenol,  $\text{C}_6(\text{OH})\text{Cl}_5$ , an odorless brownish flaky powder soluble in most organic solvents. It is insoluble in water and is an effective fungicide and preservative for woodwork and textile fibers such as jute. Santophen 20, of the Monsanto Chemical Co., is this chemical in an oil solution for use as a wood preservative. Dowicide G is the sodium salt,  $\text{C}_6(\text{ONa})\text{Cl}_5$ , soluble in water, used as a fungicide and preservative in insulation board and water-soluble paints. A solution of Thioacetamide,  $\text{CH}_3\text{CSNH}_2$ , is used to spray oranges in storage to kill the fungi that cause blue and green molds. Fermate, of E. I. du Pont de Nemours & Co., Inc., is Ferric diethyl dithiocarbamate, a fine black powder used as a fruit fungicide.

**Insulators.** Any materials that retard the flow of electricity, used to prevent the passage or escape of electric current from conductors. No materials are absolute nonconductors; those rating lowest on the scale of conductivity are therefore the best insulators. An important requirement of a good insulator is that it will not absorb moisture which would lower its resistivity. Glass and porcelain are the most common line insulators because they are cheap, hard, and not affected by moisture. Hard rubber, slate, steatite, and stone slabs are still useful for panel boards, but there is now a great variety of electric panel-board materials made by compressing glass fiber or minerals with a synthetic resin binder, or standard laminated plastics of good dielectric strength may be used. Mica is used as an insulating separator, but it must be free from traces of iron. Various varnishes, resin solutions, and asphalt mixtures are used as insulating impregnating compounds for covering wires or metals. They are also used to impregnate paper or cardboard to make insulating sheet materials. A typical insulator of this type is Armite, of the Spaulding Fibre Co., Inc., which consists of impregnated fish paper in thicknesses from 0.004 to  $\frac{1}{8}$  in. The dielectric strength is 500 volts per mil, and tensile strength 8,500 psi lengthwise. It is used in motors and trans-

formers. Vulcoid, of the Continental-Diamond Fibre Co., is a laminated fibrous material impregnated with a thermoplastic resin. Vulcabeston, of Johns-Manville, is an electric insulating material made of asbestos with a binder of rubber. It is fibrous and can be molded into various shapes. The softening temperature is 175°C.

Insulating oils are mineral oils of high dielectric strength and high flash point employed in circuit breakers, switches, transformers, and other electric apparatus. An oil with a flash point of 285°F and fire point of 310°F is considered safe. A clean, well-refined oil will have a minimum dielectric strength of 22,000 volts, but the presence of as low as 0.01% water will reduce the dielectric strength drastically. The insulating oils, therefore, cannot be stored for long periods because of the danger of absorbing moisture. Any impurities, such as acids or alkalies, also detract from the strength of the oil. Since insulating oils are used for cooling as well as for insulating, the viscosity should be low enough for free circulation, and they should not gum.

Insulation porcelain, or Electrical porcelain, is not usually an ordinary porcelain except for common line insulators. For such uses as spark plugs they may be molded silica, and for electronic insulation they may be molded steatite or specially compounded ceramics. Insulation porcelains compounded with varying percentages of zirconia and beryllia have a crystalline structure, and have good dielectric and mechanical strengths at temperatures as high as 2000°F. These porcelains may have some magnesia, but are free of silica. However, Zircon porcelain is made from zirconium silicate, and the molded and fired ceramic is equal to high-grade steatite for high-frequency insulation. Vitrolain, of the Star Porcelain Co., is an electrical porcelain of high strength and density with porosity of only 0.25%. Thyrite, of the General Electric Co., is a porcelain that possesses the property of being an insulator at low potentials and a conductor at high potentials. It is used for lightning arrestors. The German Hartporzellan, or Hard porcelains, are specially compounded ceramics having good resistance to thermal shock. The material called Nolex by the Naval Ordnance Laboratory is made by hot-molding finely powdered synthetic fluorine mica. The molded parts are practically pure mica. They can be machined, have high dimensional precision because they need no further heat-treatment, and have high dielectric strength.

**Iodine.** A purplish-black, crystalline, poisonous elementary solid, chemical symbol I, best known for its use as a strong antiseptic in medicine, but also used in many chemical compounds and war gases. In tablet form it is used for sterilizing drinking water, and has less odor and taste than chlorine for this purpose. It is also used in cattle feeds. The Chilean production of iodine is as a by-product of the nitrate industry. In Scotland, Norway, and Japan it is produced by burning seaweed and treating the ashes. A ton of seaweed produces about a pound of iodine. It is also produced from salt brines and from sea water, and in California from the waste waters of oil wells. The lump iodine from this source is 99.9% pure. As much as 1,000 tons of iodine is present in a cubic mile of sea water. The specific gravity of iodine is 4.98, melting point 114.2°C, and boiling point 184°C. It is insoluble in water, but is soluble in alcohol, ether, and alkaline solutions. Tincture of iodine, a 7% alcohol solution of iodine in a 5% solution of potassium iodide, is used in medicine as a caustic antiseptic. Iodine cyanide, ICN, an extremely poisonous colorless crystalline material soluble in water, is used as a preservative for furs and museum specimens.

**Ionium.** The parent substance of the metal radium, chemical symbol Io. It is found in all minerals and rare earths that contain uranium and radium. It is so similar in all properties to the element thorium that it is difficult to separate it from thorium when the two have become mixed. Ionium is obtained from uranium ores by fractionating the rare-earth constituents; the resulting preparation contains the radio-inactive thorium. Ionium gives out the alpha rays of radium and has some of the uses of radium, but it is the most expensive of all materials. It has been used in minute quantities in spark-plug wire.

**Iridium.** A grayish-white metal of extreme hardness, symbol Ir. It is insoluble in all acids and in aqua regia. The melting point is 4260°F, and specific gravity 22.42. The annealed metal has a hardness of 172 Brinell. Iridium is found in its natural state in alloy with the metal osmium, known as Osmi-iridium, used chiefly for making fountain-pen points. Iridium is employed as a hardener for platinum, the jewelry alloys usually containing 10%. It is sold by the troy

ounce, a cubic inch of the metal weighing 11.82 troy oz. It is also employed as a catalyst.

**Iron.** The most common of the commercial metals, although not as plentiful as aluminum. It has been in use since the most remote times, but it does not occur native except in the form of meteorites, and early tools of Egypt were apparently made from nickel irons from this source. The common iron ores are magnetic pyrites, magnetite, hematite, and carbonates of iron. To obtain the iron the ores must be fused to drive off the oxygen, sulphur, and impurities. The melting is done in a blast furnace directly in contact with the fuel and with limestone as a flux. The latter combines with the quartz and clay, forming a slag which is readily removed. The resulting product is crude pig iron which requires subsequent remelting and refining to obtain commercially pure iron.

Iron is a grayish metal, which until recently was never used pure. It melts at  $1525^{\circ}\text{C}$ , and boils at  $2450^{\circ}\text{C}$ . Even very small additions of carbon reduce the melting point. It has a specific gravity of 7.85. All commercial irons except ingot iron and electrolytic iron contain perceptible quantities of carbon, which affect its properties. Iron containing more than 0.15% chemically combined carbon is termed steel. When the carbon is increased to above about 0.40%, the metal will harden when cooled suddenly from a red heat. Iron, when pure, is very ductile, but a small amount of sulphur, as little as 0.03%, will make it hot-short, or brittle at red heat. As little as 0.25% of phosphorus will make iron cold-short, or brittle when cold. Iron forms carbonates, chlorides, oxides, sulphides, and other compounds. It oxidizes easily and is also attacked by many acids.

Electrolytic iron is a chemically pure iron produced by the deposition of iron in a manner similar to electroplating. Bars of cast iron are used as anodes and dissolved in an electrolyte of ferrous chloride. The current precipitates almost pure iron on the cathodes which are hollow steel cylinders. The deposited iron tube is removed by hydraulic pressure or by splitting, and then annealed and rolled into plates. The iron is 99.9% pure, and is used for magnetic cores and where ductility and purity are needed. Highly refined nearly pure iron is marketed by the Westinghouse Electric Corp. under the name of Puron in rod form for use for spectroscopic and magnetic stand-



ards. It contains 99.95% iron, with only 0.005 carbon, 0.003 sulphur, and less than 0.001 phosphorus. By high-temperature hydrogen annealing, the carbon can be reduced to 0.001%, bringing the purity to 99.99%.

Iron powder, as originally produced in Sweden, is made by reducing iron ore by the action of carbon monoxide at a temperature below the melting point of the iron and below the reduction point of the other metallic oxides in the ore. In the United States it is made by the reduction of iron oxide mill scale, or by electrolysis of steel borings and turnings in an electrolyte of ferric chloride. Iron powder is used for molded parts made by sintering. Magnetic iron powder, used for electrical cores of high permeability, is made by reducing iron oxide with hydrogen. For this purpose it must be free of carbon and sulphur. A 10- to 40-micron powder with an apparent density of 2.75 will compress to a density of 6.85 at 150,000 psi. Carbonyl iron powder, used for magnetic cores for high-frequency equipment and for medical application of iron, is metallic iron of extreme purity and in microscopic spherical particles. It is made by the reaction of carbon monoxide on iron ore to give liquid Iron carbonyl,  $\text{Fe}(\text{CO})_5$ , which is vaporized and deposited as a powder. The high-purity, silica-free iron powder, produced by the Powdered Iron Corp. for electronic cores, is made by electrolytic deposition in a mercury cathode. The fine dendritic particles are recovered by distillation of the cathode.

The Reduced iron, used for special chemical purposes, is a fine gray amorphous powder made by reducing iron oxide by heating in a stream of hydrogen. Iron 55 is a very pure radioactive iron produced in minute quantities by cyclotronic bombardment of manganese and used in medicine for increasing the red blood pigment, Hemoglobin, in the human system. Bushed iron is an inferior grade of iron or steel made by heating bundles of scrap iron or steel in a furnace and then forging and rolling into bars. It is not uniform in composition or in the welding together, and is used only in isolated places or in wartime.

**Iron ores.** Iron-bearing minerals from which iron can be extracted on a commercial scale. The chief iron ores in order of importance are hematite, magnetite, limonite, and siderite. The greatest pro-

ducers are the United States, France, Russia, Great Britain, Brazil, and Germany. More than 90% of the iron ores mined in the United States are red hematites,  $\text{Fe}_2\text{O}_3$ , containing theoretically 70% iron, but usually not over 60%. The districts include the Lake Superior region and northern Alabama. It is also the ore from the Furness district in England and parts of Spain and Germany. The color is various shades of reddish brown, and the structure is usually earthy. The variety known as Kidney ore is columnar with a fibrous appearance; Specular hematite has a brilliant luster and foliated structure. The specific gravity is 4.8 to 5.3. Brown hematites contain from 35 to 55% iron. Ores containing more than 50% iron are considered high grade. Lake Superior ores are now averaging only 52% Fe, with 8 silica. This region also has large reserves of Taconite, a ferroginous chert which is an alteration product from Greenalite, or ferrous silicate. Taconite eventually leaches and becomes a hematite by the loss of silica, and it can be leached artificially by hydrothermal methods to produce a good iron ore, but it is hard and difficult to mine. The Rubio iron ore of Spain is classed both as limonite and brown hematite. It is a Hydrated ferric oxide,  $\text{Fe}_2\text{O}_3 \cdot \text{H}_2\text{O}$ , brown streaked with a silica gangue. It contains 77.4% ferric oxide, 9.2 silica, 1.76 alumina, and 1.1 manganese oxide. The hematite ores are preferred for the bessemer process because of their freedom from phosphorus and sulphur. Natural iron is the percentage of iron in the ore before drying; Dry iron is the percentage of iron in the ore after drying at 212°F.

Magnetite, or Magnetic iron ore, is found in northern New York, in New Jersey, and in Pennsylvania. It has the composition  $\text{FeO} \cdot \text{Fe}_2\text{O}_3$ , containing theoretically 72.4% iron but usually only about 62%. Low-grade hematite or limonite ores can be concentrated by making them magnetic. The ground ore is passed through a reducing gas at high temperature, which causes a part of the iron in each particle to become magnetic and thus capable of being separated. The Germans concentrated very low-iron, high-silica ores by heating the crushed ore in a rotary kiln, and then separating magnetically. The ore mined in Norway and Sweden is very pure, and it is the ore used for the Dannemora iron made with charcoal as a fuel. Magnetite may also contain some nickel or titanium. The specific gravity is 5.18, melting point 1540°C, the color iron black with a metallic luster, and

it is strongly magnetic. The natural magnet known as Lodestone is magnetite.

Siderite and carbonate ores are used in Great Britain, Germany, and Russia, much of which is not considered commercial in the United States, but the Dogger iron ore of Germany contains as high as 35% iron. Siderite is the chief iron ore in Great Britain. It is found in Staffordshire, Yorkshire, and Wales, and in the United States in Pennsylvania and Ohio. It is an Iron carbonate,  $\text{FeCO}_3$ , containing theoretically 48.2% iron. It usually occurs granular or compact and earthy. Its specific gravity is 4.5 to 5, and the hardness is 3.5 to 4. The color is light to dark brown, with a vitreous luster. It often is impure, with a mixture of clay materials or forming stratified bodies with coal formations. It is also known as Carbonate ore, Ironstone, and as Spathic iron ore. Impure forms mixed with clay and sands are called Clay ironstones, Black band, and Niggerhead ores. The Ironstone and black-band ores are the important ores of England and Scotland, but there is only a slight usage of carbonate ore in the United States. The Minette ore of Luxembourg and Germany averages about 26% iron, 22 CaO, 11 silica, and 2  $\text{CaOSiO}_2$ , with 0.54 phosphorus and 0.06 vanadium.

Limonite, also called Brown hematite, Brown ore, Bog iron ore, and Shot ore when in the form of loose rounded particles, was the common iron ore of early New England. It is a mineral of secondary origin formed by the water solution of other iron minerals. Its composition is  $2\text{Fe}_2\text{O}_3 \cdot 3\text{H}_2\text{O}$ , containing theoretically 59.8% iron, but usually 30 to 55%. It occurs earthy or in stalactitic forms of a dark-brown color. The specific gravity is 3.6 to 4. Limonite is found in Alabama, Tennessee, and Virginia, and is also an English and German ore. Goethite is a minor ore of iron of the composition  $\text{Fe}_2\text{O}_3 \cdot \text{H}_2\text{O}$ , found in the Lake Superior hematite deposits and in England. It is yellowish brown in color with a specific gravity of 4.3. It is also called Turgite. The largest known deposits of high-grade iron ores are in Brazil and extending into Venezuela. The ore in southwestern Brazil is with deposits of manganese. The hematite of Minas Gerais contains 57 to 71% iron. Large deposits of high-grade iron ores are also found in the Labrador-Quebec region of Canada, in India, and in the South Africa-Rhodesia area. The nearest approach to a native

iron is the iron-nickel mineral Awaruite,  $\text{FeNi}_2$ , found in gravel in New Zealand and Alaska, and Josephinite,  $\text{FeNi}_3$ , found in serpentine in Oregon.

**Iron pyrite.** A mineral sometimes mined for the zinc, gold, or copper associated with it, but chiefly used for making sulphuric acid and copperas. It is an iron disulphide,  $\text{FeS}_2$ , containing 53.4% sulphur. It often occurs in crystals, also massive or granular. It is brittle, with a hardness of 6 to 6.5 and specific gravity 4.95 to 5.1. The color is brass yellow, and it is called Fool's gold because of the common error made in detection. Pyrite is found in rocks of all ages associated with different minerals. It was formerly roasted to obtain the sulphur, and the residue, known as Blue Billy, was used as iron ore. The pyrites mined in Missouri, known as Marcasite, also used for gem stones, have the formula  $\text{FeS}$ , and the gem specimens have a yellow color with a greenish tinge.

**Iron shot.** An abrasive material made by running molten iron into water. It is employed in tumbling barrels and also in the cutting and grinding of stones. The round sizes between No. 30 and No. 20 are used for the shot peening of mechanical parts to increase fatigue resistance. Peening shot is marketed by SAE numbers from 6 to 157, the size numbers being the diameter in thousandths of an inch. Grit numbers in shot for grinding are from No. 10 to No. 200, the No. 10 is 0.0787 in., and the No. 200 is 0.0029 in. in diameter. Steel grit is made by forcing molten iron through a steam jet so that the metal forms into small and irregular pieces of chilled iron. The regular globules are screened and graded into Steel shot in sizes from No. 6 to No. 35, and the irregular pieces and large globules are crushed into Steel grit in sizes from No. 8 to No. 80. It is preferred to sand for sandblasting some material. Steelblast, of the Steelblast Abrasives Co., is this material for tumbling and sandblasting.

Tru-Steel shot, of the American Wheelabrator & Equipment Corp., is steel shot which has been heat-treated to give toughness to prevent breakdown into fragments. Cutwire shot, of the Precision Shot Co., is made by cutting SAE 1065 steel wire into short pieces. Pellets blasting shot, of Pellets, Inc., is the same type of steel wire of a hardness of Rockwell 50 cut to lengths equal to the diameter of the wire,

ranging from 0.028 to 0.41 in. Kut-Steel is a similar abrasive of the Steelblast Abrasives Co. Permabrasive, of the National Metal Abrasive Co., is a treated malleable iron shot to give a soft resilient body with a hard exterior. All of these materials for metal cleaning are termed Blasting shot.

**Ironwood.** A name for several varieties of wood, and may refer to any exceedingly hard wood that is used for making bearings, gears, tool handles, or parts of machinery. In the United States ironwood is most likely to refer to *Hackia*, the wood of the hackia tree, *Ixora ferrea*, of the West Indies and of tropical South America, or it may refer to the wood of the quebracho tree. *Hackia* is brown in color, has a coarse, open grain, and is very hard and tough. The weight is about 55 lb per cu ft. It is also used for furniture. The Burmese tree, *Mesua ferrea*, furnishes the wood Gangaw, which is also known as ironwood. It is a tough, extremely hard wood of a rose-red color weighing 70 lb per cu ft.

**Isinglass.** A gelatin made from the dried swimming bladders of sturgeon and other fishes. Russian isinglass from the Sturgeon is the most valued grade, and is one of the best of the water-soluble adhesives. It is used in glues and cements, and in printing inks. It is also used for clarifying liquids. It is prepared by softening the bladder in water and cutting it into long strips. These dry to a dull-gray, horny, or stringy material. Isinglass is also known as Ichthyocolla. Ichthyol is an entirely different material. It is a reddish-black sirupy liquid with a peculiar odor and burning taste, distilled from an asphaltic shale found in the Austrian Tyrol. It is used as an antiseptic astringent. The name isinglass is also used for mica when employed as a transparent material for stove doors.

**Ivory.** The material that composes the tusks and teeth of the elephant. It is employed mostly for ornamental parts, such as the keys of pianos. The color is the characteristic ivory white, which yellows with age. The best grades are from the heavy tusks weighing more than 55 lb, sometimes 6 ft long. The ivory from animals long dead is a gray color and inferior. The softer ivory from elephants living in the highlands is more valuable than the hard and more brittle of the low marshes. The west coasts of Africa, India, and

Southern Asia are the chief sources of ivory. The tusks of the hippopotamus, walrus, and other animals, as well as the fossil mammoth of Siberia, also furnish ivory, although of inferior grades. Odontolite is ivory from fossil mammoths of Russia. Ivory can be sawed readily, and is made into thin veneers for various ornamental uses. It takes a fine polish. Artificial ivory is usually celluloid or synthetic resins. The specific gravity of ivory is 1.87.

**Ivory nut.** Called Tagua nut in Colombia and Ecuador, and Jarina in Brazil. The source of Vegetable ivory, which is used for making various small articles, mostly buttons. The ivory nut is the seed of the low-spreading palm tree, *Phytelephas macrocarpa*, which grows in tropical America. The nuts are about 2 in. in diameter, growing in clusters and encased in shells. They have a fine white color and an even texture. They can be worked easily and harden on exposure to the air. They take dyes readily and show fine polished colors. A similar nut called the Dom nut is used in Eritrea for making buttons and novelties.

**Japan wax.** Sometimes called Sumac wax and Japan tallow. A vegetable fat used largely for adulterating beeswax, and in candles and polishes. It is a vegetable fat contained between the kernel and the outer skin of the berries of plants of the genus *Rhus*, which grow in Japan and are also cultivated in California. The fat, which is misnamed wax, is extracted by steaming and pressing the berries, and is refined by melting and pressing through cotton cloth. The crude wax is a coarse greenish solid, but the bleached wax is in cream-colored cakes which darken to yellow. Japan wax melts at 51°C. The specific gravity is about 0.975. It contains chiefly palmitic acid in the form of Glyceryl palmitate with also stearic and oleic acids, and a characteristic acid, Japonic acid, which is also found in catechu. The saponification value is 220. It is sometimes adulterated with common tallow. Lac is a variety of lacquer oil obtained from the same sumac plants, notably *R. vernicifera*, *R. sylvestris*, and *R. acuminata*, of Japan and Korea. It is used as a drying oil in baking enamels and for transparent lacquers. It is a gum exudation of the wood and is not obtained from the berries. The plants are cultivated primarily for this Lac and the Japan wax is a by-product. Lac is not to be confused with shellac from the lac insect.

**Jewelry alloys.** An indefinite term which is most likely to refer to the soft white alloys used for casting jewelry novelties to be plated, and to the miscellaneous harder alloys used for plated cheap jewelry, rather than to the alloys of the precious metals. The soft white alloys of this type are not now as important as they were before the advent of plastics when large amounts were cast into jewelry boxes, novelties, and ornaments. Articles now produced in metals are likely to be cast from standard white metal ingots, and cheap jewelry is now largely made from standard brasses, nickel brasses, and cupronickels. Formerly, a great variety of trade names were used for jewelry alloys. Argentine metal was a silvery alloy for casting statuettes and small ornaments. It contained 85.5% tin and 14.5 antimony, and makes silvery-white, hard, and clean-cut castings. An alloy known as Alger metal contained 90% tin and 10 antimony. A harder but more expensive white alloy known as Warnes metal contained 10 parts tin, 7 nickel, 7 bismuth, and 3 cobalt. Fahlum metal, used for stage jewelry, contained 40% tin and 60 lead. When faceted, it makes highly reflective brilliants. Rosein was a white metal for jewelry and ornamental articles containing 40% nickel, 30 aluminum, 10 tin, and 10 silver. When polished it has a high white luster without plating. Mock silver was an aluminum alloy containing about 5% silver and 5 copper. Argentale was a rich low brass whitened and strengthened with about 5% cobalt. Kuromi, a Japanese white jewelry alloy, is copper whitened with tin and cobalt. Argent français, or French silver, is cupronickel containing considerable silver. Platinoid was a nickel-silver-tungsten alloy with the small amount of tungsten added to the melt in the form of phosphor tungsten. Proplatinum, another substitute for platinum, was a nickel-silver-bismuth alloy. Nuremberg gold, with a nontarnishing golden color, contained 90% copper, 7.5 aluminum, and 2.5 gold.

**Jojoba wax.** Also called Jojoba oil, pronounced ho-hó-bah. A liquid wax obtained by pressing or solvent extraction from the seed beans of the evergreen shrub *Simmondsia californica* growing in the semiarid region of southwest United States and northern Mexico. The beans contain 50% oil which has high-molecular-weight acids and alcohols and no glycerin and is a true wax. It is used as a substitute for sperm oil in lubricants, in leather dressing, and also in

cosmetics. Jojoba alcohol, extracted from the bean, is a complex alcohol used as an antioxidant to prevent deterioration of fats.

**Jujube.** The oval fruit of the small spiny tree *Ziziphus jujuba* of the buckthorn family growing in dry alkaline soils. It is native to North China, but is also grown in the Mediterranean countries and in southwestern United States. It is also known as the Chinese date, or Tsao. The fruit has high food value, being higher in sugars than the fig, 65 to 75%, and higher in protein than most fruits, 2.7 to 6%, but is very acid, containing up to 2% acid. Some varieties develop butyric acid in ripening. Jujube is used for flavoring, and in confections, preserves, and sweet pickles, and as a fresh or dried fruit.

**Juniper.** The wood of the juniper tree *Juniperus virginiana* growing in the eastern United States from Maine to Florida. It is also called Red cedar, Red juniper, and Savin. The heartwood has a bright to dull-red color, and the thin sapwood is nearly white. The wood is light in weight, soft, weak, and brittle, but is durable. It is used for chests, cabinets, and closet lining because of its reputed value for repelling moths. It was formerly employed on a large scale for lead-pencil wood, and was known as Pencil cedar, but it is now scarce and other woods are used for this purpose, notably Incense cedar, *Libocedrus decurrens*, of California and Oregon, a close-grained brown wood with a spicy resinous odor. Rocky Mountain juniper is from a medium-sized tree of the Mountain states, *J. scopulorum*, valued for fence posts and lumber. African pencil cedar is from the tree *J. procera*, of East Africa. It is harder and heavier and less fragrant than incense cedar. There are more than 40 species of juniper. The fruit or Juniper berries of the common varieties are used in flavoring gin. Cade oil is a thick brownish essential oil, of specific gravity 0.950 to 1.055, distilled from the wood of the European juniper, and used in antiseptic soaps. It is also called Juniper tar oil. The juniper oil known as Savin oil is distilled from the leaves and tops of the Juniper bush, *J. sabina*, of North America and Europe. It is used in medicine as a diuretic and vermifuge, and also in perfumes. Cedarwood oil, used in perfumes and soaps, is distilled from the sawdust and waste of the eastern red cedar. The red heartwood contains 1 to 3% oil.



**Jute.** A fiber employed for making burlap, sacks, cordage, ropes, and upholstery fabrics. It is obtained from several plants, of which *Corchorus capsularis* of India is the most widely cultivated, growing in a hot, steaming climate. This fiber in Brazil is called Jute indiana, or Indian jute. Most of the commercial jute comes from Bengal. The plant grows in tall slender stalks like hemp, and the fiber is obtained by retting and cleaning. The fiber is long, soft, and lustrous, but is not as strong as hemp. It also loses its strength when damp, but is widely used because of its cheapness and because of the ease with which it can be spun. The crude fiber may be as long as 14 ft, but the commercial fibers are from 4 to 8 ft. The butts, or short ends of the stalks, and the rough fibers are used for paper stock. Jute paper, used for cement bags, is a strong paper made of these fibers usually mixed with old rope and old burlap in the pulping. It is tan in color. Jute fiber is also used for machine packings. The Rel-Kol of the Reliance Packing Co. is jute fiber treated with Thiokol and braided into square sections.

Brazilian jute is fiber from plants of the mallow family, *Hibiscus kitaibelifolius*, or *H. ferox*, cultivated in the state of São Paulo, Brazil. It is also called Jute paulista. The fiber is long, strong, resilient, and durable. It is used for making burlap for coffee bags. The fiber known as Paco-paco is from the *H. cannabinus*, of Bahia and Minas Geraes. It is used for cordage, burlap, and calking. In the East Indies it is called Java jute. In India it is called Bimlipatam jute and Deccan hemp, and is mixed with *Corchorus* fibers as jute and in burlap. As a substitute for hemp it is known as Sunee, or Brown Indian hemp. The species known as Amaniurana is from the *H. furcellatus* of the Paraguay River Valley. The fibers are very soft and silky and are made into sacks and bags. The species *H. sabdariffa*, known as Vinagreira, is used as a substitute for jute. In the East Indies it is called Roselle fiber and has characteristics similar to Indian jute, but is lighter in color. In El Salvador it is called Kenaf fiber and is used for coffee bags. Brazilian hemp is from the *H. radiatus*, and is stronger than true hemp. It is cultivated in Bahia. Aramina fiber is from the very long stalks of a plant *Urena lobata*, of the mallow family, of Brazil. In the north of Brazil it is known as Carrapicho. The fiber is used for cordage, twine, and burlap fabrics. In Cuba this fiber is known as White malva and Bowstring hemp. Cuba jute is

from the *Sida rhombifolia*. Both Cuba jute and aramina fiber belong to the mallow family, *Malvaceae*, and in Cuba and Venezuela are also known as Malva fiber. The *U. lobata* is also grown in the Belgian Congo where it is known as Congo jute.

Pirá fiber, used in Colombia and Central America for coffee bags, is from a plant of the pineapple genus, *Ananas magdalenae*. The fiber is a light cream color, lustrous, very long, and finer and more flexible than most hard fibers, so that it is useful for ropes, twines, and fabrics although most of the fibers of this botanical class are brush fibers. It has excellent resistance to salt water. The word Pirá means yellow or reddish in the Indian language, and this name is also used for grades of yucca and other fibers. Tucum fiber is from the leaves of the oil palm *Astrocaryum tucuma* of Brazil. The fibers are long, flexible, water-resistant, and durable. They are used for ropes, hammocks, and marine cordage, but are not classed as burlap fiber. Another fiber of great length and noted for resistance to insect attack is Curana, from the stalks of the plant *Bromelia saganaria* of north-east Brazil. There are two chief grades: the white and the roxo or purple.

**Kangaroo leather.** A strong, supple, and durable leather made from the skins of the Australian kangaroo, used chiefly for shoe uppers and gloves. The skins measure from 2 to 12 sq ft in area, and the small ones are known as Wallaby. The fibers have an interwoven structure, and the leather does not scuff easily. It takes a brilliant polish. It is rated as the strongest shoe leather per unit of weight.

**Kaolin.** Also called China clay. A pure form of hydrated Aluminum-silicate clay. There are three distinct minerals, Kaolinite, Nacrite, and Dickite, all having similar composition. The formula for kaolin is usually given as  $\text{Al}_2\text{O}_3 \cdot 2\text{SiO}_2 \cdot 2\text{H}_2\text{O}$ , but is also expressed as  $\text{Al}_2\text{Si}_2\text{O}_5(\text{OH})_4$ . It occurs in claylike masses of specific gravity 2.6, and of a dull luster. Kaolin is used for making Porcelain for Chinaware, and chemical porcelain for valves, tubes, and fittings, as a refractory for bricks and furnace linings, for electric insulators, as a pigment and filler in paints, as a filler in plastics, and as an abrasive powder. When kaolin is employed as an inert colloidal pigment with zinc oxide, it is called Chinese white. It is insoluble in water. In firebricks kaolin resists spalling. Its melting point is  $3200^\circ\text{F}$ , but

this lowers with impurities. It is a decomposition product of granite and feldspar, and its usual impurities are quartz, feldspar, and mica, which can be washed out. Kaolin is white, but inferior qualities burn to a yellow color. It should never contain iron. The Cornwall kaolin of England and the Limoges kaolin of France are the best known. English china clays contain little or no iron oxide, and the yellow clays contain only organic materials that can be bleached out. The best grade of English clay is used for coating and filling paper. Cornish clay, known as China stone, is used for the best grades of porcelain glazes. Cheaper grades of kaolin, called Mica clay, are used for earthenware glazes, and as an absorbent in oil purifying. The clay of Kentucky and Tennessee, known as Ball clay, occurs in massive beds of great purity; it has high plasticity and good bonding strength, and is light in color when fired. It is used for high-grade porcelain and for wall tiles. Impure varieties of kaolin, called Kaolinic earth, are used for refractories.

Halloysite has about the same composition as kaolinite but contains more alumina and water. It occurs with kaolinite. In association with alunite in Arkansas it is called Newtonite. Some varieties, such as Glossecollite, are waxlike, and with an electron microscope the grains appear as tubular structures. A variety of halloysite is marketed in France as a fine gray powder for use as a filler in rubber latex compounds. Indianaite, or Allophane, is an impure halloysite. It is a white, waxy clay found in Indiana, and is used for pottery. The Indiana halloysite used for refractories is called Malinite. Bone clay is a pure kaolin from feldspar and granite. It makes a strong porcelain. But Bone china is a name given to high-grade English pottery made with china clay and 25% calcined bone. Flesh clay is formed from feldspar and quartz. It gives resilience to the porcelain. Clays can be proportioned to give desired characteristics.

Micronized clay is pure kaolin ground to a fineness of 400 to 800 mesh, used as a filler in rubber. Dixie clay, of the R. T. Vanderbilt Co., is ground kaolin of 300 mesh, used as a stiffening or reinforcing agent in rubber and adhesives. Osmose kaolin is kaolin deposited by electro-osmosis from an alkaline solution to eliminate iron and other impurities and raise the alumina ratio. As a fine powder it is used for making electrical insulators and synthetic mica, and for cosmetics. Osmo, of E. Fougere & Co., is finely ground kaolin for cosmetics.

**Aluminum flake**, of the Aluminum Flake Co., is a white, flaky kaolinic clay from Missouri, ground for use in paints, adhesives, and rubber.

**Kapok.** A silky fiber obtained from the seed pods of the silk-cotton trees of the genera *Ceiba*, *Bombax*, *Chorisia*, and *Ochroma*, now grown in most tropical countries. It is employed for insulation and fine padding work. It is extremely light and resilient. Most of the commercial kapok normally comes from Java and is from the *Ceiba pentandra*. The tree was brought originally from Brazil where it was known as Sumaúma. It grows to a height up to 100 ft, with diameters to 10 ft, making the picking of the kapok pods difficult. The fibers are long, white, and silky, similar in appearance to cotton, but are too brittle for spinning. It is also known as Java cotton and Illiani silk. A silky cotton somewhat similar but inferior to kapok is Madar, from the shrub *Calotropis gigantea* of India and the East Indies. Another species, Akund, is from the *C. procera*. Both fibers are sometimes mixed with kapok, but are less resilient. They are known in the East Indies as Vegetable silk. Red silk cotton, known as Simal, is from the large tree *Bombax ceiba* or *B. malabaricum*, of India. The fiber is reddish. Shilo fiber is from the tree *B. ellipticum*. White silk cotton is from the tree *Cochlospermum gossypium* of India. It is quite similar to kapok. The kapok of Ecuador is from various species of the tree *Chorisia*. The fiber from the balsa trees, of the genus *Ochroma* of Central America, Colombia, and Ecuador, is dark in color. Mexican kapok is from the *Bombax palmeri* and from the *Ceiba schottii* and *C. acuminata*, the fibers from the two latter being more buoyant than the Java fiber. The kapok from the Lower Amazon region is from the *C. samauma*, and the Pochote fiber of El Salvador is from the *C. aesculifolia*. The Balsa fiber of Central America is from the tree *O. velutina*. Paina kapok is from a ceiba tree of Brazil. Kapok oil is a semidrying oil obtained from the seeds of the kapok tree. It is used in margarine and for soaps.

A substitute for kapok for sound and heat insulation, and as stuffing for life jackets, cushions, furniture, and toys, is Typha, or Cattail fiber. It is the fluffy fiber from the cylindrical flowers of the *Typha latifolia* which grows in swamps throughout the temperate climates of North America. As an insulating material the fiber has about 90%

the efficiency of wool. Milkweed floss, used also as a substitute for kapok, is the bluish-white silky fiber from the seed pods of the common milkweed, *Asclepias syrica*, of the eastern United States. It is not grown commercially.

**Karakul.** The curly lustrous fur pelts of newly born lambs of the karakul sheep originally of Afghanistan and Siberia, but now grown extensively in southwest Africa for the fur. The wool of the older sheep is clipped for carpet wool, but the fur pelts of the young animals are highly valued for coats and garment trim. The best qualities are those with small curl and medium curl to the fur. The fur skins are also graded by color, the gray and flora being most valued and the brown the least valued. Persian lambskin is a name for pelts of small tight curl.

**Kauri gum.** A fossil gum dug from the ground in New Zealand and New Caledonia, used in varnishes and enamels to increase the body and increase the elasticity and hardness. It is also used in adhesives, and the lower grades of chips are used in linoleum. It was first known as New Zealand gum, and first spelled cowrie, although Cowrie is the name of a genus of mollusk shells found in the Indian Ocean and formerly used as money in China. Kauri is a product of kauri tree exudations buried for long periods, but it also comes from the conifer tree *Agathis australis*. There is little extraction of the gum from the present kauri forests, whose wood is employed for lumber, but some Bush gum is obtained by collecting the deposits in the forks of branches. Range gum is found in clay deposits, and some is transparent. Swamp gum is brown in color and varies from hard to friable. The fossil gum has a specific gravity of 1.05, a melting point of 182 to 232°C, and is soluble in turpentine, benzol, and alcohol. The kauri tree grows to a height of 100 ft and great diameters, and yields a yellowish-brown, straight-grained wood free from knots much prized as a useful softwood. It weighs 36 lb per cu ft. Mottled and figured Kauri pine is used as a cabinet wood.

**Kermes.** A brilliant red natural dyestuff similar in color to cochineal, having a beautiful tone and being very fast. It is one of the most ancient dyes, but is now largely replaced by synthetic dyestuffs. Kermes is an insect found on the Kermes oak tree, *Quercus coccifera*,

of southern Europe and North Africa. The body of the animal is full of a red juice, and the coloring matter, Kermesic acid,  $C_{18}H_{12}O_8$ , is separated out in brick-red crystals. It has only about one-tenth the coloring power of cochineal. Garouille is the root bark of the kermes oak. It contains 18 to 32% tannin, and is used for making sole leather. The color is darker than oak tannin.

**Kerosene.** Known in some localities as Coal oil. A light, oily liquid obtained in the fractional distillation of petroleum. It distills off after the gasoline, and between the limits of temperatures of 174 and 288°C. It is a hydrocarbon of the composition  $C_{10}H_{22}$  to  $C_{10}H_{34}$ , with a specific gravity between 0.747 and 0.775. Commercial kerosene may be as high a distillate as 325°C, with a corresponding higher specific gravity up to 0.850, but in states where it is distinguished from gasoline in the tax laws it is more sharply defined. In Pennsylvania, kerosene is defined as having a flash point above 114°F, with not over 10% distillable at 175°C and not over 45% at 200°C. Kerosene is employed for illuminating and heating purposes, and as a fuel in internal-combustion engines. The heaviest distillate known as Range oil is sufficiently volatile to burn freely in the wick of a heating range, but not so volatile as to be explosive. It is nearly free from odor and smoke. Deodorized kerosene, used in insect sprays, is a kerosene highly refined by treatment with activated earth or activated carbon. Fialasol, of Fred Fiala, Inc., is a Nitrated kerosene used as a solvent for the scouring of wool. It is less flammable and has a slower rate of evaporation than kerosene, and it is odorless.

**Khaya.** A class of woods from trees of the genus *Khaya*, growing chiefly in tropical West Africa and known commercially as African mahogany. The woods closely resemble mahogany, but they are more strongly figured than mahogany, are slightly lighter in weight, softer, and have greater shrinkage. The pores are larger, and the wood coarser. The wood is used for furniture and store fixtures, musical instruments, and boat paneling. It is not as suitable for patterns as mahogany. African mahoganies are marketed under the names of the shipping ports, as the shipments from the various ports usually differ in proportion to the different species cut in the region. The chief wood of the genus, from which the native name *Khaya* derives,

is known commercially as Dry zone mahogany, *K. senegalensis*. It is also known as Kail and Oganwo. It grows from Gambia to Angola on the west coast and eastward to Uganda. The heartwood is dark reddish brown, and the thick sapwood is grayish to pinkish red. The most favored commercial wood is that of the Red Khaya, or Red mahogany, *K. ivorensis*, known locally as Dukuma and Dubini. This wood is highly figured, with interlocking grain, and when quartered shows a ribbon figure with alternate light and dark stripes. It comes chiefly from the Ivory Coast, Gold Coast, and Nigeria. Sassandra mahogany is chiefly this species. Duala mahogany is chiefly White mahogany, *K. anthoteca*, known also as Diala, Krala, and Mangona. The wood is lighter in color but tinged with red. Big-leaf mahogany, *K. grandifolia*, has a reddish-brown color. Much African mahogany is cut into veneer; the standard thickness of the face veneer is  $\frac{1}{28}$  in.

Gaboon mahogany and Port Lopez mahogany are chiefly Okume wood, from the tree *Aucoumea klaineana* of French Africa. The tree belongs to the family *Meliaceae* to which khaya belongs, and the wood resembles African mahogany but is lighter in weight and softer. It is light pinkish brown in color. It is shipped chiefly to Europe where it is used for furniture, chests, boxes, and boats. Cola mahogany, from the Ivory Coast and Gold Coast, is Niangon, *Tarrietia utilis*. The heartwood is light reddish brown, and the wood shows a herringbone figure on the quartered surface. It is heavier than khaya, and the pores are larger and more numerous. Cherry mahogany, or Makore, is a plentiful wood on the Ivory Coast, Gold Coast, and in Nigeria. It is from the tree *Minusops beckelii*. The wood is dark reddish brown without figure. It is heavier than Khaya and is finer in texture.

**Kid.** A name for leather made from the skins of young goats, but commercial Kidskin leather is now from both young and old animals, and the term Goatskin is not liked in the American trade. It is thin and has a fine, close-grained texture, with tiny groups of pores, and the leather is soft and pliable but strong and nonscuffing. Kid is usually chrome-tanned and dyed to many colors. It has a natural lustrous surface which is heightened by glazing or polishing. The leather is sorted by grain or size of pores, weights, and sizes into 10 grades. India, Argentina, Brazil, South Africa, and northwest Africa

are large producers of goatskins. About 70% of the goat and kid leather of the world is tanned in the United States although this country produces less than 1% of the skins. Kidskin is used for shoes, gloves, pocketbooks, jerkins, and for pads and linings. The term Vici kid, used in the shoe industry, was the name originally given to chrome-tanned leather in 1888. The best kidskins come from arid regions, and these are used for the fine French kid leather. In the glove trade the term Chevreau is used to designate young goats that have never browsed, while Chevette refers to the small skins of older kids that have eaten grass. Capeskin is goatskin from South Africa. Glazed kid is made by pressing a seasoning agent into the leather and then ironing the dry leather with a glass cylinder.

**Kieselguhr.** A variety of tripoli, or Infusorial earth, obtained in Germany, and employed chiefly as an absorbing material. It is also used as an abrasive, as a heat insulator, for making imitation meerschäum, and as an absorbing material for nitroglycerin in making dynamite. Kieselguhr is very absorbent and will hold 75% of its own weight of sulphuric acid. It is insoluble in water. Desirable characteristics as an insulator are closed cells and very high porosity, giving low density and low thermal conductivity. Kieselguhr from Oberhole, Germany, has 88% silica, 0.1 alumina, 8.4 water, and the remainder organic matter. The Randanite found at Clermont-Ferrand, France, is similar to kieselguhr but has a gray color. Nonpareil insulating brick, of the Armstrong Cork & Insulating Co., is made of pulverized kieselguhr mixed with ground cork, molded into brick form, and dried. The cork is burned out, leaving small air pockets to increase the insulating effect. The bricks will withstand temperatures up to 1000°C; the heat transmission is lower than for natural kieselguhr.

**Kino resin.** Also known as Gum kino. The red exudation of the tree *Pterocarpus marsupium*, of India and Ceylon, and of *P. erinaceus*, of West Africa, formerly much used for colored varnishes and lacquers and used in throat medicines. Bengal kino, or Butea gum, from the tree *Butea frondosa*, is now limited to medicinal use, as is also the Australian red kino from species of eucalyptus. Kino belongs to the group of red resins known as Dragon's blood when used in spirit varnishes for musical instruments and furniture, but now replaced



by synthetic colors. The dragon's-blood resins from the East Indies are from the ripe fruit of various species of the tree *Daemonorops*. The resin is separated out by boiling and is shipped in small oval drops or long cylindrical sticks. It is used in fine lacquers and varnishes. The dark-red dye known as Red sandalwood is the boiled-down juice of another kino tree *P. santalinus* of India. Still another *Pterocarpus* tree of southern India produces the wood Padouk valued for furniture, cabinetwood, and veneer. The heartwood is red with black stripes. It is hard and takes a high polish.

**Kyanite.** An aluminum silicate mineral of the composition  $\text{Al}_2\text{O}_3 \cdot \text{SiO}_2$  used as a refractory especially for linings of glass furnaces and furnaces for nonferrous metals. It is a common mineral but occurs disseminated with other minerals and is found in commercial quantities and grades in only a few places. Most of world production has been in eastern India, but high-grade kyanite is now obtained from Kenya. It is also mined in North Carolina, Georgia, Virginia, and California. The related minerals sillimanite and dumortierite are mined in western United States. The specific gravity is 3.56 to 3.67, and hardness 6 to 7 Moh. Kyanite of 97 to 98% purity is obtained by flotation, but gravity concentrates rarely exceed 90%. Low-grade kyanite ore from California, containing 35% kyanite and much quartz, is used for ceramics. Kyanite is usually marketed ground to finenesses from 35 to 325 mesh. Low-grade kyanite is used in glass-making as a source of alumina to increase strength and chemical and heat resistance. Synthetic kyanite for refractories was made in Germany from a mixture of 60% kaolin, 27 aluminum hydroxide, 10 fused alumina, and 3 feldspar.

**Lacquer.** Originally the name for a kind of Oriental finish made with lac and slow-drying varnishes, but now referring to the quick-drying finishes made from nitrocellulose or from cellulose acetate, though other synthetic plastics may be used, especially where chemical resistance is desired. The original Chinese lacquer was made from the juice of the *Rhus vernicifera* mixed in oils. The juice is milky but darkens rapidly, and the lacquer is pure black.

Modern lacquers are widely used for finishing automobiles and other articles. They consist of pyroxylin or other resin, one or more gums, a pigment, a softener, and one or more volatile solvents.

Various kinds of gums are used for increasing the body and giving hardness and gloss to the finished surface. For high gloss and hardness, dammar is used. For a cheaper product elemi may be employed. Kauri is used where good wearing is required. The usual solvents are anhydrous alcohol, ethyl acetate, butyl acetate, butenol, benzol, and toluol. Softeners are such products as amyl, ethyl, and butyl phthalates. Quick drying is the chief advantage of the lacquers, but the time must be made long enough to prevent cloudiness, or blushing, from absorption of moisture from cooling by too rapid drying. For industrial work, lacquers are usually sprayed, and they then dry in about 15 min. Brushing lacquers are made slower in drying to prevent streaks and lumps in their application. The time of drying is controlled by the solvents.

Lacquers are harder and tougher than enamels, but not as elastic, and are more expensive. They are not suitable for exterior woodwork where expansion and contraction occur. The word lacquer is also used to describe a highly transparent varnish used to produce a thin protective film on polished or plated metals to preserve their luster. Lacquers are sold under a variety of trade names such as Duco, of E. I. du Pont de Nemours & Co., Inc.; Agateen, of the Agate Lacquer Mfg. Co.; Zapon, of the Zapon Co.; Zelactite, of the Zeller Lacquer Mfg. Co.; and Brevolite, of the Atlas Powder Co. Bronzing liquids are the clear lacquer-base mediums marketed ready for incorporation of bronze or aluminum powders. Cable lacquers are clear, black, or colored lacquers prepared from synthetic resins, and are characterized by high dielectric strength, resistance to oils and heat, and by their ability to give tough, flexible coatings. Chromate-protein films may be used instead of clear lacquers for the protection of metal parts. The parts are dipped in a solution of casein, albumin, or gelatin, and, after drying, dipped in a weak chromic acid solution. The thin, yellowish film is hard and adherent and will withstand temperatures to 300°F.

**Lampblack.** A soot formed by the smudge process of burning oil, coal tar, resin, or other carbonaceous substances in an insufficient supply of air, the soot being allowed to settle on the walls or floors of the collecting chambers. Lampblack is practically pure carbon, but inferior grades may contain unburnt oil. It is chemically the same

as carbon black made from gas but, since it may contain as high as 2.5% oil, it is not used as a reinforcing agent in rubber. However, some Amorphous carbon, made from crude oil by spraying the oil and air into a closed retort at 3000°F to obtain partial combustion, is equal to carbon black for many uses. Lampblack is used in making paints, lead pencils, metal polishes, electric brush carbons, crayons, and carbon papers. It is grayish black in color, and is flaky and granular. The color is not as intensely black as carbon black. One pound occupies from 200 to 230 cu in. For use as a pigment for japan the powder should pass through a 325-mesh screen. Lamp-black oil is a coal-tar product marketed for making lampblack.

**Lancewood.** The wood of the tree *Guatteria virgata*, of tropical America. It is used for fine work where toughness, uniformity, and durability are requisites, such as for measuring rods. It is used also as a substitute for boxwood. The wood is yellowish in color and has a fine, close, smooth grain. The weight is 52 to 63 lb per cu ft. It is very hard and elastic. Yaya is a name given in the Honduras trade to lancewood. Degami lancewood, or Degami wood, is a yellowish wood with a fine, dense grain, from the *Calycophyllum candidissimum* of the West Indies. Burma lancewood, used in India for implements, is a strong, straight-grained, heavy wood from the large tree *Homalium tormentosum*. It has a light brown color and weighs 60 lb per cu ft.

**Larch.** The wood of the coniferous tree *Larix occidentalis*, of northwestern United States and southwestern Canada. It is also called Western larch, Western tamarack, Mountain larch, Montana larch, and Hackmatack. The wood is heavier than most softwoods, having a specific gravity of 0.48 and weight of 36 lb per cu ft. It is fine-textured and straight-grained. In strength and hardness it ranks high among the softwoods, but shrinks and swells more than most softwoods. The heartwood is reddish-brown and the narrow sapwood is yellowish. It finishes well, but splits easily. Butt logs contain Galactan gum, which darkens the color. Larch is used for bridge timbers, flooring, paneling, and general construction. The trees reach a diameter of 5 ft, and a height up to 200 ft. Shipments of western larch and douglas fir mixed are known commercially as Larch fir. Larch is also the name given to the Tamarack tree of New

England, *L. laricina*. European larch, *L. europea*, is an important wood in Russia and some other countries.

**Lard.** The soft white fat from hogs. It is used chiefly as a shortening in bakery and food products, and in cooking and frying. The inferior grades are used for the production of lard oil and for soaps. The types of edible lard for use in the United States are defined in regulations of the Department of Agriculture. Steam-rendered lard is made by applying steam directly to the fats in a closed container. Open-kettle rendered lard is made by applying steam to the outside of the kettle. The Neutral lard used for making margarine is produced by applying hot water in place of steam. Rendered pork fat is an edible material that does not meet the specifications for lard. Average production of edible lard is about 24 lb per animal.

Leaf lard is from around the kidneys and intestines and is the best edible grade. White grease is an inedible lard from the kidneys and the back. Yellow grease is the residue from the parts of the hog remaining after the parts yielding white grease are separated. USP grade of lard is called Adeps in pharmacy. It is purified internal fat of the abdomen, and is a soft unctuous solid of bland taste. It is used in Benzoated lard and in lead oleate for plasters. Lard oil is an oil expressed from lard by subjecting it to hydraulic pressure. Prime or first-grade lard oils are nearly colorless, or greenish, and have little odor. The commercial oils vary from the clear sweet oil to the acid and offensive-smelling brown oils. The oils contain oleic, stearic, and palmitic acids. They are used in cutting and in lubricating oils, sometimes in illuminating oils. They may be adulterated with cottonseed oil or blown oils. The flash point of pure lard oil is 480°F, saponification value 192, and specific gravity 0.915. Mineral lard oil is a mixture of refined mineral oil with lard oil, the fatty content being 25 to 30%. The flash point is about 300°F. Petrofac, of the Sun Oil Co., is a lard oil substitute made entirely from petroleum. Lardine is an old name for blown cottonseed oil used in lubricants.

**Latex.** The milklike juice of the rubber tree, now much used instead of the cured crude rubber for many rubber applications such as adhesives, rubber compounds, and rubber powder. The properties of latex vary with the type of tree, age of the trees, method of tapping, and climate. Latex from young trees is less stable than from older

trees. Intensive tapping of the trees results in less rubber content, which may vary from 20 to 50%. For shipping, a preservative and anticoagulant is added to the latex, usually ammonia or sodium sulphate. Concentrated 60% latex is a stable liquid of creamlike consistency. Heveatex is the trade name of latex of various grades of the Heveatex Corp. Latex foam is a name given to a type of cellular sponge rubber made by whipping air into latex, pouring into molds, and vulcanizing. Air-cell, of the B. F. Goodrich Co., is a latex foam made from natural rubber latex. Artificial latex is a water dispersion of reclaimed rubber. Dispersite is a trade name of Dispersions Process, Inc., for water dispersions of crude or reclaimed rubbers, produced by swelling and dissolving the rubber in an organic solvent, treating with an organic acid or with ammonia, and emulsifying. It resembles latex, but is softer and more tacky, and is used for adhesives. Lotol and Revertex are brands of latex. The Revertex process consists in the concentration of latex by evaporation in the presence of protective colloids. Neoprene latex is a water dispersion of neoprene synthetic rubber. The dispersed particles are smaller than those of natural rubber, and it thus gives better penetration in coating textiles or paper. Latex is also made from vinyl chloride and other synthetics by water dispersion. Nubun, of the Firestone Tire & Rubber Co., is a modified Buna S latex, used for electrical wire insulation. The coatings are flexible and have good aging and high insulating qualities. Anodex HR, of American Anodes, Inc., is compounded synthetic latex for coatings of high chemical and heat resistance.

**Lauan.** The wood of trees of several genera of the Philippines, Malaya, and Sarawak, known in the American market as Philippine mahogany. The woods resemble mahogany in general appearance, weight, and strength, but the shrinkage and swelling with changes in moisture are greater than in the true mahoganies. The lauan woods are used for furniture and cabinet woods, and for boatbuilding. The lauans belong chiefly to the genus *Shorea*, and the various species have local or common names. The so-called Dark-red Philippine mahogany is Tangile, *S. polysperma*, and Red lauan, *S. negrosensis*. Tangile is also called Bataan mahogany, and has the closest resemblance to true mahogany of all the species. The thick sapwood is light red and the heartwood dark brownish red. It has greater tend-

ency to warp than mahogany. Red lauan has larger pores, but is favored for boat construction because of the large sizes available. Tiaong, from the *S. teysmanniana*, resembles tangile but is lighter and softer. Almon, from the tree *S. eximia*, is harder and stronger than red lauan or tangile, but is coarser in texture and less lustrous.

White lauan is from a different genus of the same family and is *Pentacme contorta*. It has about the same mechanical properties as tangile, but is gray with a pinkish tint. Mindanao lauan, *P. mindanensis*, is quite similar but is lighter and softer. Mayapis, from the tree *Shorea palosapis*, is coarser in texture than tangile and is subject to warping and checking like red lauan. It is intermediate in color, and the light-colored wood is marketed as White lauan, while the dark wood is sold as Red lauan. Yellow lauan is from the trees Kalunti, *S. kalunti*, Manggasinoro, *S. philippensis*, and Malaanonang, *S. polita*. Yellow lauan is yellowish in color and has lower strengths and greater warpage than other lauans. Bagtikan, from the tree *Parashorea malaanonan*, is reddish gray in color, not lustrous, but is heavier and stronger than the other lauans. Sometimes mixed with Philippine mahogany is the wood known as Lumbayan, from an entirely different family of trees. It is from the tree *Tarrietia javanica*. The thick sapwood is light gray in color and the heartwood reddish. The weight and strength are about equal to tangile but the pores are larger. When marketed separately, it is a more valuable wood than the lauans for furniture manufacture. The reddish woods from Sarawak, Sumatra, and Malaya known as Meranti, or Morenti, are *Shorea* species of the lauan types. In the East Indies morenti is used for barrels, casks, and tanks for palm oil. Similar woods from North Borneo are called Seraya, or known as Borneo cedar or Borneo mahogany. The *Shorea* trees yield Borneo tallow and dammar. Merawan is a wood from various species of trees of the genus *Hopea* of Malaya. It is valued for furniture and interior work. Much of the so-called mahogany normally shipped from the Philippines is Apitong, the wood of the tree *Dipterocarpus grandiflorus* also grown in Borneo and Malaya. The wood is of a reddish-brown color and weighs 44 lb per cu ft.

**Lava.** A name given to ceramic material used for molding gas-burner tips, electrical insulating parts, nozzles, and handles. It may

be calcined talc, steatite, or other material. As produced by the American Lava Corp., it is molded from magnesium oxide, and it is hardened by heat-treatment after shaping and cutting. It is baked at 2000°F. The compressive strength is from 20,000 to 30,000 psi. It will resist moisture and has high dielectric strength. Rods as small as 0.020 in. in diameter can be made. Alsimag is the trade name of a lava produced by this company from ground talc and sodium silicate. Porcelava is a similar ceramic produced by Burgess & Co., for electric heating appliances. Isolantite, of the Isolantite Co. of America, Inc., is a steatite ceramic molded with a binder and then vitrified. It can be machined or threaded before firing and, by allowing for the contraction, parts can be made with great accuracy. The specific gravity of the vitrified material is 2.5, hardness 8 to 9 Moh, crushing strength 80,000 to 120,000 psi, and the dielectric strength of  $\frac{1}{8}$ -in. thickness 40,500 volts. Lavalloy, of the Lava Crucible Co., is a high-strength ceramic made from a mixture of mullite and alumina. Lavolain, of the Star Porcelain Co., is a strong, dense, heat-resistant ceramic for electric insulation.

**Lead.** A soft, heavy, bluish-gray metal with a granular structure and a strong metallic luster. Its chemical symbol is Pb. Lead is obtained chiefly from the mineral galena. It surface-oxidizes easily, but is then very resistant to corrosion. It is soluble in nitric acid but not in hydrochloric or sulphuric, and is one of the most stable of metals. However, it becomes hard and brittle on repeated melting owing to the formation of oxides. Lead is believed to be the ultimate substance produced by the disintegration of uranium and radium. Its specific gravity is 11.38, melting point 621°F, and boiling point 2787°F. The tensile strength is low, about 3,000 psi, but it is very malleable. The coefficient of thermal expansion is 0.0000183. Lead and its compounds are highly poisonous. Lead is used for pipes and cable coverings. It alloys easily with tin and other metals, and forms many commercial alloys, including solders and babbitts. It is also used for lining acid tanks, and for storage-battery plates. Its compounds are used in paints, especially white lead. About 30% of all lead is used for storage batteries, 20% for pigments, and 10% for cable coverings. Commercial lead is sold in pigs weighing 100 lb. Seven grades of pig lead are marketed. Corroding lead, 99.99% pure, is for

making white lead. Chemical lead, 99.92% pure, with some silver and copper, is used for storage batteries, sheet, and for pipes and cable coverings. Chemical lead has a hardness of 80 Rockwell B compared with 60 for the purer corroding lead. Desilverized lead is produced from the silver-lead ores of the Rocky Mountain states and is at least 99.85% pure. Common lead is not less than 99.73% pure. Work lead is the pig lead from the blast furnaces before the silver is extracted. About 60% of the world production of lead is in the United States, Australia, Mexico, Germany, and Canada, though the ores are widely distributed and many other countries produce lead.

(Lead wool is lead in a shredded form used for calking.) The strands are 0.005 to 0.015 in. in diameter, and come in ropes  $\frac{5}{8}$  to  $\frac{3}{4}$  in. in diameter. Blue lead is a term meaning all lead products such as pipe and shot that have not been changed chemically in manufacture. Blue lead is also a name for Basic lead sulphate, a by-product of the smelting of lead ores obtained by collecting and filtering the smoke from the furnace. It is a mixture of the products of the partial combustion of the ore and coal. It consists of lead sulphate, lead sulphide, lead sulphite, lead oxide, zinc oxide, and carbon. It is used in base-coat paints for steel. Lead-coated copper, used for roofing and for acid-resistant tanks, is 16-oz copper sheet, coated on both sides with lead, made with either a rough or smooth finish. Leadtex, of Revere Copper & Brass, Inc., is a lead-coated sheet copper. Roofloy, of this company, is a strong, stiff, creep-resistant sheet lead used as a substitute for sheet copper for flashings and gutters. It contains 99.7% lead, 0.20 tin, 0.015 calcium, and 0.012 magnesium. Tea lead, used for wrapping tea, is lead with 2% tin. Shot lead is lead hardened with a small quantity of arsenic.

**Lead alkali metals.** Lead hardened with small amounts of alkali metals used chiefly as bearing metals. Alloys of this type are also called Tempered lead and Alkali lead. The original alkali lead, known as Bahmetall, was made under a German patent. It contains 0.73% calcium, 0.04 lithium, 0.55 sodium, and the balance lead, and is made by electrolysis of the fused alkali salts, using a molten lead cathode. Calcium-lead alloy is made in the same manner, and contains up to 1% calcium. The calcium forms a chemical compound,  $Pb_3Ca$ , with part of the lead, and the crystals of this compound are



throughout the lead matrix. The Brinell hardness is 35, and the compressive strength 25,000 psi, being thus superior in strength to the high-tin-bearing metals. But the metal is difficult to melt without oxidation, and is easily corroded. The melting point is  $370^{\circ}\text{C}$ , and it retains its bearing strength at more elevated temperatures than babbits. Calcium lead, with about 0.04% calcium, is used as cable sheathing to replace antimonial lead, giving greater fatigue resistance. It is also used for grids in storage batteries, and has a lower rate of self-discharge than antimonial lead. The small amount of lithium in *Bahnmetall* is intended to prevent the corrosion set up by the calcium. It also increases the compressive strength to about 30,000 psi. *Mathe-sius* metal, another German alloy, contains calcium and strontium to form  $\text{Pb}_3\text{Sr}$  crystals. *Frary* metal, of the National Lead Co., is a lead-calcium-barium alloy containing about 1.5% of the alkali metals. These alloys give low friction loss at low temperatures, but they have higher coefficients of friction than the lead-tin alloys at temperatures above  $65^{\circ}\text{C}$ . A European lead-calcium-barium alloy known as *Ferry* metal contained 0.25% mercury to decrease the coefficient of friction. Another bearing alloy, *Noheet* metal, contained slight amounts of antimony and tin in addition to the alkali metals. *B* metal, a German alloy, contains 0.73% calcium, 0.66 sodium, 0.05 lithium, and 0.03 potassium.

**Lead ores.** The chief ore of the metal lead is *Galena*, a lead sulphide,  $\text{PbS}$ , containing theoretically 86.6% lead. The ore, however, contains many other minerals and usually carries only 4 to 11% lead. It is concentrated by wet gravity methods to contain 40 to 80% lead. *Galena* has a bright metallic luster, streaked gray, a specific gravity of about 7.5, and hardness of 2.75. It frequently contains silver and sometimes cadmium, bismuth, and copper. The lead is obtained from the concentrated ore by roasting to remove the sulphur, and smelting. The ingot lead from the blast furnace contains silver, copper, zinc, and other impurities. It is refined and desilverized. Southern Missouri is the chief source of *galena* in the United States.

The abundant lead ores *Cerussite* and *Anglesite* are secondary minerals formed by the oxidation of *galena*. *Cerussite* is a lead carbonate,  $\text{PbCO}_3$ , found in crystals or in granular crystalline aggregate or massive. Its color is white to gray, transparent to opaque. The

hardness is 3 to 3.5, and the specific gravity 6.55. Anglesite is found usually in the oxidized portions of lead veins associated with galena and other minerals. It is a common mineral occurring in many localities. Anglesite is a lead sulphate of the composition  $\text{PbSO}_4$ , containing 68% lead. It occurs in crystals, massive, or granular. Its hardness is 2.75 and specific gravity 6.12 to 6.39. The color may be white or pale shades of yellow or blue, or it may be colorless.

Vanadinite is a minor ore of lead and a source of vanadium. It is a mineral of secondary origin found in the upper oxidized parts of lead veins. It is found in Arizona, New Mexico, Mexico, and Spain. It has the composition  $9\text{PbO} \cdot 3\text{V}_2\text{O}_5 \cdot \text{PbCl}_2$ , with sometimes phosphorus and arsenic replacing part of the vanadium. It occurs in reddish crystals and globular forms and as incrustations. The specific gravity is 7, and hardness 3.

**Lead pigments.** Chemical compounds of lead used in paints to give color. They are to be distinguished from the lead compounds such as lead oleate, used as driers for paints. White lead is the common name for Basic lead carbonate, the oldest and most important lead paint pigment, and also used in putty and in ceramics. It is a white, amorphous, poisonous powder of the composition  $2\text{PbCO}_3 \cdot \text{Pb}(\text{OH})_2$ . It is insoluble in water, and decomposes on heating. The specific gravity is 6.7. It is made from metallic lead, and is marketed dry, or mixed with linseed oil and turpentine in paste form. Lead carbonate,  $\text{PbCO}_3$ , is used as a pigment in the same way as the basic compound, but it discolors more easily. Basic lead sulphate, called Sublimed white lead, makes a fine white pigment. Commercial sublimed white lead contains 75% lead sulphate, 20 lead oxide, and 5 zinc oxide. Commercial white lead may be mixed with lithopone, magnesium oxide, antimony oxide, witherite, or other materials. Chrome yellow, or Leipzig yellow, is Lead chromate of the composition  $\text{PbCrO}_4$ , and comes in yellow, poisonous crystals. The specific gravity is 6.123. It is insoluble in water and decomposes at  $600^\circ\text{C}$ . Basic lead chromate,  $2\text{PbO} \cdot \text{CrO}_3$ , is red in color and is used for anticorrosive base coats for steel. American vermilion, also called Chinese scarlet and Chrome red, is basic lead chromate made from white lead. Orange mineral is the red oxide,  $\text{Pb}_3\text{O}_4$ . Cassel yellow, or Montpelier yellow, is oxychloride of lead. Mixtures of white lead and heavy spar are known as

**Venetian white.** Dutch white is composed of three parts of sulphate and one part of carbonate. Lead thiosulphate,  $\text{PbS}_2\text{O}_3$ , is a white insoluble powder, used chiefly in matches. All of the lead compounds are poisonous by skin absorption or when taken internally.

**Leaded high brass.** An alloy containing approximately 65% copper, from  $\frac{1}{2}$  to  $1\frac{1}{2}$  lead, and the remainder zinc. It is one of the standard grades of brass, and is also called Free-cutting brass, or High-speed brass. It is easier to machine than high brass but is less ductile. It is used especially for cupped, drawn, or formed parts on which a clean thread must be cut. The lead is present in finely dispersed particles, and the property of free cutting is gained at the expense of its drawing capacity, but the material is mostly employed in the form of rods for screw-machine work or in sheets for blanking. The free-cutting brass rod of the Bridgeport Brass Co. contains 61.5% copper, 35.5 zinc, and 3 lead. All impurities, including iron, are below 0.25%, since as little as 0.50% iron will harden brass 20 points Rockwell. The free-cutting brass of the Chase Brass & Copper Co. has the same amount of copper, but has 3.5% lead. A brass of this class will have a tensile strength of 57,000 psi, elongation 25%, and Brinell hardness up to 110. Ledrite brass is the name of the Bridgeport Brass Co. for leaded brass containing 60 to 63% copper and 2.5 to 3.75 lead. The alloy known as Architectural bronze, used for extruded moldings and for forgings, contains 57% copper, 40 zinc, 0.25 tin, and 2.75 lead. The free-machining alloy known as Arsenical bronze is a leaded high brass modified with other elements. A typical analysis is copper, 56.5%; zinc, 39; lead, 0.70; nickel, 2; iron, 1.20; and arsenic, 0.60. The tensile strength is 65,000 to 87,000 psi, elongation 11 to 40%. It is both wear- and corrosion-resistant.

**Leaded steel.** A free-machining steel containing about 0.25% lead. Lead does not alloy with iron but is distributed in finely divided particles and strings. It gives free machining without imparting to the steel the unfavorable characteristics given by sulphur or phosphorus. The lead is in such a fine state of dispersion that it cannot be detected except with the most powerful microscope, and there is no weakening effect on the physical properties of the steel. Ledloy, of the Inland Steel Co., contains 0.15 to 0.30% lead in the regular SAE grades of

steel. La-Led steel of the LaSalle Steel Co. is a low-carbon leaded free-machining bessemer screw steel marketed in cold-finished rounds.

**Leather.** The skin or hides of animals, cured by the chemical action of tannins. Leather is used for belting, gaskets, shoes, jackets, handbags, linings, coverings, and a variety of other products. The action of tannins precipitates the protein of the hide, changes its colloidal structure, and makes it more pliable and capable of resisting decay. The process of tanning hides consists essentially in soaking them in solutions of the tanning material after they have been unhaired in caustic lime. This soaking may be prolonged for several months, after which the hides are washed, oiled, and rolled. Cheap leathers are tanned quickly with strong solutions of tannin, but rapid action does not produce the desired chemical changes. The quality of leather depends upon the type of animal, its physical condition, the care used in taking off the hide, the method of preserving the hide before tanning, and the care used in tanning. Leather is made from many kinds of skins, including sheep, goat, deer, alligator, seal, and shark, although the bulk of commercial leather is made from cattle hides. Animals raised in the open have hides that produce tough, close-grained leather; bred cattle raised for meat produce the weakest leather. But in general, packing-house hides, well skinned and packed in brine, make the best leather if properly tanned.

Belting leather is usually made from salted hides free from cuts and scratches, and is either oak- or chrome-tanned. It is then stuffed with oils or tallows. Belting leather weighs about 0.035 lb per cu in. and has an ultimate strength of about 3,800 psi. Belting is now sold by the thickness instead of the weight because of the old practice of weighting the leather by the addition of heavy impregnations. Leather was once used widely for packings and gaskets but has now been largely replaced for such use by special compounded materials. Where it is used for this purpose, oak-tanned or chrome-tanned is preferred. The Wax calf leather, once popular for men's shoe uppers, was a leather heavily stuffed with oil, grease, and wax. It sheds water and is wear-resistant, but oily leathers are no longer desired in shoes. Cordovan is a tough, smooth, close-grained leather made from the hind quarters of horsehides. It takes a beautiful polish and is used for fancy articles. Another fancy leather is Ostrich leather used for

handbags. The skin is marked with tiny rosettes where the quills are extracted. It is imitated in embossed calf. Lace leather, for lacing machinery belting, was originally made from the skins of porpoises, or dolphins, and the fishskins were tanned with alum and salt. After they had dried hard, they were then moistened with water and oiled with cod oil. The leather is very tough, pliable, and strong. It is now made with alum-tanned and oil-treated cowhide or calfskin. Helvetia leather, for belt laces and light belts, is weak-tanned with gambier or spent oak liquor and treated with grease and salt. Cotalace, of Freydberg Bros.-Strauss, Inc., is a Plexon plastic lacing in various widths and colors used to replace leather lacing for sporting goods.

**Leather board.** Also called Imitation leather, or Fiber leather. A solid paper type of board made from pulped scrap leather sometimes mixed with jute, wood pulp, or kraft paper to harden and stiffen it. It is used for making trunks and cases. Artificial leather, used for making washers, gaskets, and clutch linings, is made from pulped leather scrap compressed with a binder. A German Synthetic leather is made by milling scrap leather in water, producing an emulsion with polyvinyl acetate resin, and adding aluminum sulphite to coagulate the resin. It is then sheeted and dried. Fagelan is a German general trade name for leather substitutes made up of artificial or synthetic fibers bound together and coated with lacquers, gums, or resins. FabINETTE is a German artificial leather made up of natural fibers, animal or vegetable, with a suitable binder. Nifarine is a similar material made up with binders of synthetic rubber or synthetic resins in various types and grades. They are waterproof. Positex is the trade name of textile fibers waterproofed with deposited rubber latex and matted into special felts and shoe fabrics, or made into substitute leathers or fiber boards. It was developed by the British Rubber Producers' Research Association and the Wool Industries' Research Association. Leather board for built-up shoe heels is made with or without a binder. It is sometimes sold under trade names such as Herkolite of the Herkimer Fiber Co. Reletha, of the Prospect Mills, Inc., is a leather substitute for shoe linings made of scrap-leather fibers. The Fibrated leather of the Armstrong Cork Co. is shredded leather impregnated with a protein binder and made into continuous sheets on a paper machine. It is resistant to liquids, resilient, and will withstand temperatures to

300°F. It is used for gaskets, packing, and sealing. Cotton-leather, of the Southern Friction Materials Co., is made from two to six plies of cotton fabric impregnated with a thermosetting resin, calendered and surface-ground to resemble leather. It is made in weights of  $4\frac{1}{2}$  to 10 iron (an iron equals  $\frac{1}{48}$  in.), and is flexible and resistant to oil and water. It is used for shoe soles, stair treads, buffing wheels, and machinery mountings. Poorer grades of leather are made suitable for use as shoe soles by immersion in a rubber solution. The impregnation of rubber reduces water absorption, and increases the wear resistance of the leather.

**Leather dust.** The light, fluffy material blown from the buffing and suèding wheels in tanneries. It has a limited use as a covering material for Artificial suède or Suèded fabrics. In Europe it is more extensively collected, and is also used as a filler in calking compounds. It is very light, giving 20 bbl to the ton. Its disadvantage for commercial use is its lack of uniformity, being the refuse from many varieties of leather with different tannages and colors not kept separate in American tanneries. Leather flour is ground and graded leather, uniform in color and in mesh. It is used for filler and for suèded fabrics.

**Lecithin.** A light-brown, soft, salvelike substance of bland taste and odor obtained from soybeans by solvent and steam extraction. It is also obtained from cottonseed, and occurs in small amounts in animal and plant cells. Lecithin is a glyceride of complicated chemical structure containing an amine, phosphoric acid, and choline. It bleaches to a faint gold color, is insoluble in water but soluble in oils and in alcohol. At about 150°F it melts to an oil that will disperse readily in edible oils taking up glycerides to remain fluid when cooled. It is used in chocolate and other foods as an antioxidant to prevent spoilage, as a stabilizer and emulsifier, and as a dietetic. It is also employed in casein paints to regulate viscosity, in printing inks to impart flow, as a softener and wetting agent in some other products, and as a curing accelerator in synthetic rubbers. The Choline,  $\text{CH}_2\text{-OHCH}_2\text{N}(\text{CH}_3)_3\text{OH}$ , is used in medicine as a heart stimulant.

**Lemongrass oil.** A pale reddish essential oil distilled from various species of *Cymbopogon* grass of the East Indies, Malaya, and tropical

America. It contains about 75% Citral,  $C_9H_{15}CHO$ , which is an aldehyde of several essential oils. The chief constituents are Citronellal,  $C_{10}H_{18}O$ , and Geraniol,  $C_{10}H_{17}OH$ . It also contains some Ionone,  $C_{13}H_{20}O$ , a terpene used as a base for violet perfumes. The oil has a powerful lemonlike odor. The plant is a tall, rapid-growing grass. Three tons of the East Indian grass yield 24 bottles of oil, each bottle being 25 oz by volume. Florida lemongrass yields 6.3 lb of oil per ton of grass. The residue Lemongrass pulp in Florida is dehydrated and mixed with cane molasses for cattle feed. The oil is soluble in 70% alcohol. It is used as a stabilizer and perfume in soaps and in cosmetics. The two chief grades are East Indian lemongrass, from *C. flexuosus*, and West Indian lemongrass, from *C. citratus*. The latter contains less citral and is less soluble, but partly owing to a difference in the method of distillation. Citronella oil is a yellow oil with a pleasant odor, distilled from the grass *C. nardus* of Ceylon, Java, and India. Java citronella is called Serah grass. It contains high percentages of geraniol and citronellal. It is used as a stabilizer and perfume in soaps, as an insect repellent, and as a base product for the production of Synthetic menthol and of geraniol. The Java citronella oil is highest in citronellal, which yields about 20% levo menthol or about 12% USP menthol. The Ceylon oil is highest in geraniol, being sold on the basis of 85%, and is used in soaps and insecticides. Palmarosa oil, also called Turkish geranium oil because the original shipments were through Turkey, is from the Motia grass, *C. martini*, of India and Java. It contains 75 to 90% geraniol. Another variety of *C. martini*, known as Sofia grass, sofia meaning mediocre, yields the product called Ginger grass oil, inferior to palmarosa, and containing less geraniol.

**Lepidolite.** A lithia mica occurring usually in small plates, with muscovite, or common mica. The composition is  $KLi(Al \cdot 20HF) \cdot Al(SiO_3)_3$ . It is one of the chief ores of the metal lithium, and also carries more rubidium than any other known mineral, containing from a trace to 3% Rubidium oxide,  $Rb_2O$ . It may also have as much as 0.77% Cesium oxide. It is the most widespread of the lithium minerals, being found in various parts of the United States, Canada, Northern Rhodesia, South Africa, India, China, Japan, Russia, and Germany. The hardness is 2.5 to 4, and specific gravity

2.8. It has a pearly-luster, and color pink and lilac to grayish white. It is insoluble in acids. Lepidolite is employed as a source of lithium compounds, and of the metals rubidium and cesium. It is also used in making opal and white glasses. Glassmakers' lepidolite contains 4%  $\text{Li}_2\text{O}$ ; West African lepidolite usually contains 3.75%. Amblygonite, plentiful in Sweden, has the formula  $\text{Al}_2\text{O}_3 \cdot 2\text{LiF} \cdot \text{P}_2\text{O}_5 \cdot \text{Li}_2\text{O}$ , and contains 4.24 to 5.26% lithium. The amblygonite from South Dakota is sold on the basis of 8 to 9%  $\text{Li}_2\text{O}$ . Other Lithium ores are Lithiophilite,  $\text{Li}_2\text{O} \cdot 2\text{MnO} \cdot \text{P}_2\text{O}_5$ , containing 4.6 to 5% lithium; Cryolithionite,  $3\text{LiF} \cdot 3\text{NaF} \cdot 2\text{AlF}_3$ , with 5.35% lithium; Petalite,  $\text{Li}_2\text{O} \cdot \text{Al}_2\text{O}_3 \cdot 8\text{SiO}_2$ , with 1.4 to 2.26% lithium; and Manandonite,  $7\text{Al}_2\text{O}_3 \cdot 2\text{LiO} \cdot 2\text{B}_2\text{O}_3 \cdot 6\text{SiO}_2$ , with 2.13% lithium.

**Licorice.** The sweet roots of a group of plants of the order *Fabraceae*. The common licorice of the Near East and Spain is *Glycyrrhiza glabra*, and of Italy, *G. echinata*. Certain other species, all native to the Mediterranean countries, are also employed. The roots are crushed and boiled in water, and the juice strained and evaporated. Finely ground root is added to aid in hardening, but starch or other adulterant may be added. Licorice is employed in confectionery, in medicines, in tobacco, and in beverages, but industrially it is used for fire extinguishers to produce a froth to smother the fire. In medicine it is known as Glycyrrhiza, and it has an estrogenic, or female hormone, action. The dark-colored extracted juice of the roots contains a glucoside, which will not ferment. Licorice also contains a saponin, or froth-producing substance. In fire extinguishers it is sold under trade names. An insulating building board made with a proportion of the residue fibers after extraction of the licorice juice is produced by the National Gypsum Co. It is tough, strong, and resistant to insect attack.

**Lignin.** A colorless to brown crystalline product recovered from paper-pulp sulphate liquor, and used in furfural plastics, as an extender of phenol in phenolic plastics, as a corrosion inhibitor, in adhesives and coatings, as a natural binder for compressed wood products, and for the production of synthetic vanilla when it contains coniferin. It is also used as a fertilizer, providing humus and organic material and some sulphur to the soil. For this use it may be mixed with phosphates. Lignin is coprecipitated with natural and synthetic



rubbers to produce stronger and lighter weight rubbers. The melting point of lignin is 250 to 275°C. It is a complex material,  $C_{41}H_{32}O_8$ , with four hydroxyl and four methoxyl groups. The lignin occurs in the liquor as a sodium compound, and is precipitated by acidification. The lignin known as Tomlinite is obtained from kraft pulp liquor by treating with  $CO_2$ , separating the black liquor, dissolving in hot water, and acidifying with sulphuric acid to yield the water-insoluble brown powder. This material is used in plastics and for impregnating wood or paper. The waste liquors from sulphite process paper mills contain about 5% lignin. Alkali lignin is produced by acidulation of the black liquors from the soda process. It is used as the organic expander in the negative plates of storage batteries, as an emulsifier for asphalt to reduce cold flow, and as a binder in paperboard plastics. Alkali lignin may also be hydrogenated to make methanol, methane, and tar acids.

**Lignite.** Also called Brown coal. A variety of organic mineral of more recent age than coal, occurring in rocks of tertiary age, and intermediate in composition between wood and coal. It is widely distributed over Europe, and found in many other parts of the world. Freshly cut lignite often contains a large quantity of water, up to 40%, and is sometimes also high in ash. When dried it breaks up into fine lumps and powder. Dry lignite contains 75% carbon, 10 to 30 oxygen, and 5 to 7 hydrogen. It kindles easily but burns with a low calorific power and a smoky flame. In retort gas production lignite loses its gas in half the time required for gas removal from bituminous coal, with a temperature of 1270°F, compared with 1655°F for bituminous. California and Arkansas lignites are processed to extract montan wax, Sap brown dye, and Van Dyke brown pigment. The color of lignite varies from brown to black, and the lower grades of brown lignite show the woody structure. The Pitch coal is brownish black, breaks with a pitchlike fracture, and shows no woody structure. Lignite is briquetted by crushing and pressing with a binder under heat. Belgian lignite briquettes have a binder of 8% asphalt, with 2 flour to assist binding. The reserves of lignite in the United States are estimated at 1,000 billion tons, and form a future fuel for use in powdered form, or for distillation of oils and coal-tar products. Jet is a hard, compact, black lignite found in Colorado and

in Europe. It can be turned in the lathe and will take a fine polish. It was formerly much used for making buttons and ornamental articles, but has been largely replaced by synthetic plastics.

**Lignum vitae.** The wood of the guayacum trees, *Guaiaacum officinale* and *G. sanctum*, of tropical America, but the commercial shipments of lignum vitae are likely to contain also other species. The wood of the Guayacan tree of Brazil and Paraguay is also called by this name. The best quality of the true lignum vitae comes in logs up to 18 ft long and up to 3 ft in diameter, and originates mostly from Cuba, Haiti, Yucatan, Dominican Republic, and the west coast of Mexico and Central America, but species of the trees grow as far south as Paraguay. It is very hard, heavy, and tough. The color is brown to greenish black. The grain is very finely twisted, and the wood has a greasy feel. The weight is from 72 to 88 lb per cu ft, and the crushing strength is 10,000 psi. The wood is used in places where extreme hardness is needed, such as for pulley blocks. It is also used for rollers, mallet heads, handles, novelties, bearings, and furniture. In machine bearings it withstands pressures up to 4,000 psi, and is used for propeller-shaft bearings in steamships. Palo santo, *Bulnesia sarmentifera*, known as Guayacan, of Argentina and Paraguay, and also Vera, *B. arborea*, of Colombia and Venezuela, are closely related to lignum vitae and were formerly classified as *Guaiaacum*. The latter is called Maracaibo lignum vitae, and the former is known as Paraguayan lignum vitae. The trees are larger than true lignum vitae, but the wood is not as hard. Philippine lignum vitae is a hard, heavy wood with interwoven grain, from the tree *Xanthestemon verdugonianus* of the Philippines. Yellow guayacan, deriving its name from the yellow flowers, is from the *Tecoma guayacan*, an important timber tree of Panama and Central America. The wood is very hard and strong, but neither this wood nor that of the Philippine wood has the self-lubricating bearing properties of the oily true lignum vitae. Ibero vera, of Argentina and Paraguay, is also called guayacan locally. It is from the tree *Caesalpinia melanocarpa*, and resembles lignum vitae in hardness, strength, and durability, but is lacking in the oily gum resin.

Artificial lignum vitae, or Compressed wood, or Densified wood, sold under trade names, is ash or a soft wood impregnated with liquid

resin and compressed hydraulically to about the specific gravity of *lignum vitae*. It is used for bearings, or as a substitute for very hard woods. The material developed by the U.S. Forest Products Laboratory under the name of Staypak, is made by compressing veneered softwood containing no resin except that used to bond the veneers. It has a smooth satiny finish, a specific gravity of 1.3 to 1.4, and about double the tensile and flexural strengths of birch. The color is darker than the original wood because of the flow of lignin. Hiden, of the Parkwood Corp., is a synthetic hardwood of about the same density and hardness as *lignum vitae*. It is made of birch veneers impregnated with phenolic resin and compressed to 30% of the original thickness and cured. The boards are used for table tops, cutlery handles, sheet-metal forming dies, and textile picker sticks.

**Lime.** A Calcium oxide,  $\text{CaO}$ , chemically known as *Calcia*, occurring abundantly in nature, chiefly in combination with carbon dioxide as calcium carbonate, in limestone, marble, chalk, coral, and shells. Lime is employed in mortars, cements, as a flux in iron melting, in many chemical processes, as an absorbent, and for liming acid soils. It is obtained by heating limestone in a furnace or kiln to about  $1000^{\circ}\text{F}$  to burn out the carbonic acid gas. The residue is called Quicklime or Caustic lime. Pure quicklime is white and amorphous or crystalline. The specific gravity is 3.2 and melting point  $4660^{\circ}\text{F}$ . Chemical lime, used in the chemical industries and for water softening, is a high-calcium lime with minimum impurities. A typical analysis is 97.9%  $\text{CaO}$ , 0.43 silica, 0.45 iron and aluminum oxides, and 0.52 magnesium oxide. The Kemidol quicklime marketed by the U.S. Gypsum Co. for glass manufacture is a free-flowing fine powdered lime made from Ohio dolomite.

Commercial limes for building purposes contain about 94% calcium oxide, some calcium carbonate, and less than 0.50% magnesia. Water causes the lime to slake with much heat, leaving a white powder,  $\text{CaO} \cdot \text{H}_2\text{O}$ . High-calcium limes slake rapidly and expand greatly on slaking and are the strongest. Limes with much magnesia slake slowly, but magnesia produces the slip that makes easier working. The so-called lean limes contain considerable silica, alumina, and iron oxide, and are slow slaking and difficult to work. Lime is marketed in lumps or ground to 20 mesh, and as mill run. Hydrated lime

is made by grinding quicklime, slaking the powder with water, and sifting to a fine powder. It is easier to handle and is a more reliable product than ordinary lime. High-grade hydrated lime will have a fineness so that 98% will pass through a 100-mesh sieve and will contain not over 2% magnesia. Some grades contain less than 0.50% magnesia, and 98% pass through a 200-mesh sieve. The pure hydrated lime for the chemical industry has 98.2%  $\text{Ca}(\text{OH})_2$ , or 74.4%  $\text{CaO}$ , and is a fine impalpable powder. Hydraulic lime that will set under water is a hydrated lime with more than 10% silica. The Grappier cement of France and Belgium is made from limestones that contain 20 to 22% silica and 2 alumina. Lime mortar, made of a mixture of hydrated lime, sand, and water, will have a compressive strength up to 400 psi. Soda lime, used for freeing air of carbon monoxide, as a chemical purifying agent, and in gas masks, is a mixture of hydrated lime with sodium hydroxide.

**Lime oil.** An essential oil expressed from the rind of the Lime, the fruit of the small tree *Citrus aurantifolia*, native to India but now grown in many tropical and subtropical countries. The fruit is smaller than the lemon, and is greenish yellow in color. Montserrat in the West Indies, Italy, and Florida are the chief commercial centers. Lime juice, from the pulp of the fruit, is used in flavoring and to give freshness to perfumes, in beverages, and was early used to prevent scurvy, but contains only about a quarter as much vitamin C as orange juice. Lemon oil is a bright-yellow oil of pleasant odor, expressed from the rind of the Lemon, the fruit of the tree *C. limonia*, grown commercially in the Mediterranean countries, California, and the West Indies. About 1,000 lemons are required to produce a pound of oil. The oil is high in Citral with also limonene, terpeneol, and citronellal. It is used in flavors, soap, and perfumery. Lemon juice is from the pulp. It contains 5% citric acid, and is used as a bleaching agent. It is also much used in beverages, but constant use causes etching and decalcination of the teeth. The Citric acid produced from lemons, limes, and pineapples is a colorless, odorless crystalline powder of the composition  $(\text{CO}_2\text{HCH}_2)_2\text{C}(\text{OH})\text{COOH}$ , specific gravity 1.542, and melting point  $153^\circ\text{C}$ . It is used in medicine, flavoring extracts, and in soft drinks, but is toxic in excess. It is also used in inks, etching, and as a "resist" in textile dyeing and printing.

**Limestone.** A term applied to a great variety of rocks that contain lime. Immense quantities of limestone are used as flux in the melting of iron, for the manufacture of lime, and as a building stone. In its broad sense limestone includes dolomite, chalk, marble, or any mineral consisting largely of  $\text{CaCO}_3$ , but many limestones contain considerable magnesium carbonate,  $\text{MgCO}_3$ . On calcination limestone yields lime,  $\text{CaO}$ . The Portland stone of England consists of fossils cemented together with lime. Indiana limestone, used for building, is a noncrystalline massive rock with aggregate, filler, and matrix of pure carbonate of lime in gray and buff colors. The average weight of Indiana limestone is 144 lb per cu ft, and crushing strength 6,000 to 8,000 psi. The mill blocks range from 8 to 12 ft in length, and are 3 ft 6 in., or 4 ft 4 in. square. Limestone is very widely distributed, and nearly 70% of all the crushed and broken stone marketed for construction purposes in the United States is limestone. The agricultural limestone, known in the trade as Agstone, and used for liming soils, has a content of 99%  $\text{CaCO}_3$ , and is ground to a fineness of 200 to 325 mesh. The Sohnhofen stone, or Lithographic stone produced at Sohnhofen, Bavaria, is a limestone that is exceptionally homogeneous, has a very fine grain, and is very low in impurities. The hardness is 3 Moh. It occurs in layers 2 to 6 in. thick, with partings of gray clay.

**Linen.** A general name for the yarns spun from the fiber of the flax plant, or for the cloth woven from the yarn. Linen yarns and fabrics have been made from the earliest times, and the ancient Egyptian linen fabrics were of exceeding fineness containing 540 warp threads per inch, not equaled in Europe until the twentieth century. Ireland, Belgium, and France are the principal producers of linen. Linen yarns are used for the best grades of cordage, and linen fabrics are employed industrially wherever a fine, even, and strong cloth is required. Linen fabrics are sold under a wide variety of trade names. They are graded chiefly according to the fineness of the yarns and the class of weave and may contain some fine hemp fibers. Lisle was formerly a fine, hard linen thread, made at Lille, France, but is now a fine, smooth yarn made of long-staple cotton spun tightly in a moist condition. Tow yarns are the coarsest linen yarns, used for making Crash, a coarse, plain-woven fabric used for towels or covers.

**Chintz** is a plain-woven linen fabric in brightly colored designs. It is also made in cotton as Cotton chintz. The name is from the Hindu word meaning color. **Damask** is a jacquard reversible woven linen fabric for table linen. It is now also made in cotton, silk, wool, or rayon.

**Linoleum.** A general name for floor-covering material consisting of a fabric impregnated and covered with a compound of blown linseed oil, ground cork or wood flour, and rosin or other gum. It is rolled under great pressure, and then dyed in plain colors or printed with designs. In good-quality linoleum the cork is ground to a 50-mesh screen, and the pressed material will take printing or coloring evenly. A filler of lithopone or other material may be used. The fabric may be of jute or other coarse material. Linoleum was invented and patented in 1863 and displaced the older Kamptulicon floor covering, which was made of rubber, cork, rosin, and boiled oil, and was more expensive. Battleship linoleum is very heavy linoleum in plain colors or mosaics. Federal specifications describe it as made with oxidized linseed oil, fossil or other resins or oxidized rosin, and an oleoresinous binder, mixed with ground cork, wood flour, and pigments, processed on a burlap back.

**Linseed oil.** This oil is the most common of the drying oils, and is widely used for paints and varnishes, and for linoleum, printing inks, and soaps. It is obtained by pressure from the seeds of the flax plant, *Linum usitatissimum*, which is cultivated for oil purposes. It is sometimes referred to as Flaxseed, though this name properly belongs only to the seed of the flax plant for producing flax fiber. The varieties producing fiber do not yield much seed. The seed contains up to 40% oil, and Argentine seed averages 38.5%, but the usual conversion factor is 34%. The linseed plant can stand high temperatures and drought, but is sensitive to cold, while the flax fiber plant needs a cool and humid climate. In normal times 80% of the world's linseed is grown in the mesopotamia region of Argentina and Uruguay, and much of the remainder in northern India and southern Russia, while the flax plant is grown in northern Europe and the Baltic region. When prices are high, much linseed is grown in the United States and Canada. The commercial oil is hot-pressed and has a bitter taste, but a cold-pressed oil is used in Russia for food pur-

poses. The residue Linseed cake is used for cattle feed and fertilizer. The oil imported from Holland under the name of Haarlem oil is linseed oil mixed with sulphur and turpentine. It is used in the southern states as a diuretic medicine. Linseed oil contains about 48% linoleic and 34 linolenic acids. The specific gravity is 0.925 to 0.935. It is a yellowish oily liquid with a peculiar odor and a bland taste. It is soluble in turpentine, ether, and benzene. It dries with a distinct gloss and makes a hard film.

The best Baltic oil is used as a standard in measuring the drying power of other oils. Genuine linseed oil has an iodine value of at least 170, and the best approaches 190. The linseed grown in cooler climates from the same type of plant generally yields oil of higher iodine value than that grown in warm climates. Baltic oil has an iodine value of 190 to 200, though this high value is from the type of plant as well as from the climate, the European plant being the flax plant yielding less seed. Oils from seeds grown in different areas vary widely in the acid content. North Dakota oil contains 26 to 33% linolenic acid, while Punjab oil of India has as high as 54%.

For varnish use, linseed oil is bleached by heating and forcing oxygen through it, or used as Boiled linseed oil, prepared by boiling in a kettle or by heating with oxidizing driers such as the salts of lead or manganese. When prepared with driers, it is called Bung oil. Stand oil, also known as Lithographic oil, is linseed oil heated for several hours without blowing, at a temperature of 550 to 650°F. It has the consistency of honey and is used in oil enamel paints. Blown oils and boiled oils are not greasy like the original oil. Lin-oxy-n is a trade name for blown linseed oil. The purity and adulteration of linseed oil for paint and varnish use are controlled by state laws. The law of the state of Ohio, which is typical, defines Boiled linseed oil as prepared from pure, raw linseed oil heated to a temperature of 225°F, and incorporating not to exceed 4% by weight of drier, and with specific gravity at 60°F of not less than 0.935 and not greater than 0.945. Esskol and Solinox, of Spencer Kellogg & Sons, Inc., are hydrogen-treated linseed oils used as substitutes for tung oil and castor oil. Keltrol L, of this company, is Styrenated linseed oil made by reacting linseed oil with styrene. It is used for paints, in which it dries rapidly to a hard, tough, and alkali-resistant film. The Heavy-bodied linseed oils of the Archer-Daniels-Midland

Co. are oxidized oils with specific gravities of 0.980 to 0.990, and iodine numbers from 210 to 230.

**Linters.** The short cotton fibers that adhere to the seed after ginning. Cotton linters removed from the cottonseed are  $\frac{1}{8}$  in. long or shorter, gray and brown in color, and are used as a filling and padding material especially for mattresses, and also for producing cellulose for the manufacture of rayon, nitrocellulose, and plastics. The No. 1 grade is spinnable, and can be used for mixing with cotton for yarns. This grade is also used for absorbent cotton. The Nos. 2, 3, and 4 grades are for felting and for filling. The Nos. 5, 6, and 7 grades are called chemical grades and constitute about 60% of the production. The extremely short fibers obtained from second-cut seeds are called Hull fiber. About 100 lb of linters are obtained per short ton of seed. The selling price usually determines how much will be cut from the hulls. The yield per short ton of seed has averaged as low as 52 lb and as high as 190 lb.

**Liquid air.** Atmospheric air liquefied under great pressure. The boiling point is about  $-310^{\circ}\text{F}$ . One cubic foot of liquid air makes 792 cu ft of free air. It is used in propellants, for cold-treating metals and chemical condensers, and as a source of oxygen. It contains more than 20% free oxygen. It is marketed in vacuum bottles, and as the evaporation is 4 to 8% a day, it is shipped only just prior to use. Liquid air mixed with alcohol was used as the propellant in the German 15-ton rocket known as the V-2. The mixture is highly explosive, and the reaction was balanced with hydrogen peroxide and potassium permanganate which also added to the power.

**Litharge.** The yellow Lead monoxide,  $\text{PbO}$ , also called Massicot. It is a yellow powder used as a pigment and also in the manufacture of glass, and for the fluxing of earthenware. An important use is as a filler in rubber. With glycerin, litharge is used as a plumbers' cement. The specific gravity is 9.375. Litharge is produced by heating lead in a reverberatory furnace and then grinding the lumps. For storage-battery use the black oxide, or suboxide of lead, is now largely substituted.

**Lithium.** The lightest of all metals, with a specific gravity of 0.534. It is abundant, and is found in more than 40 minerals, but is ob-



tained chiefly from lepidolite and spodumene and from salt brines. The brine of Searles Lake contains a ton of  $\text{Li}_2\text{O}$  in every 8,750 tons of brine. The dried crude concentrate from the flotation cells contains about 20%  $\text{Li}_2\text{O}$ . Lithium melts at  $356^\circ\text{F}$  and boils at  $2550^\circ\text{F}$ . It is unstable chemically and burns in the air with a dazzling white flame when heated to just above its melting point. The metal is silvery white but tarnishes quickly in the air, and in moist atmospheres  $\text{Li}_3\text{N}$  is formed. The metal is kept submerged in kerosene. Lithium resembles sodium, barium, and potassium, but has a wider reactive power than the other alkali metals. It combines easily with oxygen, nitrogen, and sulphur, to form low-melting-point compounds which pass off as gases, and is thus useful as a deoxidizer and degasifier of metals.

Lithium metal is produced by the fusion of Lithium chloride,  $\text{LiCl}$ , in a mixture of chlorides. The commercial metal is 99.4% pure. Its salts burn with a crimson flame, and lithium chloride is used in pyrotechnics. Lithium is used for alloying with other metals. It hardens lead by the formation of a compound,  $\text{Pb}_3\text{Li}_2$ , and is used in small quantities in bearing metals. Lithium also hardens aluminum alloys. The metal has also been alloyed with beryllium. An alloy of 65% lithium and 35 beryllium is as light as water, but corrodes easily. By adding small quantities to aluminum or zinc, the hardness, strength, and resistance to corrosion are increased. The addition of as little as 0.025% to zinc will change it from a coarse-grained to a fine-grained metal.

Lithium salts are used in storage batteries to increase the electrical capacity. Lithium chloride,  $\text{LiCl}$ , is used in spray solution for dehumidifying air for industrial drying and for air conditioning, as it absorbs water rapidly. It is also used in welding fluxes for aluminum. Lithium hydride,  $\text{LiH}$ , a colorless to white powder of specific gravity 0.82 and melting point  $680^\circ\text{C}$ , is used for the production of hydrogen for emergency signal balloons. A 1-lb can of hydride when immersed in water will liberate 45 cu ft of hydrogen gas. Lithium metal is also used in light-sensitive control cells which depend on the change in resistance of the cell due to varying electron emission with changing light sensitivity. A form of the metal known as Lithium six,  $\text{Li}^6$ , consists of the light atoms and is a silvery-white metal of extreme lightness.

**Lithium alloys.** Lithium is soluble in most commercial metals. It is a powerful deoxidizer and desulphurizer of steel, but no lithium is left in the Lithium-treated steel. The steel, however, has increased elastic limit. In stainless steels it increases fluidity to produce dense castings. Cast iron treated with lithium has high impact value, a fine grain structure, and increased density. Not more than 0.01% lithium remains in the casting when treated with lithium copper. In magnesium alloys the tensile strength is increased 30% by the addition of 0.05% lithium. In Lithium-lead the lithium combines chemically and the solid solubility of lithium in lead is not over 0.09% lithium. The lead becomes harder and tougher, with a fine-grained structure and increased strength. The alloys are known as alkali lead.

Lithium-copper master alloys consist of a group of foundry alloys containing usually 90, 95, or 98% copper with the balance lithium, used for deoxidizing and degasifying nonferrous alloys. Lithium combines easily in the molten bath with oxygen, hydrogen, nitrogen, sulphur, and the halides. The compounds formed are stable, of a nonmetallic nature, of low melting points, and volatilize easily so as to pass off as vapors at the pouring temperature of the metals. Lithium copper is a high-conductivity, high-density copper containing a minute quantity of residual lithium, 0.005 to 0.008%, made by treating copper with a 50-50 lithium-calcium master alloy. The conductivity of lithium copper is 101.5% IACS. The tensile strength is 31,500 to 36,500 psi, with elongation 60 to 72%. The wrought metal is tougher than phosphorized copper, and has exceptional deep-drawing properties. The cast metal has a density of 8.92. Lithium is an excellent desulphurizer for nickel alloys. From 1 to 7% calcium may also be included in lithium-copper master alloys. Lithium-calcium alloys usually contain 30 or 50% lithium, with the balance calcium. They are silvery white in color, with a metallic luster, and are hard and brittle. The melting range is 230 to 260°C. They must be kept in tight containers under kerosene. The alloys are used for treating steel, cast iron, or nickel where no residual copper is to be left. Copper-manganese-lithium contains 60 to 70% copper, 27 to 30 manganese, 0.5 to 5 lithium, and sometimes 5 to 7 calcium. Copper-silicon-lithium contains 80 to 84% copper, 10 to 11 silicon, 2.5 to 10 lithium, and sometimes 2.5 calcium.

**Lithopone.** Also known under various trade names: Ponolith, Albalith, Sunolith, Beckton white, Zincolith, Sterling white, and others. A white pigment consisting of barium sulphate and zinc sulphide. A standard lithopone is 66% barium sulphate and 34 zinc sulphide. High-strength lithopones contain about 50% zinc sulphide, which latter is one of the whitest pigments. Titanated lithopone contains a percentage of titanium dioxide. Tidolith is a titanated lithopone of the United Color & Pigment Co. having 85% lithopone and 15 titanium oxide. Cadmolith is the trade name of the Glidden Co. for cadmium red and cadmium yellow lithopones used as pigments for plastics, as they are chemical-resistant and nonbleeding. Commercial lithopone is a fine white powder used in the manufacture of paints, inks, oilcloth, linoleum, and rubber goods. For paints the powder should pass through a 325-mesh screen. The ground paste should contain 76 to 80% pigment and 20 to 24 linseed oil. As a paint pigment, lithopone has good hiding power and is lower in cost than other whites, but is not as durable for outside use as white lead or zinc white. It is the most used white pigment for interior work. Albalith is a 70-30 lithopone of the New Jersey Zinc Co., also used in rubber goods, inks, and paper.

**Litmus.** A dyestuff prepared from several varieties of the lichen, *Variolaria*, chiefly *Rocella tinctoria*, by allowing them to ferment in the presence of ammonia and potassium carbonate. When completely fermented, the mass assumes a blue color and is mixed with chalk and made up into tablets, or made in paper form. It is used for dyeing textiles, staining wood, and coloring foods. Litmus gives a deep-blue color with alkalies and a red with acids, and is used as an indicator of acidity. Azolitmin,  $C_7H_7O_4N$ , is the coloring matter of litmus, and is a reddish-brown powder. Orchil, or Cudbear, is a red dye from another species. Litmus paper is paper treated with litmus marketed for acidity testing.

**Locust.** The wood of the locust tree, *Robinia pseudacacia*, also known as Acacia, False acacia, Black locust, and Red locust. The tree is native to North America, but is also grown in Europe. The wood is strong and durable, with a weight of 43 to 52 lb per cu ft. Its hardness is about the same as ash, and the strength, flexibility, and shock resistance are greater than oak. The grain is coarse, but the sur-

face is lustrous and satiny. Locust is used for furniture, wheel spokes, posts, crossies, and in construction. Honey locust is a lighter and weaker wood from the tree *Gleditsia triacanthos*. The name locust is also applied to the wood of the tree *Hymenaea courbaril* of tropical America. This wood has a brownish color, with an open grain, and takes a beautiful polish. The wood of the Australian locust, *Acacia melanoxylon*, known as Australian blackwood and Tasmanian blackwood, and employed for cabinetwork, is reddish brown to black in color and beautifully grained. It is similar in durability and appearance to rosewood, but lighter in weight. Various species of true acacia trees furnish the tannins catechu and wattle. The Silver wattle of New Zealand, *A. prominens*, used for ax handles and fruit cases, is hard and tough.

**Locust bean gum.** Also called Locust bean flour, and Carob flour. A tasteless and odorless white powder obtained by milling the bean kernels of the locust trees of tropical America, Africa, and the Mediterranean countries, notably *Cerafonia siliqua* of Cyprus, Syria, and Spain. The Carob bean, or pod, contains 6 to 10 hard seeds, which are the Locust beans, the beans in the pod averaging 9% of the weight. In Gambia the locust bean is called Netto. When dissolved in water and boiled, it produces an adhesive, transparent jelly, which dries into a colorless, strong elastic film. It is not a starch but is composed of galactan and mannan. It is used for coating textiles and also as a thickener and binder in glues, pastes, and latex, in leather finishes, and in sizings for yarn and paper. The flour is marketed in 50, 100, 150, and 175 mesh. It dissolves in cold water and swells in warm water. The flour is edible and is also used in jellies and in bakery products. The dried pods are used also in flavoring dog biscuit and tobacco. In the Near East they are eaten like candy, and are also used as cattle and horse feed. The pods also yield Tragacanth gum, which is used as a textile size and in leather tanning. The production of carob beans in Spain is large, and fully 90% of the crop is used locally for livestock feed. The Algaroba tree, *Prosopis chilensis*, growing in semiarid regions of Mexico, Central and South America, called also Mesquite, and in Hawaii called Keawe, furnishes an important stock feed from the pods and beans, which are similar to the locust. An acre of mesquite produces four times as much food

for beef cattle as an acre of corn. The wood of the mesquite also contains up to 10% pyrogallol tannin valuable for tanning leather.

**Logwood.** An extract obtained from the wood of the tree *Haematoxylon campechianum*, of tropical America, used as a black dye or as a darkening agent in browns and grays. The wood yields 15% extract. The coloring matter, Hematine,  $C_{16}H_{12}O_6$ , forms brownish-red crystals and is produced only in the aged wood or by oxidation of the white extract of fresh wood. Logwood, or Hematine, is marketed in crystals, solid extract, or water extract.

**Loofa sponge.** A yellowish, porous, skeletal, fibrous body obtained by retting the fruit or seed pods of the tropical edible cucumber, *Luffa cylindrica* and *L. acutangula*, obtained in India, Japan, and the Caribbean countries. It is also called Vegetable sponge, although it is harder and coarser than a sponge. The paper-thin skin is easily removed when the pod dries. The skinned sponge is washed to remove the slimy interior, and when redried the seeds are shaken out. The seeds are used to produce a food oil similar to olive oil but colorless and tasteless. The sponges vary in size from 8 to 24 in. long. The plants grow rapidly, giving four annual crops in Brazil, and a hill of 3 seeds can produce 300 sponges. Loofa sponges are used chiefly for filters in feed tanks of ships. A stiff curly fiber used for making hats is obtained from the product by further retting.

**Low-alloy steels.** Any steel that has small amounts of alloying elements below the normal amounts in standard alloy steels may be termed low-alloy, but the name has come to refer to steels with balanced proportions of alloying elements designed to give high strength while conserving chromium, nickel, and other strategic elements. A number of such steels classified during the war by the Iron & Steel Institute were designated as National emergency steels. They were primarily intended as a conservation measure to use alloy scrap directly in the mix, and the alloying elements were not uniform. But the advantages of these low-alloy steels for a wide range of use were so apparent that they were then made under controlled conditions to uniform specifications. Plain carbon steel hardens only near the surface, leaving the core soft and weak, but with the small amounts of alloying elements the hardening and strengthening effect is carried

deeper and distortion in heat-treating is reduced. Chromium and manganese are important in these steels. Both form hard carbides, and both are soluble in ferrite. Manganese is an austenite-forming element, and austenite is easily cold-worked. But with considerable manganese in steels where chromium is present, martensite and manganese carbide are formed and the steels have low ductility. Tensile strengths of 70,000 to 95,000 psi can be obtained with 1.25% manganese and 0.5 chromium, and low carbon, 0.10 to 0.20%. Such a steel is balanced when normalized, but for structural steels to be used in the as-rolled state about 0.75% silicon is added to balance the effect of rolling and cooling. Cromansil, with 1.25% manganese, 0.50 chromium, and 0.75 silicon, is typical of this class of high-strength, low-alloy structural steel. Typical of a balanced steel for carburized and heat-treated articles subject to heavy dynamic stress is one having 1.5% chromium, 1 manganese, 0.5 silicon, and 0.15 carbon. It can be heat-treated to a strength of 175,000 psi. Nickel is also added in low-alloy steels to balance the chromium and give high strength. Molybdenum also gives high-fatigue and -impact strength. A structural steel is N-A-X high-tensile steel, of the Great Lakes Steel Corp. A typical composition is carbon, 0.13%; manganese, 0.70; silicon, 0.80; copper, 0.23; chromium, 0.60; nickel, 0.15; molybdenum, 0.10; zirconium, 0.12. In structural shapes it has a tensile strength of 80,000 psi with elongation 24% and is resistant to fatigue. The N-A-X 9100 steels are in four grades with carbon from 0.08 to 0.70, including a high-tensile grade, a carburizing grade, a shallow-hardening and a deep-hardening grade. These contain small amounts of silicon, chromium, and zirconium, with sometimes a small amount of molybdenum. The minimum tensile strength of N-A-X 9112 steel, as rolled, is 75,000 psi with elongation 27%.

Small amounts of copper refine the grain and also give added corrosion resistance, especially when up to 0.20% phosphorus is present. Mayari R steel, of the Bethlehem Steel Co., is a low-alloy, high-strength, corrosion-resistant structural steel with tensile strength of 70,000 psi and elongation 22%. It contains 0.12% carbon, 0.50 to 1 manganese, 0.20 to 1 chromium, 0.25 to 0.75 nickel, 0.50 to 0.70 copper, and 0.05 to 0.50 silicon. Aldecor, of the Republic Steel Corp., is a high-strength structural steel containing 0.12% max carbon, 0.50 copper, 0.16 to 0.28 molybdenum, 0.35 to 0.75 silicon, and 0.15

to 0.40 manganese. Hi-Steel, of the Inland Steel Co., has 0.95 to 1.3% copper, 0.45 to 0.75 nickel, 0.08 to 0.18 molybdenum, 0.50 to 0.90 manganese, 0.12 to 0.27 aluminum, and 0.12 max carbon. The minimum tensile strength is 70,000 psi. A typical casehardening high-strength steel is Carpenter No. 872, which is a commercial adaptation of NE steel 8715. It contains 0.10% carbon, 0.80 manganese, 0.50 chromium, 0.50 nickel, and 0.22 molybdenum. When heat-treated, it has a tensile strength up to 130,000 psi, and elongation 18 to 25%. This steel with 0.45% carbon, Carpenter No. 874, when heat-treated, has a tensile strength from 115,000 to 225,000 psi, with elongation 10 to 24%, and Brinell hardness 235 to 444.

A typical Bolt steel used in the automotive industry contains 0.37% carbon, 0.90 manganese, 0.55 nickel, 0.50 chromium, and 0.20 molybdenum. NE steel 8630, for aircraft tubing, contains 0.40 to 0.70% nickel, 0.40 to 0.60 chromium, and 0.15 to 0.25 molybdenum. The tensile strength is 90,000 psi with elongation 35%. SAE steel X4340, used for aircraft engine crankshafts and connecting rods, contains 1.5 to 2% nickel, 0.60 to 0.90 chromium, and 0.20 to 0.30 molybdenum. The tensile strength of the heat-treated steel is 230,000 psi and elongation 12%. Otiscoloy, a low-alloy steel of the Otis Steel Co., has 0.90 to 1.25% manganese and only 0.08 to 0.12 carbon, with 0.30 copper, 0.10 nickel, 0.05 chromium, and 0.10 silicon. It has a minimum tensile strength of 70,000 psi, with elongation 25%. Its corrosion resistance is three times that of plain copper-bearing steel, and it is abrasion resistant.

**Low-expansion alloys.** Alloys, usually of nickel and iron, which have a very low coefficient of expansion at ordinary temperatures, used chiefly for instrument parts and for lead wires to be sealed in glass or other material. The alloy first developed in France under the name of Invar has an expansion so low for measuring purposes, under ordinary conditions, that it is generally taken as zero. This is about 0.000004 per deg C, but above 120°C the coefficient rises. Invar is used for the measuring guides of accurate instruments and for parts for watches. A typical composition is 63.5% iron, 36 nickel, 0.5 manganese, with sometimes 0.20 selenium to make it free-machining. Such an alloy is also very resistant to corrosion. Nivar is another alloy similar in composition. The tensile strength of Invar is 65,000 psi,

elongation 35%, and hardness 125 Brinell when annealed. The cold-drawn metal has a tensile strength of 90,000 psi, elongation 20%, and hardness 185 Brinell. Nivarox, a Swiss alloy for watch and clock springs of exceptional accuracy, has 37% nickel, 8 chromium, 54 iron, 0.85 manganese, 0.90 beryllium, 1 titanium, 0.20 silicon, and 0.10 carbon. Another Swiss alloy noted for corrosion resistance as well as high fatigue-resistance is Contracid. It has 60% nickel, 15 chromium, 7 molybdenum, 15 iron, 2 manganese, 0.5 silicon, and 0.5 to 0.75 beryllium.

Elinvar, used for chronometer balances and springs for gages and instruments, has low thermal expansion and almost invariable modulus of elasticity. Elinvar for hair springs for watches contains 33 to 35% nickel, 53 to 61 iron, 4 to 5 chromium, 1 to 3 tungsten, 0.5 to 2 manganese, 0.5 to 2 silicon, and 0.5 to 2 carbon. Elinvar Extra, of the Hamilton Watch Co., contains 42% nickel, 5.5 chromium, 2.5 titanium, about 0.5 each of manganese, aluminum, and silicon, 0.06 max carbon, and the balance iron. It is nonmagnetic, corrosion-resistant, and has low thermal expansion. A Watch spring alloy developed by the Elgin National Watch Co. under the name of Elgiloy, and called Octanium by the Parker Pen Co. when used for fountain-pen nibs, contains 40% cobalt, 20 chromium, 15.5 nickel, 15 iron, 7 molybdenum, 2 manganese, 0.15 carbon, and 0.03 beryllium. It is also used for rifle sear springs and for surgical instruments. It is nonmagnetic, corrosion-resistant, and fatigue-resistant. The tensile strength is 368,000 psi, with a Vickers hardness 700. Platinite, a French alloy with a coefficient of expansion about the same as that of glass, contains 46% nickel and 54 iron. It is used in light bulbs. Dilver and Adr are also French low-expansion, nickel-iron alloys. Super-Invar is a Japanese product containing 5% cobalt to replace an equal amount of nickel. It has a nearly zero coefficient of expansion at ordinary temperatures. Nilvar, of the Driver-Harris Co., used for instrument parts, measuring tapes, and connections through glass, is in various grades with about the same coefficient of expansion as glass or with the zero expansion of invar. Fernico, of the General Electric Co., is an alloy used for sealing vacuum tubes.

Low-expansion alloy 42, of the Carpenter Steel Co., is an invar with 42% nickel and 0.10 carbon, used for temperatures above 400°F. It has an electrical resistance of 430 ohms per cir mil ft. The



hot-rolled material has a tensile strength of 82,000 psi, and elongation 30%. It can be hardened by cold work to Rockwell B-102, with a tensile strength of 125,000 psi and elongation 3%. Dumet, of the Westinghouse Electric Corp., is a composite metal for lead-in wires for electric lamps and electronic tubes. It is made of a nickel-steel core with a thin coating of brass and an outer shell of copper tubing. This composite rod is then drawn into wire of diameters 0.010 to 0.040 in. The radial expansion is 0.000009 per deg C, which is close to that of soft glass. The tensile strength is up to 79,000 psi, with elongation 18 to 26%. Kovar, of the Stupakoff Ceramic & Mfg. Co., is an alloy of 29% nickel, 17 cobalt, 0.3 manganese, and the balance iron, having an expansion the same as that of heat-resistant glass for all temperatures up to the softening point of the glass. It is used for making gastight window assemblies, instrument and radio-tube sealing, and for metal attachments to glass. When the metal is heated to a red heat and applied to the glass, the metal oxide formed dissolves in the glass and gives a gastight seal. This alloy made in France contains no manganese. The other three metals are reduced from pure oxides, and the powdered metals are molded and sintered. Sealmet alloy, of the Allegheny Ludlum Steel Co., used for wire and strip to be attached directly to glass, contains 27% chromium and the balance iron.

**Lubricating grease.** Usually a compound of a mineral oil with a soap, employed for lubricating machinery where the speed is slow or where it would be difficult to retain a free-flowing oil. The soap is one that is made from animal or vegetable oils high in stearic, oleic, and palmitic acids. The lime soaps give water resistance, or a mineral soap may be added for this purpose. Aluminum stearate gives high film strength to the grease. All of these greases are more properly designated as Mineral lubricating grease. Originally, Grease for lubricating purposes was hog fat or the inedible grades of lard, varying in color from white to brown. Some of these true greases were stiffened with fillers of rosin, wax, or talc which were not good lubricants. The stiffness of such a grease should be obtained with a mineral soap. ASTM specifications for heavy journal bearing grease require 45% soap content. About 2% calcium benzoate increases the melting point. Mineral lubricating grease may contain from 80

to 90% mineral oil and the remainder a lime soap. Federal specifications prescribe 85% mineral oil.

Lime greases do not emulsify as readily as those made with a soda base, and are thus more suitable for use where water may be present. Hard grease flows at a temperature of about 90°C; medium grease flows at 75 to 80°C. Paraffin wax, sometimes added, is an adulterant and not a lubricant. Graphite grease contains 2 to 10% amorphous graphite, and is used for bearings, especially in damp places. Federal specifications call for 2 to 3% graphite. For large ball and roller bearings a low-lime grease is used, sometimes mixed with a small percentage of graphite. Cylinder grease is made of about 85% mineral oil or mineral grease and 15% tallow. Compounded greases are also marketed containing animal and vegetable oils, or are made with blown oils and compounded with mineral oils. The fatty acids in vegetable and animal oils, however, are likely to corrode metals. Tannin holds graphite in solution; in the gear grease sold under the name of Gredag by the Acheson Colloids a graphite-tannin mixture is used. Metaline, of the R. W. Rhoades Metaline Co., Inc., is a compound of powdered antifriction metal, oxide, and gums, which is packed in holes in the bearings to form self-lubricating bearings. Lead-Lube grease, of Knapp Mills, Inc., has finely powdered lead metal suspended in the grease for heavy-duty lubrication. Chemicals may be added to lubricating greases to retard oxidation, reduce the catalytic action of the bearing metals, and provide greater stability at high temperature. Ortholeum 300, marketed as a brown flaky powder by du Pont, is a mixture of complex amines, and small amounts added to a grease will give high heat stability.

Sett greases are mixtures of the calcium soaps of rosin acids with various grades of mineral oils. They are low-cost semisolid greases used for lubricating heavy gears or for greasing skidways. Clay fillers may be added to improve the film strength, or copper or lead powders may be incorporated for heavy load conditions. Solidified oil is also a name given to grease made from lubricating oil with a soda soap and tallow, used for heavy bearings. Cup grease is made with soda soap and light lubricating oils. Greases made with potash and soda soaps tend to form soap fibers when water is present. A metallic soap that contains no fibers is called a Neat soap, and gives a smooth grease. Greases made with lithium stearate have good water

and high temperature resistance, and have a buttery texture. Alrania grease of the Shell Oil Co. is a grease of this type. Fatty acids used for grease making may be hardened by hydrogenation to remove polyunsaturated acids. The greases have greater resistance to heat discoloration, and do not gum or become rancid. Lubrex 45, of W. C. Hardesty, Inc., is hardened fatty acids of this type. Slushing oil, for use in protecting machine parts from corrosion in shipping or storage, is usually a low-melting grease preferably compounded with a waxy fat such as lanolin. Paralan, of the American Lanolin Corp., is such a slushing oil having a lanolin base.

**Lubricating oils.** Oils used for lubricating the bearing parts of machinery. They are usually the heavy distillates following kerosene in the fractional distillation of petroleum, between the temperatures 253 and 317°F. They are separated into grades, light, medium, and heavy, depending upon the molecular weight. They are also classed as pale, when yellow to reddish, and dark, when brownish black in color. The flash points range from 300 to 600°F, and the specific gravities usually from 0.860 to 0.940. Neutral oils are light oils obtained by distillation without cracking, and they will not emulsify in contact with water as do the paraffin oils. They are thus desirable for crankcase lubrication and in circulating systems. Lubricating oils may be bleached with acid, and they may be mixed with vegetable or animal oils.

Animal oils are more greasy than mineral oils, but they are acid. Vegetable oils are greasy and have more oiliness, but they oxidize easily and are also acid. They are likely to gum in use unless an antioxidant is used. Vegetable and animal oils add the property of adhesion to the lubricating oil, but in no case should any element be added to an oil that will cause emulsification. Federal specifications for marine engine oil call for 15 to 20% blown refined rapeseed or peanut oil. This lubricating oil has a flash point of 350°F. Steam cylinder oil has 5 to 10% fatty acid vegetable oils, and the flash point is 450°F. Absorbed oil is a name of a combination oil of E. F. Houghton & Co. which acts as both film and lubricant. Amlo is a trade name of a mineral oil refined wax-free, used for low-temperature lubrication. Antioxidants used in oils to reduce oxidation and minimize sludging and acid formation are usually tin compounds

such as tin dioxide, tin tetraphenyl, and tin ricinoleate. Tin dust alone has also an inhibitory action. Tetraethyl lead is an effective antioxidant for high temperatures. High percentages of animal or vegetable oils may be added to lubricating oils for use on textile machinery. They are called Stainless oils for this purpose, since such oils wash out of the textile more easily than mineral oils. They also give lower coefficients of friction. The high lubricating qualities of the vegetable oils without the disadvantage of gumming can be obtained with mineral oils by the addition of an Oiliness agent such as the Cetyl piperidine ricinoleate patented by the Elgin National Watch Co. For extreme high pressure and high temperatures where oils and greases will oxidize, Molybdenum sulphide,  $\text{MoS}_2$ , is used alone or mixed with oils or silicones. It is a fine black powder which adheres strongly to metal surfaces, gives a low coefficient of friction, and will permit operation up to  $700^\circ\text{F}$ . Molykote, of the Alpha Corp., and Liqui-Moly, of the Lockrey Co., are molybdenum sulphide lubricants. Boron nitride, BN, a light fluffy white powder, is also used for the same purpose, but is more expensive.

Hydraulic fluids for the operation of presses must lubricate as well as carry the pressure, and they are mostly mineral oils, but chemicals are used where high temperatures are encountered such as in die-casting machines. Lindol HF-X, of the Celanese Corp. of America, is a flame-resistant hydraulic fluid with a tricresyl phosphate base. Skydrol, of the Monsanto Chemical Co., for aircraft hydraulic systems, is an oily ester produced from petroleum gas. The ignition point is  $1050^\circ\text{F}$ , and it will operate at temperatures as low as  $-40^\circ\text{F}$ . Refrigeration oils, for lubricating refrigerating machinery, are mineral oils refined to remove all moisture and wax. Ansul oil, of the Ansul Chemical Co., is an oil of this class which will remain stable at temperatures as low as  $-70^\circ\text{F}$ .

The nature of the bearing metals often has an effect upon the action of the lubricating oil. In highly alloyed metals some elements act as catalyzers to oxidize the oil, or the acids or moisture in the oils may act to break down the metal. In lead-bearing metals free magnesium causes disintegration of the lead in contact with moisture. The alkali-lead metals also tend to dissolve in contact with animal or fish oils. Normally, however, none of the white bearing metals are attacked by the animal and vegetable oils used for lubrication unless there are

perceptible amounts of a freely oxidizing element present. Graphite adds to the effectiveness of a lubricating oil and can be held in suspension with a tannin. Graphite lubricants are used where continuous lubrication is difficult, for running in, for springs, or for bearings where heavy films are desired. Oildag, of the Acheson Colloids Corp., is a graphite-tannin mixture in oil used for lubricating internal-combustion engines. Glydag, of this company, is a solution of 10% graphite in glycerin, used as a low-temperature lubricant, and Castordag is a 10% mixture of colloidal graphite in castor oil used for high-temperature conditions. Neolube, of Huron Industries, is colloidal graphite in alcohol, the alcohol evaporating to leave an adherent film of graphite on the bearing. Alfograf, of the Grafo Colloids Corp., is a similar colloidal dispersion for spraying on metals to give lubrication for deep drawing and forming. The silicones are now much used to replace lubricating oils for many applications, especially for very high or very low temperatures.

**Luminous paint.** Paints which when applied to a surface make that surface visible in the dark. They are used for road signs, watch hands, or signals. Luminous paints are of two types. The permanently luminous variety contains a radioactive substance, usually radiothorium or mesothorium. These are called Radioactive paints and obtain their energy from the decomposition of their radioactive pigment, though they may also contain a phosphorescent salt pigment. They are used on watch hands and for printing on instrument dial faces. Phosphorescent paints must obtain their energy from an outside source. They depend upon the ability of certain chemicals to absorb energy and to emit it again in the form of photons of light. This variety usually has a base of calcium, strontium, or barium sulphide with traces of other metal salts to improve luminosity, and the vehicle contains a moistureproof gum or oil. Temporary luminous paints may be visible for long periods after the activating light is withdrawn. A paint activated by 5 min of exposure to sunlight may absorb sufficient energy for 24 hr of luminosity. The Luminous wall paints used for operating rooms to eliminate shadows are made by mixing small amounts of zinc or cadmium sulphide into ordinary paints. After being activated with ultraviolet rays, they will give off light for an hour and a half.

Phosphorescent paints are lower in cost than radioactive paints, but are not as durable. They may be obtained in various colors. In general, the yellow and orange phosphorescent pigments are combinations of zinc and cadmium sulphides, the green is zinc sulphide, and the violet and blue pigments are combinations of calcium and strontium sulphides. They are marketed in powder form to be stirred into the paint or ink vehicle since mixing by grinding lowers the phosphorescence. The natural minerals are not used, as the pigments must be of a high degree of purity, as little as a millionth part of iron, cobalt, or nickel killing the luminosity of zinc sulphide. These phosphorescent pigments are called Phosphors, but technically they are incomplete phosphors, and copper, silver, or manganese are coprecipitated with the sulphide as activators or to change the color of the emitted light. The metals that are used as activators are called Phosphorogens, and their atoms diffuse into the lattice of the sulphide. For the manufacture of fluorescent screens the phosphors must have a rapid rate of extinguishment so that there will be no time lag in the appearance of the events. For television, electron microscope, and radar screens the phosphors must cease to glow  $\frac{1}{50}$  sec after withdrawal of excitation. They must also be of very minute particle size so as not to give a blurred image. For a white television screen, mixtures of blue zinc sulphide with silver and yellow zinc-beryllium silicates are used. For technicolor television the screen is completely covered with a mixture of various colored phosphors. Fluorescent fabrics for signal flags and luminescent clothing are impregnated with fluorescent chemicals which can be activated by an ultraviolet light that is not seen with the eye. Some Fluorescent paints contain a small amount of luminous pigment to increase the vividness of the color by absorbing the ultraviolet light and emitting it as visible color. Fluorescein, made from phthalic anhydride and resorcinol, has the property of fluorescence in a solvent. Since cellulose acetate will keep it in a permanently solvent state, acetate rayon is used as the carrier fabric. Signal panels are distinguishable from a plane at great heights even through a haze, and at night they give a brilliant glow when activated with ultraviolet light. Uranine, the sodium salt of fluorescein, is used by fliers to mark spots in the ocean. One pound of uranine will cover an acre of water to a brilliant yellowish green easily seen from the air. One part of uranine is detect-

able in 16 million parts of water. The Luminous plastic marketed by the U.S. Radium Corp. for aircraft markings is coated on the inside with radioactive material to give visibility in the dark. The Fluorescent plastic of the Rohm & Haas Co. is acrylic sheet containing a fluorescent dye. Lettering or designs cut into the sheet will glow brightly in the dark after exposure to light. It is used for direction signs and decorative panels. The Whitening agents used to increase the whiteness of paper and textiles are fluorescent materials that convert some of the ultraviolet of sunlight into visible light. The materials are colorless, but the additional light supplied is blue, and it neutralizes the brownish cast and enhances the whiteness. They were first developed in Germany and called Blankophors. Ultrasan, the first of the German blankophors, was a 1,3,5-triazine derivative. Luminous materials also occur in nature as organic compounds. The luminous material of the firefly, known as Luciferin, is a water-soluble protein.

**Lutes.** Adhesive substances, usually of earthy composition, employed for closing pipe joints or seams to make them tight, or for coating pipes or boilers to protect them from high temperatures. Various clays are used for this purpose, or sulphur, white lead, and oil. Plaster of paris mixed with a weak glue will withstand a dull-red heat. Fat lute is pipe clay mixed with linseed oil. Linseed meal with lime is also used. Many prepared compounds for this purpose are marketed under trade names. Spence's metal is the name of an old lute for pipe joining. It was made by introducing iron disulphide, zinc blende, and galena into melted sulphur. It melts at 320°F and expands on cooling. It makes a good cast joint which is resistant to water, acids, and alkalies. It is not a metal, but is a mixture of sulphur with metallic oxides. Sulphur cements, or lutes, usually have fillers of silica or carbon to improve the strength. They are poured at about 235°F. They form a class of acidproof cements used for ceramic pipe connections. The term lute also properly belongs to the class of adhesives used for sealing in wires in light bulbs, and sealing over connections in electrical apparatus. These lutes are usually compounds of sodium silicate with a filler, but they may also be compounds of mineral waxes or bitumen mixtures.

**Madder.** Formerly the most important dyestuff with the exception of indigo. It is now largely replaced by the synthetic mauve dye Alizarin, the manufacture of which from anthracene was patented in 1869 by Sir William Perkin. Madder was grown on a large scale in France and the Near East and was known by its Arabic name Alizari and by the name Turkey red. Madder is the ground root of the plant *Rubia tinctorum*, which has been stored for a time to develop the coloring matter, the orange-red Alizarin,  $C_{14}H_{18}O_4$ . Purpurin,  $C_{14}H_{18}O_5$ , is also developed, but this is now also produced synthetically. Madder gives fast colors. Madder lake is a pigment consisting of an inorganic powder colored with madder; Madder red is a lead pigment.

**Magnesite.** A white to bluish-gray mineral used in the manufacture of bricks for basic refractory furnace linings and as an ore of magnesium. The ground, burned magnesite is a light powder, is shaped into bricks at high pressure, and baked in kilns. Magnesite is a magnesium carbonate,  $MgCO_3$ , with some iron carbonate and ferric oxide. Magnesite releases carbon dioxide on heating, and forms Magnesia,  $MgO$ . When heated further it forms a crystalline structure known as Periclase, which has a melting point of  $5070^{\circ}F$  and specific gravity of 3.65. The mineral periclase occurs in nature but is rare. The product known as Deadburned magnesite is in the form of dense particles used for refractories. It is produced by calcining magnesite at a temperature of  $1450$  to  $1500^{\circ}C$ . Caustic magnesite is a product resulting from calcination at  $700$  to  $1200^{\circ}C$  which leaves from 2 to 7% carbon dioxide in the material and gives sufficient cementing properties for use as a refractory cement. Magnesium oxide, or magnesia, obtained by calcining magnesite, or dolomite, is put through a complex purifying process to obtain the fine white magnesia powder used in pharmaceuticals, cosmetics, in rubber as a scorch-resistant filler, in soaps to prevent shrinkage, and in printing inks to absorb grease. This Magnesia powder has a particle size of 0.5 micron and weighs 6 lb per cu ft. It requires 6.5 tons of dolomite to produce 1 ton of pure magnesium oxide.

Magnesite is sold on the basis of the  $MgO$  content. British India magnesite has 92.7% magnesia. Manchurian dead-burned magnesite



has 90.9% magnesia with 4 silica, and some iron oxide and aluminum oxide. Magnesite for use in producing magnesium metal should have at least 40%  $\text{MgO}$ , with not over 4.5%  $\text{CaO}$  and 2  $\text{FeO}$ . Brucite, a natural hydrated Magnesium oxide found in Ontario, contains a higher percentage of magnesia than ordinary magnesite and is used for furnace linings. Austrian magnesite has from 4 to 9% iron oxide, which gives it the property of fritting together more readily. Magnesite occurs in compact earthy forms, or in granular masses. The crystalline form is Breunnerite. Its hardness is 3.5 to 4.5, and its specific gravity is 3.1. It has a vitreous luster, and the color is white, gray, yellow, or brown. It fuses at  $2165^{\circ}\text{C}$ . The high-melting and softening points of magnesite and its chemical resistance make it a valuable refractory. The chief disadvantage is its low resistance to sudden temperature changes. The American production of crude magnesite is in Nevada, Washington, and California. Magnesite materials are usually sold under trade names. Magnesite is employed as an insulating covering for steam pipes. The pure magnesium carbonate is used in boiler compounds. Ritex is a magnesite brick having strong basic characteristics, which is marketed by the General Refractories Co. Magnesite is also used in Germany to produce the artificial stone known as Kunststein. Ramix is the name of a magnesite refractory of Basic Dolomite, Inc. Basifrit is a name given to impure Canadian magnesitic dolomite.

**Magnesium.** A silvery-white metal, symbol  $\text{Mg}$ , which is the lightest metal that is stable under ordinary conditions and produced in quantity. It is the sixth most abundant element, and is only 64% the weight of aluminum and 23% the weight of iron. By volume, 1 lb of magnesium produces five times as much rolled metal as 1 lb of copper. It was originally called Magnium by Sir Humphry Davy. The specific gravity is 1.74, melting point  $651^{\circ}\text{C}$ , and boiling point  $1120^{\circ}\text{C}$ . It has a tensile strength when cast of 14,000 psi. The rolled metal has a tensile strength of 25,000 psi, and elongation 4%. The strength is somewhat higher in the forged metal. Magnesium is too brittle to roll cold, but can be rolled at 300 to  $500^{\circ}\text{C}$ . It is the easiest to machine of the metals. Magnesium ingot is marketed 99.9% pure, but the metal is not ordinarily used alone. It is alloyed with aluminum and small amounts of other metals. Rolled sheet

magnesium for special purposes is made in thicknesses down to 0.005 in. Magnesium alloys are used for parts where lightness is needed, especially in transportation equipment. It is also a major constituent in many aluminum light alloys. It cannot safely be used for parts that are to be subjected to temperatures above 450°F. Because of its sound-damping characteristics it is valued for diaphragms, speaker cones, and resonators. It is immune to attack by alkalies, is resistant to sea water, and is thus used for many marine parts. For better corrosion resistance, magnesium alloy parts are given a thin zinc coating by dipping in a solution of pyrophosphate zinc before plating or painting. Because of its close-packed hexagonal crystal structure, the thin metal can be drawn in dies without folding and wrinkling. When heated to 450°F the metal is plastic and draws easily. Thinstrip magnesium, of the Burgess Battery Co., is commercially pure magnesium sheet in thicknesses from 0.005 to 0.010 in. for die forming and for paneling. One pound of the 0.005-in. sheet will cover 22.2 sq ft.

Magnesium alloys with most of the common metals except those in the iron and chromium groups. The pure metal ignites easily, and even when alloyed with other metals the fine chips must be guarded against fire. In alloying, it cannot be mixed directly into molten metals because of flashing, but is used in the form of master alloys. The metal is not very fluid just above its melting point, and casting is done at temperatures considerably above the melting point so that there is danger of burning and formation of oxides. A small amount of beryllium added to magnesium alloys reduces the tendency of the molten metal to oxidize and burn. The solubility of beryllium in magnesium is only about 0.05%. As little as 0.001% lithium also reduces fire risk in melting and working the metal. Lithium and cerium also increase the strength of the alloys. Molten magnesium decomposes water so that greensand molds cannot be used, as explosive hydrogen gas is liberated. For the same reason water sprays cannot be used to extinguish magnesium fires. The affinity of magnesium for oxygen, however, makes the metal a good deoxidizer in the casting of other metals. Flashlight powder is also made of magnesium, and the powder is also used in flares and fireworks.

Magnesium is produced commercially by the electrolysis of a fused chloride or fluoride obtained either from brine or from a mineral

ore, or it can be vaporized from some ores. Much of the magnesium produced in the United States is from brine wells of Michigan, which brine contains 3%  $\text{MgCl}_2$ , and from sea water. From sea water the magnesium hydroxide is precipitated, filtered, and treated with hydrochloric acid to obtain a solution of magnesium chloride from which the metal is obtained by electrolysis. The magnesium ion content of sea water is 1,270 parts per million. One cubic mile of sea water contains 12 million pounds of magnesium, and 2.56 lb is obtained per ton of water. Magnesium is also obtained from dolomite by extracting the oxide by reacting the burned dolomite with crushed ferrosilicon in a sealed retort under vacuum. The dolomite of Ohio averages 20% magnesium oxide, and the metal is obtained 99.98% pure in a solid, dense, crystalline mass which is then melted with a flux and poured into ingots. Magnesium metal and ferrosilicon are produced from the olivine of Washington state. In Russia, magnesium is produced from the mineral carnallite. In Germany it is produced from dolomite, carnallite, magnesite, and from the end lyes of the potash industry. The metal can also be produced from serpentine, olivine, and other siliceous ores by heating the powdered ore in a vacuum retort and driving off the metal as a vapor which is condensed to the pure metal.

**Magnesium alloy.** An alloy of magnesium, usually with aluminum, noted for extreme lightness, the specific gravity seldom exceeding 1.83. In general the magnesium alloys have a strength-weight factor 14 times that of steel. The alloys are easily machined and have a higher stiffness factor than aluminum, and they are used for aircraft engine parts, pistons, propellers, and structural shapes, where weight saving is an important factor, or where light reciprocating parts are required. Wrought alloys usually contain aluminum and manganese; forgings contain aluminum, manganese, and zinc; and die-casting alloys contain aluminum, manganese, and silicon. Aluminum up to 8% refines the grain, increasing hardness, strength, and rigidity; with higher percentages the alloys become brittle. Zinc has a somewhat similar effect. Small amounts of manganese give added corrosion resistance and high strength. Some alloys with no aluminum have as high as 1.5% manganese. Cadmium improves the physical properties of the casting and extruding alloys. Copper softens but weakens

the structure. The ASTM designates magnesium alloys with the initial letters of the alloying elements and numbers indicating the approximate percentages. Thus, Magnesium alloy AZ31 contains 3% aluminum and 1 zinc.

Alloy AM240, of the Aluminum Co. of America, has 9 to 11% aluminum and 0.10 manganese. It is for sand and permanent-mold castings, and has a tensile strength of 20,000 psi with elongation 2%. Alloy AM403, for sand castings, has 1.2 to 2% manganese with no aluminum. The tensile strength is 14,000 psi and elongation 5%. This alloy in hot-rolled sheet or extruded bar has a tensile strength of 34,000 psi. Revere alloy M, of the Revere Copper & Brass, Inc., is this metal. Revere alloy JS-1 for sheet plate has 5% aluminum, 1 zinc, and 0.25 manganese. The tensile strength is 40,000 to 47,000 psi, elongation 10 to 18%. This is AN-M-28 alloy in U.S. Government aeronautical specifications. Alloy AM74S, for forgings, has 2.5 to 3.5% aluminum, 0.2 manganese, and 2.5 to 3.5 zinc. When aged it has a tensile strength of 42,000 psi and elongation 14%. Eclipsealloy 56, of the Eclipse-Pioneer Div., Bendix Aviation Corp., contains 8.3 to 9.7% aluminum, 1.7 to 2.3 zinc, 0.30 max silicon, 0.10 max manganese, 0.05 max copper, 0.01 max nickel, and the balance magnesium. It has a tensile strength up to 34,000 psi, elongation 6%, and Brinell hardness 50 to 70. Eclipsealloy 15A has less aluminum and up to 3.5% zinc, and has higher strength. Dowmetal B has 12% aluminum. Dowmetal F has 4% aluminum and 0.3 manganese. In extruded rod it has a tensile strength up to 42,000 psi. The British Air Ministry specification of Electron calls for 1.3 to 1.7% manganese and the remainder magnesium. Dowmetal M has this composition, with tensile strength of 45,000 psi.

The German alloy Elektron has 9 to 11% aluminum, 4 zinc, and up to 2.5 manganese. Zinc gives good salt-water resistance, but when the zinc is high the alloys do not cast easily, as they are hot-short and have a narrow temperature pouring range. Alloys containing 6% aluminum, 3 zinc, and small amounts of manganese have good salt-water resistance. They have tensile strengths, as cast, up to 30,000 psi, which by heat-treatment can be increased to 42,000 psi, with added hardness up to 70 Brinell. Dowmetal H, of the Dow Chemical Co., and Mazlo alloy AM265, of the Aluminum Co. of America, are of this type. Dow alloy No. 251, for sheet, has 5% aluminum and 1

zinc. It is tough and ductile. Alloy AZ-63, of the Dow Chemical Co., has 5.3 to 6.7% aluminum, 2.5 to 3.5 zinc, and 0.15 manganese. The heat-treated castings have a tensile strength of 39,000 psi and elongation 8%. ASTM alloy A231X, for sheets and extrusions, has 2.5 to 3.5% aluminum, 0.6 to 1.4 zinc, and 0.20 manganese. The tensile strength is 39,000 psi, elongation 12 to 18%, and Brinell hardness 50. ASTM alloy AZ80X, for forgings, has 9.2% aluminum, 0.4 to 1.5 zinc, and 0.12 manganese with slight amounts of silicon, copper, and nickel. Heat-treated forgings have a tensile strength of 48,000 psi with elongation 7%. The forging alloy, ASTM alloy TA54, has 3.5% aluminum, 5 tin, and 0.20 manganese. The tensile strength is 40,000 psi, elongation 12%, and Brinell hardness 52. High amounts of magnesium are used in some aluminum alloys stabilized and strengthened with beryllium and boron. Almag 55, of the Acme Aluminum Alloys, Inc., has 11% magnesium, 0.5 beryllium, and 0.4 boron. The tensile strength, cast, is 55,000 psi.

Magnesium-zinc alloys may have small amounts of zirconium or other element to refine the grain. Dowmetal ZK60A, of the Dow Chemical Co., with 6% zinc, 0.6 zirconium, and no aluminum, has a small grain size and has good shock resistance and fatigue properties. The tensile strength of the extruded alloy is 51,000 psi with elongation of 11%. The extruding and forging alloy Elektron ZZ contains 0.5 to 1% zirconium, 1 to 5 zinc, and up to 4 cadmium. It has a fine grain. In these alloys pure metals are used to keep the iron content low for better corrosion resistance. Dowmetal EK30, used for high-temperature applications, contains 3% rare-earth metals introduced as misch metal, and also 0.2% zirconium to refine the grain and lower the hot-cracking tendencies. At 400°F the tensile strength is 20,000 psi and elongation 13%. Magnesium alloy EM51, for aircraft engine parts, has 5% cerium metals and 1.2 manganese.

**Magnesium carbonate.** A white, insoluble powder of the composition  $\text{MgCO}_3$ , containing also water of crystallization. The specific gravity is 3.10. It is made by calcining dolomite with coke, slaking with water, saturating with carbonic acid gas, and crystallizing out the magnesium carbonate. It is employed as an insulating covering for steam pipes and furnaces, for making oxychloride cement, in boiler

compounds, and as a filler for rubber and paper. Montax, of the R. T. Vanderbilt Co., used as a filler, is a mixture of hydrated magnesium carbonate and silica powder. Magnesium carbonate is a good heat insulator because of the great number of microscopic dead-air cells in the material. As an insulating pipe covering it is usually mixed with asbestos fibers to give structural strength. Federal specifications for magnesia call for the hydrated magnesium carbonate,  $4\text{MgCO}_3 \cdot \text{Mg}(\text{OH})_2 \cdot 5\text{H}_2\text{O}$ , combined with 10% asbestos fibers, for use in heat-insulating blocks. The hydrated carbonate is a fine white powder called Magnesia alba levis, slightly soluble in water, and used in medicine.

**Magnesium-nickel.** An alloy of magnesium and nickel used for adding nickel to magnesium alloys and for deoxidizing nickel and nickel alloys. A magnesium-nickel marketed by Alloys & Products, Inc., contains about 50% of each metal, is silvery white in color, and is furnished in round bar form. Magnesium-monel made by the same company contains 50% magnesium and 50 monel metal. Alloys of magnesium with nickel, monel, zinc, copper, or aluminum, used for deoxidizing and cleaning nonferrous metals, are called Stabilizer alloys.

**Magnesium powder.** A fine powder for pyrotechnic and chemical uses, made by reducing metallic magnesium into particles in the shape of curly shavings to give maximum surface per unit of weight. It is produced in four grades: Cutting powder, Standard powder, Special specification, and Fireworks powder. Cutting powder is finely cut shavings in a matted condition, made from magnesium of 99.8% purity. Standard powder is loose powder in fineness from 10 to 200 mesh. Fireworks powder is 100 mesh. The speed of ignition increases rapidly with decreasing particle size. A 200-mesh powder is used for Flashlight powder, and a 30- to 80-mesh for more slowly burning flares. For flares, magnesium gives a brilliant light of high actinic value. Incendiary powder, for small-arms incendiary ammunition, is magnesium powder mixed with barium peroxide. Ophorite is an English name for magnesium powder and potassium perchlorate used as an igniter for incendiaries. The material known as Goop, used in block-burner bombs, is a rubbery mixture containing magnesium powder coated with asphalt, gasoline, and chemicals.

**Magnesium sulphate.** A colorless to white, bitter-tasting material occurring in sparkling needle-shaped crystals of the composition  $\text{MgSO}_4 \cdot 7\text{H}_2\text{O}$ . The natural mineral is called Epsomite, from Epsom Spa, Surrey, England. In medicine it is called Epsom salt. It is used in leather tanning, as a mordant in dyeing and printing textiles, as a filler for cotton cloth, for sizing paper, in water-resistant and fire-proof magnesia cements, and as a laxative. It can also be obtained in the anhydrous form,  $\text{MgSO}_4$ , as a white powder. The specific gravity of the hydrous material is 1.678, and of the anhydrous 2.65. It occurs naturally as deposits from spring waters, and is also made by treating magnesite with sulphuric acid. In Germany it is produced from the mineral Kieserite,  $\text{MgSO}_4 \cdot \text{H}_2\text{O}$ , which is abundant in the Strassfurt district, and is used as a source of sulphuric acid and magnesium. The magnesium sulphate from the waters at Seidlitz, Bohemia, was called Seidlitz salt, but Seidlitz powder is now a combination of rochelle salt and sodium bicarbonate. Synthetic kieserite is made from the olivine of North Carolina. The mineral Langbeinite, found in the potash deposits at Carlsbad, N.M., is a potassium-magnesium-sulphate, containing 22% potassium oxide and 18 magnesia, and is used in the production of potassium sulphate and magnesium metal. The crude langbeinite with the halite and clay washed out is called Sulpomag.

**Magnet steels.** Steels employed for making permanent magnets, that is, magnets that retain their magnetism after they are removed from the magnetic field, as distinct from electromagnets, which are of soft iron and are magnetized only while in the magnetic field. Most of the metals are not true steels, and are more properly termed Magnet alloys. Magnet steels were originally good grades of crucible tungsten steel, sometimes containing chromium and manganese. Tungsten magnet steels contain 5 to 6% tungsten and about 0.65 carbon. They can be hot-forged, and machined when annealed. They are hardened in water without drawing the temper. They are then aged by heating in oil at a temperature of about 250°F, and afterward placed in a vibrating device. With increased carbon the coercive force increases, but the maximum induction and the residual magnetism decrease. Molybdenum may be used instead of tungsten in magnet steels. Molybdenum-iron magnet alloys have been made with

20% or more of molybdenum having high residual magnetism and high coercive force.

Chromium magnet steels are less expensive, and contain up to 5% chromium, usually 3, and about 1 carbon. A standard grade contains 2.25 to 4% chromium, 0.45 manganese, and 0.95 carbon. The magnetic properties are similar to those of the tungsten steels, and they have the same difficulty in hardening because of breakage when the carbon is high. Cobalt magnet steels contain from 18 to 60% cobalt, part of which may be replaced by the less expensive chromium, or some tungsten may be used. Some cobalt magnet steels contain 1.5 to 3% chromium, 3 to 5 tungsten, 0.50 to 0.80 carbon, with high cobalt. A Japanese alloy, KS magnet steel, contained 30 to 40% cobalt, 5 to 9 tungsten, 1.5 to 3 chromium, and 0.4 to 0.8 carbon. The coercive force of this alloy is about three times that of a 5% tungsten steel. The Alfer magnet alloys, used in Japan during the shortage of nickel and cobalt, were Iron-aluminum alloys. Oerstit 400, used by the Germans during the Second World War because it gave high coercive force in proportion to weight, contained 22% cobalt, 16 nickel, 8 aluminum, 4 copper, and the remainder iron. An Alnico sintered alloy of the General Electric Co. for small magnets has a somewhat similar composition, with 25% cobalt, 14 nickel, 8 aluminum, 1 titanium, and 49 iron. It has high tensile strength and a minimum coercive force of 575 oersteds. A cobalt alloy containing 36% cobalt, 3.5 carbon, with the balance iron, is hard and strong, can be hot-forged, and can be machined when annealed. Its coercive force is 210 compared with 70 for the 5% tungsten steel with 1 carbon. A nonferrous magnet alloy contains 41% cobalt, 24 nickel, and 35 copper. It has a coercive force of 440. It is ductile and can be cold-rolled. Cobalt steel and cobalt-chromium magnet steel may contain molybdenum, which gives them air-hardening properties. A magnet alloy marketed by the General Electric Co. under the name of Comol contains 12% cobalt, 17 molybdenum, and 71 iron. The coercive force is 245. It can be cast to shape or hot-forged. Vectolite is a lightweight magnet of the Indiana Steel Products Co. made by molding and sintering ferric and ferrous oxides and cobalt oxide. The weight is 0.114 lb per cu in. It has high coercive force, and has such high electrical resistance that it may be considered as a nonconductor. It is very brittle, and is finished by grinding. Ferro-



cube, of the Philips Laboratories, Inc., is a similar material. Armat is a magnet steel of the Jessop Steel Co. Tuncro, of the Allegheny Ludlum Steel Co., is a tungsten-chromium magnet steel. Alnico, of the General Electric Co., is an aluminum-nickel-cobalt-iron alloy in which precipitation hardening occurs with AlNi crystals dissolved in the metal. Alnico I contains 63% iron, 20 nickel, 12 aluminum, and 5 cobalt. The alloy is cast to shape as it is hard and brittle and cannot be reworked. The coercive force is 400. Alnico IV contains 12% aluminum, 28 nickel, 5 cobalt, and the balance iron. It has a coercive force of 700, or 10 times that of a plain 5% tungsten magnet steel. Alnico V has the AlNi crystals aligned in the direction of magnetization to give greater coercive force and to give rapid demagnetization.

**Mahogany.** A name applied to a variety of woods. All of the true mahogany, however, comes from trees of the family *Meliaceae*, but of various genera and species. The tropical cedars, Spanish cedar and Paraguayan cedar, belong to this family. Mahogany, of the tree *Swietenia mahogani*, and other species of *Swietenia*, is obtained from Mexico to as far south as northern Argentina. The Central American has the best reputation and is frequently referred to under the Spanish name Caoba. The mahogany from Cuba and Santo Domingo has a close grain and beautiful color and is valued for furniture. The so-called Horseflesh mahogany from Cuba is from the Sabicu tree. Baywood is an English name originally applied to a superior, straight-grained mahogany from the shores of the Bay of Honduras. Colombian mahogany is the wood of the tree *Cariniana pyriformis* of northern South America. It resembles mahogany but is heavier and harder.

The wood of the mahogany tree is obtainable in large logs. It has a reddish color of various shades. The grain is often figured, and it has a high luster when polished. It seasons well and is much prized for furniture and cabinetwork. It is often used for small patterns in foundry work where they must be employed frequently and should not alter in shape. The cheaper grades are used for this purpose. The weight varies from 32 to 42 lb per cu ft. The hardness and closeness of the different mahoganies also vary considerably. The beautiful curled-grain specimens are from selected forks or crotches of the trees.

The various species of mahogany formerly used for airplane propellers were either African *Khaya* or American *Swietenia*, with average specific gravities kiln-dried of 0.47 to 0.51. The compressive strength is up to 1,760 psi perpendicular to the grain, and the shearing strength 860 psi parallel to the grain. The *Swietenia* is used for small naval boats and for trim on large boats. Australian red mahogany is from the tree *Eucalyptus resinifera* of Australia. It is hard, durable, of a dark-red color, with a coarse, open grain. Crabwood, used as a substitute for mahogany, is the wood of the *Carapa* tree, *Carapa guianensis*, of Brazil and the Guianas. It has a deep reddish-brown color with a coarse grain and weighs 40 lb per cu ft. This tree produces the seed nuts from which Carapa fat is pressed, used for soap, candles, and as an edible fat. Oleo vermelho, from the tree *Myrospermum erythoxylum* of Brazil, is a fine-grained reddish cabinet wood similar to mahogany. The specific gravity is 0.954. It has an agreeable odor. Cameroon mahogany is from the tree *Bassia toxisperma* of West Africa. The kernels of the nuts of the tree yield about 60% of a yellowish-white semisolid oil known as Djave butter, or Adjab butter, used in Europe for soapmaking. It is used locally for food by steaming off the traces of hydrocyanic acid.

**Malleable iron.** A high-tensile-strength white cast iron produced by a long heat-treatment of white chilled castings. Iron for malleable iron is usually melted in the reverberatory furnace, which gives it greater strength and ductility than iron melted in the cupola in contact with the fuel. The iron contains 1 to 1.5% silicon and is cooled rapidly to produce white iron. The castings seldom exceed 10 lb in weight. After casting, the parts are packed in annealing pots with hammer scale or mill scale, or oxidized turnings or borings, and subjected to an increasing temperature to about 1650°F, for a period of 48 to 60 hr. They are then cooled slowly with temperature decreasing 8 to 10°F per hr to below 1275°F. The resulting iron has the carbon in regular tiny particles instead of flakes as in gray cast iron. With high annealing temperatures and a long annealing period the total carbon is reduced in the shell, resulting in a coarse-grained casting known as Whiteheart which has reduced strength. The ordinary American malleable iron called Blackheart has a white shell and a dark core, the outside being completely decarbonized. Slight

additions of copper accelerate the annealing of blackheart iron. An iron known as Quick malleable iron, used for automotive engine castings, has 2.2% carbon, 1.5 silicon, 0.30 to 0.60 manganese, and 0.75 to 1 copper. The copper also increases the tensile strength. For ease of machining, malleable iron normally should have 2.60% or more of carbon, although less carbon is desirable for strength and ductility. An average composition is carbon, 2%; silicon, 0.60 to 1.10; manganese, under 0.30; phosphorus, under 0.20; and sulphur, 0.06 to 0.15. About 1% copper is used for corrosion-resistant castings.

Malleable iron is used for castings for implements, pipe fittings, building hardware, and small machine parts, requiring strength. The tensile strength is about 50,000 psi, elongation 15%, and Brinell hardness 115. Federal specifications call for two grades, with strengths of 50,000 and 53,000 psi. Modern Pearlitic malleable iron, with a matrix of pearlite and temper carbon, may have tensile strengths about 100,000 psi with elongation 5%, and Brinell hardness 250. It is made by giving special heat-treatment to arrest graphitization, or to recombine some of the carbon. Chromium gives a stabilizing effect. Other alloying elements used are manganese and molybdenum in small quantities. Malleable irons are sold under trade names. Certified malleable iron, of the Erie Malleable Iron Co., has a tensile strength up to 57,000 psi and hardness up to 120 Brinell. Promal is a specially processed malleable iron of the Link-Belt Co., used for chain links. The hardness is up to 170 Brinell, and it has high fatigue resistance. Supermal, of the Jeffrey Mfg. Co., is a similar type of iron. Flecto iron, of the Ohio Brass Co., is a malleable iron specially annealed to prevent brittleness when hot-galvanized. Z-metal, of the Ferrous Metals Corp., used for pump and chemical machine parts, has 2 to 2.6% total carbon, with 0.30 to 0.80 combined carbon, 0.90 to 1.10 silicon, and 0.75 to 1.25 manganese. It has a tensile strength of 70,000 psi, elongation 8 to 18%, and hardness 180 Brinell. It is a pearlitic malleable iron. Cu-Z metal contains also about 1% copper. Another grade with copper and molybdenum has higher strength, ductility, and fine grain with high density. Belmalloy is the trade name of an electric-melted pearlitic malleable iron.

The Shock-Proof iron of the Lake City Malleable Co. has 2.35 to 2.55% carbon, 1.1 to 1.35 silicon, 0.3 to 0.55 manganese, 0.16 max phosphorus, and 0.16 max sulphur. Castings have a tensile strength of 70,000 psi, elongation 5%, and Brinell hardness to 217, or the more ductile castings have a tensile strength of 53,000 psi, elongation 18%, and Brinell hardness to 135. Austenitic cast iron used by the American Cast Iron Pipe Co. contains 2.3% total carbon, 2 silicon, 1.25 manganese, 15 nickel, 6 copper, 3 chromium, 0.10 max phosphorus, and 0.12 max sulphur. It is chill-cast to produce a white iron, and then annealed to decompose the combined carbon. The castings have a tensile strength of 70,000 psi and Brinell hardness up to 200. They are tough and corrosion-resistant.

**Manganese.** A metallic element, symbol Mn, found in the minerals manganite, pyrolusite, and others, with most iron ores and traces in most rocks. Manganese has a silvery-white color with purplish shades. It is very brittle. Distilled manganese, with no iron, and with carbon and silicon not over 0.006% total, has a fine silvery-gray luster very resistant to corrosion. It is brittle but hard enough to scratch glass. The specific gravity is 7.42, melting point 2237°F, and weight 0.268 lb per cu in. Manganese is used in the steel industry as a deoxidizer and as a hardener, and nearly all steel now contains some manganese. For this purpose it is used largely in the form of ferromanganese. More than 80% of the manganese charged into an open-hearth furnace for making ordinary steel goes off in the slag. American practice is to use manganese almost exclusively for deoxidizing steel, an average of 14 lb metallic manganese being used per ton of steel produced in the United States. But alkalies have been used in Germany for deoxidizing steel, and lithium is also an effective deoxidizer for steel. Manganese is also added to steel in considerable amounts for the production of wear-resistant alloy steels. Manganese metal, for adding manganese to nonferrous alloys, is marketed in crushed form containing 95 to 98% manganese, 2 to 3 max iron, 1 max silicon, and 0.25 max carbon. Special grades of manganese ores are used for electric dry batteries and for making chemicals.

Electro manganese, or Electrolytic manganese, is produced from low-grade ores by the electrolytic process and is 99.9% pure metal, with not more than 0.1% sulphur and iron. It comes in cathode

chips  $\frac{1}{8}$  in. thick, up to 1 sq in. in size. Manganese powder is powdered metal of high purity, of 150 to 325 mesh, employed for pyrotechnic and metallurgical uses. Manganese tablets, for use in steelmaking, are made by pressing electrolytically reduced powder in an inert atmosphere and then coating the tablets with ammonium chloride to prevent oxidation.

**Manganese alloy.** A series of nonferrous alloys containing manganese, copper, and nickel. They can be forged readily and machined, and then age-hardened at 500 to 1000°F to a hardness of 400 to 500 Brinell with tensile strengths of 200,000 psi and high wear resistance. Chace alloy No. 720, of the W. M. Chace Co., contains 60% copper, 20 manganese, and 20 nickel. It is soft and ductile, but can be hardened to 400 Vickers. The tensile strength of the forged metal varies from 98,000 to 220,000 psi depending upon the hardness. The specific gravity is 8.25. It is used for high-strength, corrosion-resistant parts and for springs. Wyndaloy 720, of the Wyndale Mfg. Co., is this metal in forgings. These alloys are also noted for their high electrical resistivity, the 20% manganese alloy having a resistivity of 300 to 500 ohms per cir mil ft, and a conductivity of only 2 to 3.5% IACS. It is thus used for resistor wire and strip. A high-manganese alloy used for rheostat resistors and electrically heated expansion elements is Chace alloy No. 772. It contains 72% manganese, 18 copper, and 10 nickel. It can be machined, drawn, and stamped. The cold-rolled metal has a hardness of 220 Vickers and a tensile strength of 115,000 psi, with elongation 6.5%. It is non-magnetic, has a heat conductivity of only 12% that of steel, and a vibration damping constant 25 times that of steel. The electrical resistivity is 1,050 ohms per cir mil ft. Manganese alloy resistor wire is produced by the Driver-Harris Co.

**Manganese-aluminum.** A Hardener alloy employed for making additions of manganese to aluminum alloys such as Duralumin. Manganese lowers the thermal conductivity of aluminum but increases the strength and increases the contraction. Manganese up to 1.5% is used in aluminum alloys when strength and stiffness are required. A manganese-aluminum marketed by the Niagara Falls Smelting & Refining Corp. contains 25% manganese and 75 aluminum. The Manganese-aluminum of the Electro Manganese Corp.

has 92% aluminum and 8 manganese. With high manganese aluminum alloy is brittle. Manganese-boron is another hardener alloy used for deoxidizing and hardening bronzes. It contains 20 to 25% boron, with small amounts of iron, silicon, and aluminum. For deoxidizing and hardening brasses, nickel bronze, and cupronickel, Manganese copper, or Copper manganese, may be used. The alloys used contain 25 to 30% manganese and the balance copper. The best grades of manganese copper are made from metallic manganese and are free from iron. For nickel bronzes and nickel alloys the manganese copper must be free of both iron and carbon, but grades containing up to 5% iron can be used for manganese bronze. Grades made from ferromanganese contain iron. Manganese copper is usually marketed in slabs with notched sections, or as shot. It has a lower melting point than metallic manganese and is thus more easily dissolved in the brass or bronze. The 30% alloy melts at about 1600°F.

**Manganese bronze.** A brass containing iron and manganese which, because of its hardness and crystalline structure, is called a bronze. It casts easier than aluminum bronze and is used for propeller blades, valve stems, engine frames, and machinery parts requiring high strength and resistance to sea water. Manganese is a deoxidizer in the alloys, but in excess, usually up to 3.5%, it hardens and strengthens the alloy, increases the solubility of the iron in the brass, and acts to stabilize the aluminum when this metal is used. Manganese has nearly the whitening power of nickel in copper alloys. Turbadium bronze was an old name used by the British Admiralty for manganese bronze containing 50% copper, 44 zinc, 1 iron, 1.75 manganese, 2 nickel, and 0.5 tin, used for casting propellers and marine parts. The original Turbiston's bronze contained 55% copper, 41 zinc, 1 aluminum, 2 nickel, and 1 iron. ASTM and Federal specifications for manganese bronze call for 55 to 60% copper, 38 to 42 zinc, up to 3.5 manganese, up to 1.5 tin, 1.5 aluminum, and up to 2 iron. This alloy has a minimum tensile strength of 65,000 psi and elongation 30% as cast; the wrought metal has a strength of 72,000 psi. Even very small amounts of lead decrease the strength of manganese bronze and lower the ductility. Phosphor copper is sometimes added to make the metal easier pouring. The most popular manganese bronze in the automotive and aviation industries for castings contains

little manganese. It has 57% copper, 40.5 zinc, 1 aluminum, 1 iron, and 0.5 manganese. It is tough and wear-resistant, and has a tensile strength of 65,000 psi min. Manganese bronze has high shrinkage,  $\frac{3}{16}$  in. per ft, and large fillets are necessary between changes in section thickness.

A Super manganese bronze, used for aircraft engine parts, contains 69% copper, 20 zinc, 2 manganese, 2.5 iron, and 6.5 aluminum. It has a tensile strength of 110,000 psi and Brinell hardness 225 when heat-treated. A Manganese-aluminum brass, under the name of Hy-Ten-SI, marketed by the American Manganese Bronze Co., contains 66% copper, 19 zinc, 10 aluminum, and 5 manganese. The castings have a tensile strength up to 105,000 psi, elongation 15%, and Brinell hardness 175. It is also made in wrought forms. The alloys known as Manganese casting brass are usually muntz metal containing a small amount of manganese. The original manganese brass patented in 1876 under the name of Parsons' alloy, contained 56% copper, 41.5 zinc, 1.2 iron, 0.7 tin, 0.1 manganese, and 0.46 aluminum. An alloy used by one automotive company has 58% copper, 40 zinc, and 2 of a master alloy consisting of tin, iron, manganese, and aluminum. The lead content is not permitted to exceed 0.15%. The tensile strength is 70,000 psi and elongation 20%. It is used as a substitute for malleable iron or drop-forged steel. Lumen manganese brass, of the Lumen Bearing Co., is a 60-40 brass with 3% of the copper replaced with 1% iron and small amounts of manganese, tin, and aluminum.

**Manganese ores.** Manganese is a widely dispersed metal, occurring in many ores and in many parts of the world, but normally less than 10% of the manganese used in the United States is produced domestically, as most of the American ores are low-grade. The ores are used largely for producing ferromanganese, but some low-grade ores are reduced electrolytically to the metal, and the oxide ores are used directly in dry batteries, glassmaking, and in the chemical industry. Pyrolusite is the most important manganese ore. It is a manganese dioxide,  $\text{MnO}_2$ , with a black color and a metallic luster. The specific gravity is 4.75 and hardness 2 to 2.5. It is mined in various parts of Europe, Australia, Brazil, Argentina, Gold Coast, Cuba, India, Canada, and the United States. It is valued for glass manu-

facture, and the high-grade lead-free Montana and Gold Coast ores are used for batteries. Battery-grade manganese must be free of lead, copper, iron, and other impurities which are electronegative to zinc, and which would decrease the potential and the life of the dry battery. When used as a decolorizer for glass, pyrolusite has been called Glass-makers' soap. Bog manganese, known as Wad, is an impure mixture of  $\text{MnO}_2$  and  $\text{MnO}$ , together with other oxides. It is a soft friable mineral of black or brown color. The wad ore of Arkansas, used for making manganese sulphate, contains 15 to 50% manganese. Manganblend, or Alabandite, is a natural Manganese sulphide,  $\text{MnS}$ , and is an iron-black mineral with a specific gravity of 4 and a Moh hardness of 3.5 to 4.

Rhodochrosite, found in several parts of the United States and in central Europe, is a manganese carbonate,  $\text{MnCO}_3$ , with usually some iron replacing part of the manganese. It has a rose-red to dark-brown color, with a vitreous luster, specific gravity 3.5, and hardness 3.5 to 4.5. It usually has a massive cleavable structure. Manganite, found with other manganese minerals and with iron, is an iron-black mineral of the composition  $\text{Mn}_2\text{O}_3 \cdot \text{H}_2\text{O}$ , containing theoretically 62.4% manganese. It is found in Germany, England, and in the Lake Superior region of the United States. Hausmanite, found in Washington state, is another hydrated oxide,  $\text{Mn}_3\text{O}_4 \cdot 2\text{H}_2\text{O}$ , containing theoretically 62.26% manganese. It is used for coating welding rods. Bementite, from the same area, is a hydrated silicate,  $8\text{MnO} \cdot 7\text{SiO}_2 \cdot 5\text{H}_2\text{O}$ , containing 40.8% manganese. The high silica makes it difficult to use.

In general, an ore for ferromanganese should contain at least 35% manganese. Much of the American ore contains only 5 to 10% manganese. Arkansas ores are low-grade, with as little as 18% manganese, and high-grade with more than 70%. The low grades of Montana ore are concentrated by a nodulizing process up to 58% manganese. Manganese is also extracted from low-grade ores by a chemical process of leaching the pulverized ore with acid, treating with calcium chloride to remove calcium sulphate, and then with limestone, and filtering off the iron oxide. In Germany, low-grade ore is made into ferromanganese by first smelting to spiegeleisen and then treating part in an acid and part in a basic converter before mixing. The three grades of ore designated by the Metals Reserve



Co. are: High grade, with 48% min manganese and 7 max iron; Low grade A, with 44% min manganese and 10 max iron; and Low grade B, with 40% min manganese and no maximum on iron. Chemical grade manganese ore should have 80 to 90%  $\text{MnO}_2$ , equivalent to 51% min manganese, and not more than 2% iron. Indian ore is classed as first grade when it has 50% min manganese, second grade with 48 to 50%, and third grade with 45 to 48%. The battery-grade ore from Papua averages 86% manganese dioxide. The ore of the Belgian Congo averages 50% manganese and 4.5 min iron.

**Manganese steel.** All commercial steels contain some manganese which has been introduced in the process of deoxidizing and desulphurizing with ferromanganese, but the name was originally applied only to steels containing from 10 to 15% manganese. Steels with from 1.0 to 1.5% manganese are known as Carbon-manganese steel, Pearlitic manganese steel, or Intermediate manganese steel. Medium manganese steels, with manganese from 2 to 9%, are brittle and are not ordinarily used. The original Hadfield manganese steel made in 1883 contained 10 to 14.5% manganese and 1 carbon.

Manganese increases the hardness and tensile strength of steel. In the absence of carbon, manganese up to 1.5% has only slight influence on iron; as the carbon content increases, the effect intensifies. Air hardening becomes apparent in a 0.20 carbon steel with 1.5% manganese, and in a 0.35 carbon steel with 1.4% manganese. The manganese steels used for dipper teeth, tractor shoes, and wear-resistant castings, contain 10 to 14% manganese, 1 to 1.4 carbon, and 0.30 to 1 silicon. The tensile strength is up to 125,000 psi, elongation 45 to 55%, weight 0.286 lb per cu in., and Brinell hardness, when heat-treated, of 185 to 200. Cold working hardens this steel, and dipper teeth in service will work-harden to a hardness up to 550 Brinell.

High-manganese steels are not commercially machinable with ordinary tools, but can be cut and drilled with tungsten carbide and super high-speed tools. The Austenitic steels, with about 12% manganese, are exceedingly abrasion-resistant and harden under the action of tools. They are nonmagnetic. The coefficient of expansion is about twice that of ordinary steel. Various trade names are used

to designate the high-manganese steels. Rol-man steel, marketed by the Manganese Steel Forge Co., contains 11 to 14% manganese and 1 to 1.4 carbon, and has a tensile strength of 160,000 psi and elongation up to 50%. Amsco steel, of the American Manganese Steel Co., contains 12 to 13% manganese and 1.2 carbon. The tensile strength is 125,000 psi, and it will work-harden to 500 Brinell. Tisco steel, of the Taylor-Wharton Iron & Steel Co., has up to 15% manganese, and is used for rails and crossovers where high resistance to abrasion is needed. Timang, of this company, is a high-manganese steel made in the form of wire for rock screens. A German stainless type of steel, made without nickel, has 12% manganese. It is called Roneusil steel. High-manganese steels are brittle when cast and must be heat-treated. For castings of thin sections or irregular shapes where the drastic water quenching might cause distortion, nickel up to 5% may be added. The Manganese-nickel steels have approximately the same characteristics as the straight manganese steels. Nickel is also used in high-manganese steel wire, and the hard-drawn wire has strengths up to 300,000 psi. Manganal is a hot-rolled plate steel of high strength and wear resistance marketed by Joseph T. Ryerson & Son, Inc. It contains 11 to 13% manganese, 2.5 to 3.5 nickel, and 0.60 to 0.90 carbon. The tensile strength is 150,000 psi.

Structural steels with 0.50% carbon and from 1 to 2 manganese have tensile strength above 90,000 psi. Martinel steel, or Martin elastic limit steel, of Alfred Holt & Co., was an early English steel of this type. D-steel, developed by the British Admiralty for warship construction, contains 1.1 to 1.4% manganese, 0.33 carbon, and 0.12 silicon. The tensile strength is 96,000 psi and elongation 17%. N.Y. Central rails have 1.30 to 1.60% manganese and 0.65 carbon. Man-Ten steel, of the U.S. Steel Corp., is a medium-carbon, medium-manganese structural steel. Steels containing 1.30 to 1.90% manganese are now being used in automobile manufacture to replace more expensive alloy steels. Most mills now list these steels as Special alloy machinery steels; those containing about 0.10% sulphur are designated as Manganese screw stock. The SAE steels X1330 and X1340 are of this type. E.Z. Cut plate steel, of Joseph T. Ryerson & Son, Inc., is a free-machining steel for molds, gears, and machine parts. It has 0.14 to 0.21% carbon, 1.15 to 1.4 manganese, and 0.17 to 0.23 sulphur. The tensile strength is 65,000 psi and elonga-

tion 30%, but when carbonized and water-quenched the tensile strength is 100,000 psi. The sulphur is in the form of manganese sulphides. Stressproof steel, of the La Salle Steel Co., is a high-tensile steel which has machinability equal to 76% of an SAE 1112 bessemer screw stock, and, because of its resistance to warpage, is used for such parts as long lead screws and worm gears. It contains 1.35 to 1.65% manganese, 0.24 to 0.33 sulphur, 0.15 to 0.30 silicon, and 0.40 to 0.48 carbon. The minimum yield point is 100,000 psi. When heat-treated to 285 Brinell, it has a tensile strength of 135,000 psi and elongation 13%. The manganese steels with about 1.5% manganese and low carbon are much used for railway castings, and when deoxidized with titanium have tensile strengths close to 100,000 psi and elongation 30%.

Intermediate manganese steels are also sold under trade names such as Hylastic, of the American Steel Foundries. Max-El No. 4, of the Crucible Steel Co., is a pearlitic manganese steel with a small amount of chromium and 0.75% carbon, used for spring collets and called Collet steel. Slight amounts of chromium will increase the strength and hardness of the intermediate manganese steels. A forging steel for shafts and crankpins, designated as Manganese-vanadium steel, contains 1.5 to 1.75% manganese, 0.15 vanadium, and 0.25 carbon. The strength is 90,000 psi and elongation 30%. Moloie is the name of a Manganese-molybdenum steel of W. T. Flather, Ltd. Pearlitic Nickel-manganese steel contains 1.25% manganese and 1.25 nickel. It has high yield point and ductility. A steel used by the Union Pacific Railway for draft yokes has 1.4% nickel and 1.5 manganese. The strength is 95,000 psi.

**Mangrove.** An extract from the bark of the mangrove tree, *Rhizophora mangle*, of Venezuela and Colombia, the Red mangrove, *R. racemosa*, of Nigeria, the East African mangrove, *R. mucronata*, and other species of Africa, the East Indies, southern Asia, and tropical America, used for tanning leather. In Java it is called Baku bark. The East African bark contains 22 to 33% tannin, and the Nigerian bark contains 15 to 29%, usually at the low level. The South American barks range in tannin content from 5 to 45%. In the Brazilian mangrove, the leaves contain 24%. The solid extract marketed in blocks contains 62 to 63% solids and 53 to 54 tannin.

The liquid extract contains 25 to 35% tannin. Red mangrove contains a red coloring matter which is objectionable in tanning, but can be decolorized with albumen. White mangrove produces a pale pinkish-brown leather, fairly soft and of firm texture. Mangrove from East Africa is called Mangrove cutch, and is sometimes erroneously referred to as wattle.

**Manila hemp.** A fiber obtained from the leaf stalks of the Abaca plant, *Musa textilis*, a tree of the banana family growing in the Philippines, the East Indies, and Central America. It is employed for rope and cordage and is the strongest of the vegetable fibers. The fibers are also very long, from 4 to 8 ft, and do not stiffen when wet. It is thus valued for marine cordage. The best grades are light in weight, soft and lustrous, and white in color. The finest fibers, called Lupis, are used in the East for weaving into cloth. The plant grows to a height of 20 to 30 ft, with huge leaves characteristic of the banana. Each successive layer of leaves toward the stalk yields fibers that are lighter in color, higher in strength, and of finer texture than those outside. There are 15 grades in the Philippines.

**Maple.** The wood of maple trees native to the United States and Canada which include 13 species in the United States. Of these the Sugar maple, *Acer saccharum*, is the most plentiful and the most important. Other names for this tree and wood are Hard maple and Rock maple. The wood is heavy, tough, and hard. Black maple, *A. nigrum*, is similar to sugar maple and is marketed with it. The Broad-leaved maple, also known as Bigleaf maple and Oregon maple, is *A. macrophyllum*, and is the only species native to the Western states. Silver maple, *A. saccharinum*, grows most extensively in the Middle states. It is also called Soft maple, White maple, River maple, and Swamp maple. Box elder, *A. negundo*, grows over the Northern states east of the Rocky Mountains. The Red maple is *A. rubrum*, and the Vine maple is *A. circinnatum*. The wood of the maples may be white or yellowish to brownish, and is close-grained and hard. It often has a curly, twisted grain. The weight is about 40 lb per cu ft. Sugar-maple heartwood is light reddish brown with a wide white sapwood. The wood of the soft maples is not as heavy or as strong as that of the sugar maple. Maple is used for furniture, cabinetwork, flooring, rollers, measuring rules, shoe heels and lasts, and where a

hard, fine-grained wood is needed. Sugar maple has an average specific gravity when kiln-dried of 0.67, compressive strength perpendicular to the grain of 2,170 psi, and shearing strength parallel to the grain 1,520 psi. Rose maple, used in Australia for cabinetwork and paneling, is not a maple but is from the tree *Cryptocarya erthyroxylon*. The pinkish-brown wood has a wavy grain, weighs 45 lb per cu ft, is hard, and has a fragrant odor.

Maple sugar, used in confectionery, and in sweetening agents as Maple sirup, is the boiled-down sap of the sugar maple tree, harvested by tapping the tree in the early spring. The ratio of sap to sugar is 40:1, and an average production is 2 lb per tree, or 20 qt of sap from a 15-in. tree. Maple sugar is produced chiefly in Vermont, New Hampshire, New York, and Canada. Maple flavor is made artificially by the reaction of an alpha amino acid with a reducing saccharide.

**Marble.** A compact crystalline limestone used for ornamental building, for large slabs for electric-power panels, and for ornaments and statuary. In the broad sense, marble includes any limestone that can be polished, including Breccia, onyx, and others. Pure limestone would naturally be white, but marble is usually streaked and variegated in many colors. Carrara marble, from Italy, is a famous white marble, being of delicate texture, very white and hard. In the United States the marbles of Vermont are noted and occur in white, gray, light green, dark green, red, black, and mottled. A typical white Vermont marble slightly mottled with gray is 99% pure carbonates with only slight amounts of manganese and aluminum oxides and organic matter. But about 60% of American marble is quarried in Tennessee and Georgia. It is highly crystalline, and is colored white, gray, bluish, or pink. The Alabama marble is a pure, low-porosity material of good statuary grade. For great variety of beautiful colors the marbles of southern Uruguay are famous and occur in immense blocks.

The weight of marble is about 170 lb per cu ft, the specific gravity is 2.72, and the crushing strength 10,000 psi. It will ordinarily withstand heat up to 1200°F without injury. Translucent marble is selected and processed marble, semitransparent to light. Statuary marble is always selected by experts who have had long experience

in cutting. It must be of a single shade, and be free of hard or soft spots, iron inclusions, and other defects. Marble chips are irregular small graded pieces of marble marketed for making artificial stone. It is a by-product of marble quarrying. Marble flour, or Marble dust, is finely ground chips used as a filler or abrasive in hand soaps. Marbelite is an Artificial marble used for casting statues and small ornamental articles. It is made by heating potassium alum in water and adding about 10% heavy spar, and then casting in rubber molds. Marble dust may be added to increase the weight.

**Mastic.** The gum exudation of the tree *Pistacia lentiscus*, native to the Mediterranean countries. It is used in lacquers, varnishes, and adhesives. Mastic is obtained by making an incision in the tree, each tree yielding 6 to 11 lb annually. There are two general grades, the purer resin adhering to the tree, and the resin collecting on the ground. It is easily soluble in turpentine but is more expensive than many other natural resins, and is used for high-grade pale varnishes for art work. The name mastic is also erroneously applied to asphalt when used in calking or adhesive compounds.

**Mauritius hemp.** The fiber obtained from the fleshy leaves of the plant *Furcraea gigantea*, of Mauritius, Nigeria, and Gold Coast, used for rope and cordage. The product from West Africa is often erroneously termed sisal. The plant belongs to the lily family. Similar fibers are obtained from other species, notably *F. foetida*, of Brazil. The *F. gigantea* is also grown in Brazil under the name of Piteira. Each plant yields about 40 leaves annually, from 10 to 12 ft in length, each leaf giving 35 gm of fiber. The plant *F. cabuya* produced the ancient cordage fiber of the Mayas. The term Cabuya, which means cordage, is applied to the fibers of the several species growing through Central America, the West Indies, and northern South America to Ecuador. The fibers of the *F. cabuya* of Costa Rica are up to 100 in. long. The leaves yield up to 3.5% of their green weight in dry fiber, which is coarser than henequen but is used for coffee-bag fabric. The fibers of the cabuya of Ecuador, *F. andina*, are not as long. They are used extensively for burlap for bagging. Fique fiber, of Colombia, used for rope and for coffee bags, is from the leaves of the *F. macrophylla*. The leaves are longer than those of henequen, and the fiber is finer and more lustrous.

**Meerschaum.** A soft, white or gray, claylike mineral of the composition  $3\text{SiO}_2 \cdot 2\text{MgO} \cdot 2\text{H}_2\text{O}$ , used for making pipes and cigar holders, but also employed for making various other articles, as it can be cut easily when wet and will withstand heat. When fresh, the mineral absorbs grease and makes a lather; its German name means seafoam. It is used as a filler in soaps in Germany. The hardness is about 2 and the specific gravity 1.28. Most of the commercial meerschaum comes from Asia Minor; the mines at Eskisehir have been worked for 20 centuries. A little is produced in New Mexico and some in Spain. Artificial meerschaum is made from meerschaum shavings, kieselguhr, and from silicates of aluminum, calcium, and magnesium.

**Melamine resin.** A synthetic resin of the alkyd type made by reacting melamine with formaldehyde. The resin is thermosetting, colorless, odorless, and is resistant to organic solvents. It is more resistant to alkalis and acids than urea resins, has better heat and color stability, and is harder. The melamine resins have the general uses of molding plastics, and also are valued for dishes for hot foods or acid juices as they will not soften or warp when washed in hot water. Melamine, a trimer of cyanamide, has the composition  $(\text{N}:\text{C}:\text{NH}_2)_3$ . It has a specific gravity of 1.56 and melting point  $354^\circ\text{C}$ . Melamine alone imparts to other resins a high gloss and color retention. The melamine resins are too hard for use alone in coatings and varnishes, but they are combined with alcohol-modified urea-formaldehyde resins to give coating materials of good color, gloss, flexibility, and chemical resistance. Uformite MU-56, of the Resinous Products & Chemical Co., is a urea-modified melamine-formaldehyde resin used for coatings and varnishes. Melmac 1077, of the American Cyanamid Co., is a melamine-formaldehyde molding resin with cellulose filler. It has a tensile strength of 7,500 psi, and dielectric strength 325 volts per mil. Melmac 592 has a mineral filler. It has a dielectric strength of 400 volts per mil and will withstand temperatures to  $300^\circ\text{F}$ . Melurac 300 is a melamine-urea-formaldehyde resin with a lignin extender used as an adhesive for water-resistant plywood. Melmac 483 is a phenol-modified melamine-formaldehyde resin solution used for laminating fibrous materials. Melmac 404 is a highly translucent melamine-formaldehyde resin for molding high-

gloss buttons. Lanoset is a methylol-melamine made by alkylating a melamine-formaldehyde resin with methyl alcohol. It is used for shrinkproofing woolen fabrics. Resimene 812, of the Monsanto Chemical Co., is a colorless melamine-formaldehyde resin powder that can be dissolved in water or ethyl alcohol, for impregnating paper or fabrics, or for laminating.

**Menhaden oil.** An oil obtained by steaming or boiling the fish *Brevoortia tyrannus*, caught along the North Atlantic Coast of America. It was first called Porgy oil, the Maine name for the fish. In Connecticut it is called Whitefish. In the South it is known as Fatback and Mossbunker. The fish, when fully grown, are 12 to 15 in. long, weighing about a pound. They yield up to 15% oil, although fish from warm southern waters yield less oil. The catch of menhaden averages one-fifth of the total annual commercial catch of fish, but it is not a food fish because of its oily nature. The oil is used as a substitute or adulterant for linseed oil, for dressing leather, mixing in cutting oils, and for making blown oils. The residue Fish meal is sold for fertilizer. The meal is not as rich in vitamins A and D as that from some other fish, but much is used for poultry feed though more than about 15% of fish meal in a poultry feed may produce a fishy taste in the eggs. However, the Fish flour made in Norway by quick-drying fillet waste is mixed with wheat flour for making bakery products, and less than 20% does not give a pronounced flavor. It adds protein and mineral salts.

The better qualities of the oil are bleached, as it has a natural yellow-brown color. Inferior qualities are obtained by pressure from the residue or may be from putrid fish. Menhaden oil contains about 23% palmitic acid. The drying power is good, though it does not form an elastic film as do the vegetable oils. Its strong odor is due to Clupanodonic acid,  $C_{17}H_{27}COOH$ . The specific gravity is 0.927 to 0.933 and iodine value 180. It is soluble in benzene, naphtha, and ether.

**Mercerized cotton.** Cotton yarns treated with sodium hydroxide. The treatment gives a fine, silky luster to the yarn, makes it stronger, and practically nonshrinking. It was discovered in 1851 by John Mercer of Lancashire. The present process consists in immersing the yarns in a stretched condition in the soda and, after washing,



neutralizing the remaining alkali with dilute sulphuric acid. The stretching of the yarns prevents excessive shrinking. Mercerized cotton has a greater affinity for dyes than untreated cotton. Mercerized yarns have a variety of uses and, when mixed with silk, cannot be detected easily.

**Mercury.** Also called Quicksilver. A metallic element, symbol Hg. It is the only metal that is a liquid at ordinary temperatures. Mercury has a silvery-white color and a high luster. Its specific gravity is 13.596. The solidifying point is  $-40^{\circ}\text{F}$ , and its boiling point is  $662^{\circ}\text{F}$ . It does not oxidize at ordinary temperatures, but when heated to near its boiling point it absorbs oxygen and is converted into a red crystalline powder, Mercuric oxide,  $\text{HgO}$ , used as a pigment in marine paints. Mercury is derived chiefly from the mineral cinnabar. Spain, Italy, Russia, Mexico, and Western United States are the chief producers. The metal is marketed in steel flasks holding 75 lb. European flasks hold 76 lb. It is used for separating gold and silver from their ores, for coating mirrors, as an expansive metal in thermometers, in mercury-vapor lamps, rectifiers, mercury-vapor motors, in amalgams with other metals, and in its compounds for fungicides, pharmaceuticals, paint pigments, and explosives. The black mercurous oxide,  $\text{Hg}_2\text{O}$ , is used in skin ointments. Mercuric chloride, or Corrosive sublimate,  $\text{HgCl}_2$ , is an extremely poisonous, white crystalline powder soluble in water and in alcohol, used as a wood preservative, as an insecticide and rat poison, in tanning, as a mordant, and as a caustic antiseptic in medicine. Mercurochrome,  $\text{C}_{20}\text{H}_8\text{O}_6\text{Na}_2\text{Br}_2\text{Hg}$ , is a green crystalline powder which gives a deep-red solution in water, and is used as an antiseptic. Mercury forms a vast number of compounds, all of which are poisonous and some are explosive.

**Mesothorium.** A radioactive substance found in the rare-earth minerals. It is separated out of monazite sand and other thorium ores as a by-product of thorium production. Mesothorium is identical in chemical properties with radium, and cannot be separated from radium if mixed with it. A disadvantage of mesothorium, however, is that it decays, decreasing to half value in 5.5 years. The radiations from mesothorium are the same as from radium, alpha, beta, and gamma rays being sent off. As it decomposes, it forms radiothorium,

which is identical in chemical properties with thorium but gives off a powerful alpha radiation. Mesothorium is used in luminous paints. It is a better activator than radium for this purpose, but is scarcer and more expensive.

**Metallic soap.** A term used to designate compounds of the fatty acids of the vegetable and animal oils with metals other than the alkali metals. They are not definite chemical compounds like the alkali soaps, but may contain complex mixtures of free fatty acid, combined fatty acid, and free metallic oxides or hydroxides. The name distinguishes the water-insoluble soaps from the soluble soaps made with potash or soda. Metallic soaps are made by heating a fatty acid in the presence of a metallic oxide or carbonate, and are used in lacquers, leather and textiles, paints, inks, ceramics, and grease. They have the properties of being driers, thickening agents, and flattening agents. They are characterized by ability to gel in solvents and oils, and by their catalytic action in speeding the oxidation of vegetable oils.

When made with fatty acids having high iodine values, the metallic soaps are liquid, such as the oleates and linoleates, but the resinates and tungstates are unstable powders. The stearates are fine, very stable powders. The fatty acid determines the physical properties, but the metal determines the chemical properties. Aluminum stearate is the most widely used metallic soap for colloid products. Aluminum soaps are used in polishing compounds, in printing inks and paints, for waterproofing textiles, and for thickening lubricating oils. The resinates, linoleates, and naphthanates are used as driers, the lead, cobalt, and manganese being the most common. Soaps of copper, arsenic, and mercury are used in Antifouling marine paints. Calcium resinate is an insoluble soap of the composition  $\text{Ca}(\text{C}_{44}\text{H}_{62}\text{O}_4)_2$  produced by boiling rosin with lime water, and filtering. It is also called Calcium abietate, and is a yellow powder of high molecular weight, 1349.06, used as a paint drier and for waterproofing. Calcium linoleate is a white amorphous powder of the composition  $\text{Ca}(\text{C}_{18}\text{H}_{31}\text{O}_2)_2$  used in paints and in waterproofing. It is insoluble in water but soluble in alcohol. Calcium stearate,  $\text{Ca}(\text{C}_{18}\text{H}_{35}\text{O}_2)_2$ , is a white fluffy powder of 250 mesh. It is used as a flattening agent in paints, for waterproofing cements and stucco, as a lubricant for rub-

ber and plastic molds, as a softening agent in lead pencils, and in drawing compounds for steel-wire drawing. The calcium stearate of the Mallinckrodt Chemical Works, used in food and pharmaceutical emulsions, is impalpable powder of 325 mesh.

Barium stearate,  $\text{Ba}(\text{C}_{18}\text{H}_{35}\text{O}_2)_2$ , is a waxy nontacky white powder with molecular weight 703 and melting point 140 to 150°C. It is used as a dry lubricant for molding plastics, greaseless bearings, wax compounding, and wire drawing. Strontium stearate,  $\text{Sr}(\text{C}_{18}\text{H}_{35}\text{O}_2)_2$ , is a white powder with molecular weight 654 and melting point 130 to 140°C. It is partly soluble and gels in benzol, mineral spirits, and hydrocarbons. It is used in grease and wax compounding and in crimson flares and signals. Chromium stearate is a dark-green powder of the composition  $\text{Cr}(\text{C}_{18}\text{H}_{35}\text{O}_2)_3$  which melts at 95 to 100°C. It is used in ceramics, plastics, and in plastic waxes and greases, and as a catalyst. Manganese stearate is a pink powder of the composition  $\text{Mn}(\text{C}_{18}\text{H}_{35}\text{O}_2)_2$ , with a melting point 100 to 110°C. It is used in wax and grease compounding. Cerium stearate,  $\text{Ce}(\text{C}_{18}\text{H}_{35}\text{O}_2)_2$ , is a very inert, waxy white powder melting at 100 to 110°C, used as a catalyst and in waterproofing compounds. Nickel stearate is a green powder,  $\text{Ni}(\text{C}_{18}\text{H}_{35}\text{O}_2)_2$ , with a melting point 150 to 160°C, soluble in aromatic hydrocarbons, and forming gels with petroleum oils. It is used in lubricants, waterproofing compounds, leather finishes, and as a flux in nickel welding.

Dibasic lead stearate,  $2\text{PbOPb}(\text{C}_{18}\text{H}_{35}\text{O}_2)_2$ , is a soft white powder of specific gravity 2.02, insoluble in water or mineral spirits. It is used in greases, cutting oils, and as a heat and light stabilizer in vinyl plastics. Lithium stearate is a white, odorless powder melting at 217°C. It is used in machinery greases and as an oil soluble emulsifying and dispersing agent in cosmetics. The Lithium soap greases are very adhesive to the bearings and are heat-resistant. The Stanolith greases of the Standard Oil Co. of Indiana are lithium soap greases containing an oxidation inhibitor. The Uni-Temp grease of the Texas Co. is a lithium soap grease made with a synthetic hydrocarbon instead of an oil. It has uniform lubricating qualities between -100 and 300°C.

**Metalized wood.** Wood treated with molten metal so that the cells of the wood are filled with the metal. The fusible alloys, with melt-

ing points below the scorching point of wood, are used. The wood is immersed in molten metal in a closed container, and air pressure applied. Only a short treatment is needed to impregnate the wood; it can be controlled to give various degrees of penetration. The tensile strength of the wood is not affected, but the hardness, compressive strength, and resistance to flexure are increased. The wood also becomes an electrical conductor lengthwise of the grain. Metalized wood is costly but is used where the special characteristics are needed.

**Methane.** Also known as Marsh gas, in coal mines as Firedamp, and chemically as Methylhydride. A colorless, odorless gas,  $\text{CH}_4$ , employed for carbonizing steel, in the manufacture of formaldehyde, and as a starting point for many chemical compounds. It occurs naturally from the decomposition of plant and animal life, and is also one of the chief constituents of illuminating gas. It is made synthetically by the direct union of carbon or carbon monoxide with hydrogen. It is also produced by the action of water on Aluminum carbide, a gray, massive substance of the composition  $\text{Al}_4\text{C}_3$ . Methane has a specific gravity of 0.560 and, since it is much lighter than air, it is easily diffused in it. In air the gas is highly explosive, although the gas alone is not explosive. Pintsch gas, once used widely for car lighting, contained up to 60% methane and was made by spraying petroleum oil into a hot retort. This type of gas, under the name of Oil gas, or Carbohydrogen, and containing as high as 85% hydrogen, gives a low-temperature flame used for flame-cutting torches. Nitromethane is nitrated methane. It is a liquid explosive more powerful than TNT. Methane is also the chief constituent of Natural gas from oil fields. Natural gas contains usually at least 75% methane, although some Pennsylvania gas contains 98.8%, and some gas from Kentucky as low as 23%. A typical pipe-line gas containing gas from several fields showed 78% methane, 13 ethane, 6 propane, 1.7 butane, 0.6 pentane, and some higher gases. Sour gas is natural gas with more than one grain of  $\text{H}_2\text{S}$  per 100 cu ft. This hydrogen sulphide is removed to eliminate the odor before being piped. The propane, butane, and heavier hydrocarbons may also be removed for the production of chemicals. Much of the American production of natural gas is in Texas and Louisiana, but there are large reserves in California and other areas and throughout the Canadian plains area.

**Methyl alcohol.** Commonly known as Wood alcohol, and called Methanol when made synthetically. A colorless, poisonous liquid of the composition  $\text{CH}_3\text{OH}$ , obtained from the distillation of hardwoods. It is used as a solvent in lacquers, varnishes, and shellac. On oxidation it yields formaldehyde, and is used in making the latter product for synthetic molding materials. The specific gravity of methyl alcohol is 0.795, the solidifying point is  $-98^\circ\text{C}$ , and the boiling point is  $65^\circ\text{C}$ . It is now produced largely from synthesis gas.

**Mica.** Known originally as Muscovy glass. A group of minerals with monoclinic crystals which break off easily into thin, tough scales, varying from colorless to black. Muscovite is the common variety of mica, and is called Potash mica, or Potash silicate,  $\text{H}_2\text{KAl}_3(\text{SiO}_4)_3$ . It has dielectric properties superior to Phlogopite and is valued for radio condensers. Sheets as thin as 0.001 in. are used as electrical insulators. The Magnesium mica known as phlogopite, of the composition  $\text{H}_2\text{KMgSi}(\text{SiO}_4)_3$ , is distinguished from muscovite by its decomposition in sulphuric acid. It is known as Amber mica and is superior to muscovite in heat resistance, but is softer. It has a brownish-yellow color, and is valued for electrical work. It comes from India, Canada, Madagascar, and Tanganyika. The colorless muscovite used in stove doors was called isinglass for this purpose. Fuchsite is Chromium mica. It is known only in small emerald-green flakes. The rare greenish Vanadium mica known as Roscoelite is usually in fine scales, and where there are considerable amounts, as in the sandstones of Colorado, Utah, and Arizona, it is most valuable as a source of vanadium, as it contains 1.5 to 3.5% vanadium. Margarite is a yellow or purple Calcium mica,  $\text{CaO}(\text{SiO}_2)_2 \cdot (\text{Al}_2\text{O}_3) \cdot \text{H}_2\text{O}$ , and is a transition product. The chief uses of mica are as an electrical insulator, a heat insulator, and as a filler in plastics and insulating materials. The value of sheet mica depends greatly upon the absence of staining, especially from iron inclusions which decrease the electric insulating value. Most stains are black, which form magnetite or other iron oxide. Reddish stains are usually red iron oxide. The brown-colored micas containing much iron are valueless as electric insulators.

The specific gravity of mica is 2.7 to 3.1, and the hardness from 2 to 3. India, Brazil, and Argentina are the largest producers of block

mica. Ruby mica is the finest grade of Indian mica for electrical condenser use. India is the largest producer of phlogopite. About 80% comes from Bihar and is ruby mica. Madras mica is greenish, and is not high-quality electric mica. Indian mica is graded as No. 5 first and second quality bookform; No. 6 loose with powder; extra loose, first quality and second quality; special loose, second quality; and No. 6A loose, third quality. Argentine mica runs 80% stained, 15 semiclear, and 5 clear. It has eight size grades from No. 6 in sheets of 1 to 3 sq in. to AA, or Special, in sheets of 48 sq in. or more.

Mica is marketed as cut or uncut block, sheet, splittings, and ground. The value is usually on the size of clear, flat sheets. The sheets vary from clear to black, stained in six grades. Splittings are usually only 0.001 in. in thickness, and only 1 or 2 in. in diameter, but are readily cemented together for use. Indian mica has been obtained in books as large as 15 ft, and sheets as large as 24 by 30 in. without flaws. Small pieces are made into mica powder. Micanite is an old name for small splittings molded together with an adhesive for insulating use. The original Micanite made in India in 1892 was made from small pieces cemented together with shellac. Mycalex, of the Mycalex Corp., and the General Electric Co., are Glass-bonded micas. That of the latter company is composed of ground mica and lead borate heated together to the softening point of the borate, 675°C, and compressed while plastic. Part of the mica combines to form a lead borosilicate, giving greater insolubility. It has good mechanical strength, is a good heat and electrical insulator, is impervious to water, resistant to arcing, and has a low coefficient of expansion. The tensile strength is 5,000 to 7,000 psi, and compressive strength 22,000 to 30,000 psi. Mykroy sheet, of the Electronic Mechanics, Inc., is a glass-bonded mica in large brownish-gray sheets ground on the sides and used for electrical panels and structural parts of radio equipment. The dielectric strength is 620 volts per mil, and hardness 63 to 70 Brinell. Mykroy No. 51 is made from ground mica, boric acid, lead oxide, and a small amount of cryolite, and is injection-molded to intricate shapes and fired at 1100 to 1450°F. It is used for radio and electrical parts. The dielectric strength is 500 to 620 volts per mil, Brinell hardness 63 to 70, and it will withstand temperatures to 1000°F. Lamicoid is a synthetic plastic with mica

filler produced by the Mica Insulator Co. Micabond is a trade name of the Continental-Diamond Fiber Co. for mica bonded with shellac and resin to form sheets, tubes, and molded parts. Micabond cloth is mica splittings faced on one side with tissue and on the other with cotton cloth. Watsonite is the name of a mica substitute consisting of scrap or flake mica dehydrated by heating and then sheeted with a flexible binder. A Synthetic mica, known as Alsifilm, is produced from bentonite, and is made in thin, transparent sheets with many of the characteristics of mica. The German mica substitute known as Glushartgewebe is made by impregnating very fine high-alkali glass-fiber cloth with an alcohol solution of osmose kaolin and a partially polymerized Resinol resin and compressing the plies under high pressure at 160°C. It is nonhygroscopic, uniform in thickness, has a dielectric strength above 1,000 volts per mil, and can be had in larger sheets than mica. The synthetic mica, of the Charles Lenning Co., is made with a dispersion of colloidal magnesium silicate and synthetic resin which polymerizes to a thin sheet of high dielectric strength. Synthetic mica made by Siemens & Halske during the war was produced by melting a mixture of 11.6% aluminum oxide, 32.6% magnesium oxide, 30.7% kieselguhr, and 25.1%  $K_2SiF_6$ . The crucible of melted material was enclosed in a silicon carbide crucible with the space filled with fused alumina sand, and brought to a temperature of 1500°C. After cooling slowly the material is removed by breaking the inner crucible. The solidified mass splits into thin clear sheets equal to high-grade natural mica. The synthetic mica made by the National Bureau of Standards is a Fluorine-phlogopite mica produced by calcinating a mixture of quartz, bauxite, and magnesite to drive off the carbon dioxide, adding potassium fluorosilicate, and melting at 1400°C. As the furnace cools, the mica crystals grow from a seed at the bottom of the crucible. The mica has the composition  $K_4Mg_{12}Al_3O_{40}F_8$ , and is similar to a natural mica in which the hydroxyl radical has been replaced by fluorine. In physical properties it is equal to a high-grade natural mica.

**Mica powder.** Mica in very small flakes used as a filler in plastics, in paints, in roofing and asphalt shingles, and for making glass-bonded mica. When produced by grinding the small scrap pieces from mica workings, it is known as Ground mica. The ground mica

from Canada is phlogopite. It comes in 20, 60, 120, and 150 mesh. Mica in paints helps to bond the film and prevent cracking, acting similarly to aluminum leaf. Mica powder for plastic filler and paints is produced directly from mica schists by froth flotation. The powder recovered averages more than 50% of sizes smaller than 200 mesh and 20% between 150 and 200 mesh. The recovered mica equals in every way the powder made by grinding mica scraps. Sericite mica, or Damourite, from North Carolina kaolin workings, and in pockets in the fireclay deposits of Adelaide Co., Australia, is a type of potash mica related to muscovite but softer. It occurs as a finely divided powder with a talclike feel. Mixed with aluminum powder it produces a finish paint superior to aluminum alone. It has some activating properties, and is a substitute for zinc oxide in rubber. It is also used as a filler in plastics, and replaces graphite as a foundry core and mold wash. The recovery from North Carolina clay is 10% of the gross weight of the clay. Water-ground mica is ground to a fineness of 90% through a 325-mesh screen and 9% on a 325-mesh. It is for paint and rubber use. The mica powder known as Micalith G, of the Glidden Co., is sericite mica from Pennsylvania washings with 0.5% graphite embedded in the mica crystals. The graphite improves the wetting and dispersion in paints. Micronized mica is a powder of a fineness of 400 to 1,000 mesh, used as a filler. Mica flake, used in the manufacture of shingles and roofing, is washed from pegmatite deposits.

**Milk.** The secretion of the mammary glands of mammal animals. Commercial milk in the United States is almost entirely from the cow. Besides its use as a food for direct consumption and in bakery products, it is employed for making cheese, butter, casein, ice cream, lactic acid, and lactose chemicals. The production of cow's milk in the United States is about 120 billion pounds from 28 million animals. Although the average production from registered dairy animals is only about 4,700 lb per year, the average yield from 800,000 cows under the Dairy Herd Improvement Assoc. is 8,000 lb per year. The composition of milk is 87.34% water, 3.75 butter fat, 3 caseinogen, 0.4 lactalbumin, and 0.75 mineral salts. It also contains vitamins A, B, and C. The vitamin A content is low during the winter months when the animals do not feed on green grasses. The fat-digesting



enzyme in milk is destroyed by sunlight or by ultraviolet light. Much milk is used in the production of evaporated and condensed whole milk. Dried milk, or Milk powder, is made largely from skimmed milk, or milk from which the cream has been separated. One gallon of milk yields 1.2 lb of dried milk. Dried milk is used mostly in bakery products. While milk has many useful applications in cookery and commercial baking, it is essentially a natural baby food to build up the original low-calcium soft bones and to provide calcium for bones and teeth. Too much milk in the diet of adults may give an excess of calcium in the arteries and also cause cirrhosis or fatty growth of the liver. It may also cause an excess of lactic acid, which is normally produced in the muscles by exercise to cause tiredness and sleep, but which is highly toxic in excess.

Pasteurized milk is milk that has been heated to kill any disease organisms. Milk is sometimes sterilized and stabilized against souring by treating with a small amount of hydrogen peroxide to kill the bacilli. Homogenized milk is milk that has been treated by sonic vibration to break up the fat globules and distribute them evenly in the liquid. In natural milk the fat and proteins are in colloidal solution. Under the U.S. Food and Drugs Act milk must contain not less than 3% milk fat and 8.5 solids not fat. In most countries the handling of milk is regulated by laws as it is easily contaminated.

Cow's milk for direct consumption and for industrial use is produced on a large scale in the United States, Canada, Europe, Argentina, New Zealand, and Australia. Kumyss is sweetened cow's milk fermented with yeast, used as a nutrient. Soy milk is a water solution of soybean solubles combined with sugar, calcium phosphate, irradiated sesame oil, and vitamins. It has the approximate composition of cow's milk and is almost indistinguishable from it. Lactic acid derives its name from the fact that it was originally obtained from milk. It is now made by fermenting dextrose in the presence of lime to produce calcium lactate and regenerating with sulphuric acid, or it is produced synthetically from sulphite pulp liquor. It has the formula  $\text{CH}_3\text{CHOHCOOH}$ , and is used for producing plastics and many chemicals. Polylactic plastics are made by reacting lactic acid with castor oil or linseed oil at 525°F to form a soft, brown, elastic resin, which is used with a solvent to produce tough, water-resistant coatings for paper or textiles. Metal polylactates are made by reacting

lactic acid with salts of aluminum, copper, or other metals to form pale, infusible resins. When dissolved in organic solvents, they are used for protective and decorative coatings.

**Millet.** The very small seeds of a number of grasses. It is one of the most ancient of food grains, and is a most important grain in Asia, being used as a food by a third of the population of the world. Nearly 40 million acres are cultivated to this grain in India alone. The plant is very drought-resistant, but will not withstand frost. The seeds are high in phosphate, protein, minerals, and oil. In the United States millet seed is used as a birdseed, and the plant is grown for pasturage and silage. German millet, also known as Foxtail millet and as Hungarian grass, is from the grass *Setaria italica*. The seed contains phosphates and many minerals and vitamins A and E. It is an important food in Europe and Asia, but in North America is a forage crop. White millet, or Proso millet, from the grass *Panicum miliaceum*, is one of the richest grains in food value, but is employed in the United States only as a birdseed. It is much used in Russia as a food. The millet from the plant *Sorghum vulgare* is a staple food in India. Sanwa millet, from the *Echinochloa frumentacea*, is an important food in Japan. The plant will produce as many as eight forage crops per year.

**Millstone.** Any stone employed for grinding paint, cement, grain, or minerals. Millstones are made from sandstone, basalt, granite, or quartz conglomerate. Burrstone is a millstone made from chalcedony silica of cellular texture, usually yellowish in color. The stone is also used as a building stone. Esopus stone is a conglomerate of this type from Ulster County, New York. The most noted burrstones for grinding grains are the European stones cut in wedge-shaped blocks 6 in. long, 3½ to 4 in. wide, and 2 to 2½ in. thick bound together with iron hoops. The French stones are chalcedony quartz, creamy white, with a cellular structure, the cavities formerly occupied by fossil shells. German burrstones are basaltic lava. Millstones vary greatly in sharpness of grain and size of grain, but should be of even texture throughout. Chaser stones are very large stones run on edge in mills for grinding minerals.

**Mineral wool.** A fibrous material employed as a heat insulator in walls or as a sound insulator. It was first obtained as a natural prod-

uct from volcanic craters in Hawaii and was known as Pele's hair. It is made by mixing stone with molten slag from blast furnaces and blowing steam through it. Slags from copper and lead furnaces are also used. Slag wool is made from slag without the rock. A lead slag containing 30 to 50% calcium and magnesium oxides makes a mineral wool that will withstand temperatures to 1500°F when made into blocks or boards. Mineral wool usually consists of a mass of fine, pliant, vitreous fibers, which are incombustible and a nonconductor of heat. Rock wool is made by blowing molten rock in the same manner, and is more uniform than common mineral wool, with physical qualities depending, however, on the class of rock used. The rock wool marketed by Johns-Manville under the name of Banrock is made from high-silica limestone and is used for insulating oven walls for temperatures up to 1000°F. Zerofil is a nonsweating, low-temperature insulating material of the same company consisting of rock wool coated with asphalt. The rock wool of the Philip Carey Co., known as Rocktex, has a heat conductivity of 0.22 Btu per hr per sq ft per deg F difference in temperature. Rock cork is a name for a low-temperature insulating material made of rock wool molded in sheet form with a waterproof binder, used for walls in cold-storage rooms.

Granulated mineral wool, of the Keasbey & Mattison Co., is milled to 1/2-in. diameter size which can be poured into the space to be insulated. It has a density of 4 to 6 lb per cu ft. Supertemp block, of the Eagle Picher Lead Co., an insulator for temperatures up to 1700°F, is made of a cement composed of small rolled pellets of mineral wool and asbestos fibers combined with a mineral binder, making a block with tiny dead-air pockets. The thermal conductivity at 100°F is 0.40 Btu per sq ft per in. of thickness per hr. Mineral-wool board, of the Armstrong Cork Co., is a moisture-resistant board in thicknesses of 1, 1 1/2, 2, 3, and 4 in. for cold-storage insulation. The thermal conductivity is 0.31 to 0.33 at 90°F. Mono-Block, of the Baldwin-Hill Co., is rock wool made into standard blocks and slabs by a felting process. It is used for both cold and heat insulation to temperatures up to 1600°F. The weight is 18 lb per cu ft. The heat conductivity at 200°F is 0.325 Btu per sq ft per hr per in. thickness per deg F. Insulating blocks are also made of granulated mineral wool or the fiber compressed with a binder of clay or bentonite for elevated temperatures, or with a plastic binder for temperatures below

400°F. Rock-wool quilt consists of felted fibers stitched between layers of treated kraft paper. Rock-wool blankets for insulation are made of long fibers felted and bonded with a synthetic resin. They are water-repellent and verminproof. Rock wool is marketed as loose wool of fine silky fibers, in granulated pellets, and in batts or matted pads. Selected mineral, to give various characteristics, may be used to make rock wools. Wollastonite, a natural Calcium metasilicate,  $\text{CaO} \cdot \text{SiO}_2$  found in California and New York, is melted to produce a rock wool. Fibrous silica, used for high-temperature insulation in jet aircraft, is produced from silica minerals in the same manner as rock wool and then extracting the nonsilica content of the fiber. Refrasil, of the H. I. Thompson Co., is this material. The fibers have a diameter of 0.00023 in., fuse at 3100°F, and will withstand continuous temperatures to 2000°F. It is produced as fibers, batts, cloth, and cordage.

**Mohair.** The long, lustrous fleece of the Angora goat, *Capra angorensis*, important as a textile fiber because of its luster, length, strength, and spinning qualities. Mohair fabrics are used for upholstery material for hard service, and valued for summer wearing apparel, linings, and plushes. Army Necktie cloth, notable for durability and noncreasing, has a cotton warp and a mohair filling. Mohair commonly contains shorter fibers, coarse and difficult to dye. These are known as Kemp and sometimes comprise 18% of the fiber. They are removed by combing. Mohair has a natural curl but no crimp, and does not felt like wool. The American fiber is 6 to 8 in. long, and the Turkish fiber is up to 10 in. long. South Africa produces much mohair.

**Mold steel.** A term that generally refers to the steels used for making molds for plastics. Mold steel should have a uniform texture that will machine readily with die-sinking tools. It must have no microscopic porosity, and be capable of polishing to a mirrorlike surface. When annealed, it should be soft enough to take the deep imprint of a hob, and when hardened it must be able to withstand high pressure without sinking and have sufficient tensile strength to prevent breakage of the small mold sections. It should not warp under ordinary heat-treating processes. For most plastic molding a casehardening, low-carbon, low-alloy steel is used, but it must be of tool-steel quality

and not of structural-steel grade. For hot sinking a typical analysis is 0.10% carbon, 0.50 manganese, 0.60 chromium, and 1.25 nickel. Such a steel has an annealed hardness of 120 Brinell, but will give a hardened case of Rockwell C62 and core of C21, with a tensile strength up to 120,000 psi. For molds that are machined and not hobbled a higher carbon content is used which increases the strength of the steel. For molds that must withstand the highest hydraulic pressures the nickel content is increased to 3.5% and the chromium also increased. For severe pressures and resistance to abrasion high-carbon manganese steels may be used. A typical analysis is 0.90% carbon, 1.6 manganese, and 0.25 silicon. These steels are deep-hardening and withstand high compression, but are not as strong in tension. Stainless steels are also used for molds where high strength, long wear life, and chemical resistance are required, but these are difficult to machine. A carburizing steel for plastic molds is SAE steel 3312, containing 3.5% nickel and 1.2 chromium. Carpenter No. 158 steel has 3.5% nickel, 1.5 chromium, 0.40 manganese, and 0.10 carbon. It gives a surface hardness of Rockwell C62 with a core strength of 165,000 psi. Samson Extra, of this company, is a deep-hobbing steel of good machinability and high core strength. It contains 0.10% carbon, 0.30 manganese, 0.20 silicon, and 2.30 chromium. When water-quenched to a hardness of Rockwell C65, it has a tensile strength of 120,000 psi. Hoballoy, of the Crucible Steel Co., is a steel of this type with 0.10% carbon. Plastalloy, of Henry Disston & Sons, Inc., is a low-carbon, low-alloy, fine-grained steel for molds to be hobbled. Speed-Cut steel of the Vanadium Alloys Steel Co., used for die-casting molds, will air-harden slightly. It contains 1.12% chromium, 0.85 manganese, 0.50 molybdenum, 0.30 silicon, 0.40 carbon, and is free of sulphur and phosphorus. When machined at the heat-treated condition of 250 to 325 Brinell, it requires no further heat-treatment, but it can be annealed to 170 Brinell for hobbing.

**Molding sand.** Called also Foundry sand. Any sand employed for making molds for casting metals, but especially referring to sands that are refractory and have also binding qualities. Pure silica is ideal for heat resistance, but must contain enough alumina to make it bind together. Molding sands may contain from 80 to 92% silica, up to

about 15% alumina, about 2% iron oxide, and not more than a trace of lime. Some molding sand contains enough clay or loam to bond it when tamped into place. The amount of bond in Grant and in Tuscarawa sand is 17 to 18%. About 33% of these natural sands pass through a No. 100 screen, and 20 through a 150 screen. The finer the grain, the smoother the casting, but fine-grained sand is not suitable for heavy work because of its impermeability to the gases. Sands without natural bond are more refractory and are used for steel molding. Sands for steel casting must contain over 90% silica, preferably 98%, and are mixed with 6 to 10% fireclay. These are usually called Silica sands as distinct from foundry or molding sands.

Zircon sand has high heat resistance, and is used for alloy steel casting. Zircon flour is finely milled zirconite sand used as a mold wash. Zirconite sand for molding is 100 to 200 mesh in its natural state. It is 70% heavier than silica sand, and has a higher heat conductivity that gives more rapid chilling of castings. The zirconite sands have melting points from 3650 to 3850°F. Common molding sand may contain from 5 to 18% of clay materials, and be mixtures of sand, silt, and clay, but they must have the qualities of refractoriness, cohesiveness, fineness of grain, and permeability. To have refractory quality they must be free of calcium carbonate, iron oxide, and hydrocarbons. Core sands also have these qualities, but they are of coarser grain, and always require a bond that will bake solidly but will break down easily at the temperature of pouring. About 25% of a medium molding sand will be retained on a 150-mesh sieve, and about 10% on a 200-mesh sieve. Sand with rounded grains is preferred, and the grains must be very uniform in size to prevent filling. When a molding sand is burned out, it is made suitable for re-use by adding bond but, when fireclay is used as a bond, it adheres to the sand grains and makes it unsuitable for re-use. Parting sand is a round-grained sand without bond used on the joints of molds. Foundry parting is usually tripoli or bentonite. Cores are made with sand mixed with core oils. Greensand cores are unbaked cores made with molding sand.

**Molybdenum.** A silvery-white metal, symbol Mo, occurring chiefly in the mineral molybdenite but also obtained as a by-product from copper ores. About 90% of all molybdenum is produced in the

United States, the remainder coming from Chile, Mexico, Peru, and Norway. The metal has a specific gravity of 10.2, and melting point of 4750°F. It is ductile, softer than tungsten, and is readily worked or drawn into very fine wire. The coefficient of thermal expansion is low, and the heat conductivity is twice that of iron. Above a temperature of 1400°F the metal forms an oxide that evaporates as it is formed. The tensile strength of rolled molybdenum is up to 260,000 psi with Brinell hardness 160 to 185. Because of the high melting point, the extraction of the metal is similar to that of tungsten. The commercial metal is 99.95% pure. It is used for grids, hooks, and support members in radio and light bulbs, for windings in electric furnaces, welding electrodes, and for powder metallurgy. The metal is marketed in rods up to  $\frac{3}{4}$  in. diameter, in tubes to  $\frac{1}{2}$  in., in sheets as thin as 0.001 in., and in wire as fine as 0.004 in. The hydrogen-reduced Molybdenum powder of the Indar Co. is of high purity and fine particle size. Most of the molybdenum used is employed in alloy steels, and for this purpose it is used in the form of Ferromolybdenum, which is made directly from the ore by reduction with carbon, lime, and silicon, and adding iron. The standard grade of ferromolybdenum contains 50 to 60% molybdenum with up to 2.5% carbon. It is marketed in steel drums on the basis of the contained molybdenum metal. Calcium molybdate is also used for adding molybdenum to steels. Briquettes of Molybdic oxide, containing 70 to 75% molybdenum trioxide and 12 carbon, are also used for alloying steel.

**Molybdenum cast iron.** Cast iron containing small amounts of molybdenum added to the iron as ferromolybdenum or as calcium molybdate. Molybdenum in iron is not a carbide-former or a graphitizer. It goes into direct solid solution and refines the matrix, increasing the strength, toughness, and wear resistance. Usually the manganese is increased when molybdenum is added, and the irons are more uniform in structure than plain cast iron. A plain molybdenum cast iron with 0.65% molybdenum has a tensile strength of 44,000 psi and Brinell hardness 223, which can be raised by heat-treatment to above 60,000 psi with a hardness above 300 Brinell. Greater hardness can be obtained in the iron with the addition of small amounts of chromium. A chrome-molybdenum cast iron with

0.50% chromium, 0.50 molybdenum, and 1.25 manganese added to the cupola, resulting in an iron of 3.1% total carbon, 0.30 molybdenum, 0.33 chromium, and 0.75 manganese, has a tensile strength of 48,000 psi, Brinell hardness 240, and an increase of about 40% in transverse strength over the plain iron. Raising the amount of molybdenum increases the hardness, but the machinability is kept by the addition of nickel or copper. Nickel-molybdenum cast irons have hardnesses as high as 300 Brinell without massive carbides that interfere with machining. An iron with 0.80% each of molybdenum and nickel, without chromium, has a tensile strength of 50,000 psi and a hardness of 270 Brinell. It has great uniformity, and can be cast in combined thin and heavy sections.

**Molybdenum ores.** Molybdenite is the chief ore of the metal molybdenum. It is a molybdenum disulphide,  $\text{MoS}_2$ , containing 60% molybdenum, occurring in granite, gneiss, and granular limestone. Molybdenite resembles graphite in appearance, with a lead-gray color, metallic luster, and greasy feel. The hardness is 1, and specific gravity 4.75. It is infusible. The American production of molybdenite is from Colorado, New Mexico, and Nevada. Wulfenite, another important ore, is a Lead molybdate,  $\text{PbMoO}_4$ , and occurs in lead veins with other ores of lead. It is found in Utah, Nevada, Arizona, and New Mexico. Wulfenite occurs in crystals and also massive granular. The specific gravity is 6.7 and hardness 3. Its color is yellow, orange, gray, red, or white. Molybdite, another ore, is a hydrous ferric molybdate of the composition  $\text{Fe}_2\text{O}_3 \cdot 3\text{MoO}_3 \cdot 7\text{H}_2\text{O}$ . It occurs either crystalline massive or as an earthy powder. It is yellowish, with a specific gravity of 4.5 and a hardness of about 1.5. Molybdenum ores are converted into ferromolybdenum or into calcium molybdate for use in adding molybdenum to steel.

**Molybdenum steel.** Next to carbon, molybdenum is the most effective hardening element for steel. It also has the property like tungsten of giving steel the quality of red-hardness, requiring a smaller amount for the same effect. It is also used in hot-work steels, and to replace part of the tungsten in high-speed steels. It is added to heat-resistant irons and steels to make them resistant to deformation at high temperatures and to creep at moderate temperatures. It increases the corrosion resistance of stainless steels at high temperatures. Molyb-



denum in small amounts also increases the elastic limit of steel, reduces the grain size, strengthens the crystalline structure, and gives deep hardening. It goes into solid solution, but when other elements are present it may form carbides and harden the steel, giving greater wear resistance. It also widens the heat-treating range in tool steels. As it decreases the temper brittleness of aluminum steels, small amounts are added to nitriding steels.

Plain Carbon-molybdenum steels are easier to machine than other steels of equal hardness. Molybdenum structural steels usually have from 0.20 to 0.75% molybdenum. SAE steels 4130 and 4140 contain about 1% chromium and 0.20 molybdenum, and are high-strength forging steels for such uses as connecting rods. Alloy, used by the Allen Mfg. Co. for hollow-head screws, is SAE 4150 steel. SAE steels 4615 to 4650 have no chromium but contain about 1.75% nickel and 0.25 molybdenum. SAE 4615 is used for molds and dies to be hobbled. It is easily worked when annealed. The alloying elements increase the rate of carbon pickup in carburizing, and the steel has a core hardness of 280 Brinell after hardening. SAE 4650 Nickel-molybdenum steel is used for forming dies and, when hardened and drawn to a hardness of 435 Brinell, has a tensile strength of 215,000 psi. Hyten M steel, of Wheelock, Lovejoy & Co., and Durodi steel, of A. Finkl & Sons, are high-strength nickel-chromium-molybdenum steels. Up to 3% molybdenum is used in stainless steels for cast parts for hot-oil and chemical equipment. Lebanon 22-XM steel has 19.5% chromium, 9 nickel, and 3 molybdenum. Welmet, of the Welland Electric Steel Foundry, is a similar steel.

The old Damascus steel and Toledo steel were molybdenum steels, the molybdenum being in the original ore. Damascene steel is a name referring to the wavy marks on blades by forging and was not necessarily a molybdenum steel. But the original Wootz steel, or Indian steel, of this type, contained small percentages of aluminum incorporated in some unknown manner. Wootz steel was made in the crucible, although the crucible method was not used in Europe until 1740.

**Monazite.** A mineral occurring as sand or in granular masses, usually as sea sand. It is the chief source of thorium oxide and of the

**rare-earth metals:** Most of the monazite comes from Brazil, India, and the East Indies. Brazilian monazite usually contains 6 to 8% thorium oxide. The Indian ore may have as high as 10%, but is marketed on the basis of 7.5 to 8% thorium oxide and 60 rare-earth metals. Monazite is a phosphate of the cerium metals,  $(\text{CeLaY})\text{PO}_4$ , with Thorium silicate,  $\text{ThSiO}_2$ , having a specific gravity of 5.2 and a hardness of 5.5. It has a reddish-brown color with a resinous luster. Monazite also contains about 3.5 grams of mesothorium per 1,000 tons. It usually has also 30 to 35% of the oxides of lanthanum, neodymium, praseodymium, and yttrium, and a small amount of the element Europium.

**Monel metal.** A natural alloy produced directly from Canadian Bessemer matte by reducing the nickel ore. It was introduced in 1905 by the International Nickel Co. The average composition is nickel, 67%; copper, 28; iron, manganese, silicon, and other elements, 5. The alloy may be cast, rolled, or forged, and can be annealed after cold working. It is resistant to corrosion and to the action of many acids, and will retain its bright nickel-white surface under ordinary conditions. The melting point is about  $2460^\circ\text{F}$  and weight 0.318 lb per cu in. The tensile strength is 65,000 psi with elongation up to 50% depending upon the condition of hard rolling. The cast metal may have a tensile strength up to 100,000 psi. Monel metal is employed for parts for chemical and mining equipment, marine fittings, kitchen and restaurant equipment, and valves. A synthetic alloy of this type is Mond metal. It does not contain iron, but contains higher manganese; the composition is 70% nickel, 26 copper, and 4 manganese.

S Monel is an alloy of monel metal with 3.75% silicon. It is used for valves and for castings subject to wear and corrosion. It has a hardness of 275 to 390 Brinell when heat-treated. K Monel is an alloy of Monel metal with a small amount of aluminum. It can be hardened by heat-treatment. A typical composition is 63.3% nickel, 30.8 copper, 3.5 aluminum, 1.5 iron, 0.5 manganese, with small amounts of carbon, sulphur, and silicon. The soft alloy, with a hardness of 145 Brinell, will have a hardness above 300 Brinell when heat-treated, and a tensile strength up to 160,000 psi. It will retain its hardness up to  $700^\circ\text{F}$  and is suitable for high-pressure steam

valves. R Monel contains 67% nickel, 30 copper, and 0.035 sulphur. The cold-drawn rods have a tensile strength of 90,000 psi, elongation 25%, and Brinell hardness 180. H Monel is a sand-casting alloy containing 65% nickel, 29.5 copper, 3 silicon, and 1.5 iron. The tensile strength is 100,000 psi, elongation 15%, and Brinell hardness 210. Ebonized Monel is monel metal in commercial form with a lustrous ebony finish obtained by an oxidizing process.

**Mordant.** A substance used in dyeing for fixing the color. A mordant must have an affinity for the material being dyed and at the same time the property of combining with the dyestuff. The vegetable fibers, such as cotton and linen, frequently require mordants. The mordant may be applied first, usually in a hot solution or simultaneously with the dye. Besides fixing the color, mordants sometimes also increase the brilliancy of the dye. A common mordant is alum. Salts of aluminum, chromium, and other metals are used. Sodium stannate, used both as a mordant and for fireproofing textiles, is a gray-white water-soluble powder of the composition  $\text{Na}_2\text{SnO}_3 \cdot 3\text{H}_2\text{O}$  made by treating tin oxide with caustic soda. Chromium acetate, used as a mordant for chrome colors, and to produce khaki shades with iron solutions, is a grayish-green powder of the composition  $\text{Cr}(\text{C}_2\text{H}_3\text{O}_2)_2 \cdot \text{H}_2\text{O}$ . It is soluble in water. In gilding, the term mordant is used to mean a viscous or sticky substance employed to make the gold leaf adhere, but such a material does not have the chemical action of a mordant.

**Mother of pearl.** The hard, brilliant-colored internal layer of the pearl oyster shell and of certain other marine shellfish. It is employed for knife handles, buttons, inlay work, penholders, and other articles. Large oysters of the Indian Ocean, especially off Ceylon and in the Persian Gulf, furnish much of the mother of pearl. Other producers are Australia and the lands bordering the Coral Sea. The large Hawaiian pearl oyster is *Pinctada gatliffi*. The iridescent appearance is due to the structure of the nacre coating, and the shells are also called Nacre. Mother of pearl is brittle but can be worked with steel saws and drills using a weak acid lubricant. The shells are thick and heavy, and disks cut from them are split for buttons. Fresh-water shells from mussels of the Mississippi River are also used for buttons but do not have the iridescence of mother of pearl. The waste shell

from the manufacture is crushed and marketed for poultry feed and for fertilizer.

**Mucilage.** A sticky substance obtained from linseed or other seeds, and employed as an adhesive, as a thickening agent, and as a stabilizer for solutions. The seeds are infused in hot water, bruised, and strained. The gummy substance, which contains arabinose, glucose, and galactose, is precipitated, and a heavy solution is known as mucilage. It is easily soluble in water, and is used as a light cementing material for paper. Mucilage as a general name also includes water-soluble gums from various parts of many plants and has the same uses. It is the stored reserve food of plants. There are two types: the cell-content mucilage which acts as a disorganization product of some of the carbohydrates, and membrane mucilage which acts as a thickening agent to the cell wall. Membrane mucilage occurs in the acacias, algae (Seaweeds), linum (flax plants), ulmus (elms), and astragalus. When it is collected in the form of exudations from the trees, it is called a gum. Cherry gum, from the *Prunus cerasus*, is this type of water-soluble gum, as is also Medlar gum, from a small tree *Mespilus germanica*, of the same family as the cherry, grown in Europe and the Near East.

**Mullite.** A mineral found originally in the Isle of Mull and employed as a refractory material for firebrick and furnace linings. The natural material occurs as fused argillaceous sediment inclusions in the mineral Buchite, but it is rare and is produced artificially. It can be made by decomposing Sillimanite by heating to 1850°C. Artificial mullite, or Synthetic mullite, made by a prolonged fusing in the electric furnace of a mixture of silica sand or diasporic clay and bauxite, has the composition  $3\text{Al}_2\text{O}_3 \cdot 2\text{SiO}_2$ . It is valued as a refractory because it does not soften below its high melting point, 3290°F, and will withstand continuous temperature changes. Sillimanite, as well as Andalusite found in California, has the composition  $\text{Al}_2\text{O}_3 \cdot \text{SiO}_2$ , with the same melting point and a specific gravity of 3.20. Diaspore andalusite from Mono County, California, is used for spark plugs. Mullite is also made by burning silica clay and alumina at a very high temperature, and is used for making spark plugs, chemical crucibles, and extruding dies. For spark-plug cores it is fired at a temperature of 1450°C and aged before use. The tensile strength is above 9,000

psi, or double that of porcelain, and it has high dielectric strength. The hardness is 6 to 7 Moh. Sillimanite is decomposed to mullite and silica when heated above 1550°C. Dumortierite, produced in Nevada, has the composition  $8\text{Al}_2\text{O}_3 \cdot \text{B}_2\text{O}_3 \cdot 6\text{SiO}_2 \cdot \text{H}_2\text{O}$ . Deep-blue crystals of this mineral from the Colorado River resemble lapis lazuli and are cut as gem stones. A high-grade electric porcelain material marketed by Champion Sillimanite, Inc., under the name of Champion Sillimanite, is a mixture of andalusite and dumortierite. Shamra is the trade name of a mullite refractory produced by the Mullite Refractories Co. Mullfrax is a mullite refractory of the Carborundum Co. A synthetic mullite made by fusing a mixture of kyanite and alumina is known as Durox and is used for spark-plug porcelains.

**Muntz metal.** A yellow brass containing 60% copper and 40 zinc, invented in 1832 by George F. Muntz. In England it is called Yellow metal. It is also known as Malleable brass, and is now a standard product of the brass mills. Muntz metal has a tensile strength, when annealed, of 52,000 psi, elongation 50%, and Rockwell B hardness 30. When hard-rolled, the strength is 85,000 psi. The weight is 0.3015 lb per cu in. It is used for sheathing, marine fittings, bolts, and parts exposed to corrosion. Wrought muntz metal is frequently modified with small amounts of tin to give greater hardness and corrosion resistance, and is then called Naval brass or Naval bronze. The usual composition is 60% copper, 39.25 zinc, and 0.75 tin. The Roman bronze of the Revere Copper & Brass, Inc., has this composition, and the naval brass of this company has 60% copper, 39 zinc, 0.75 tin, with 0.2 lead to make it easy machining. Roman bronze has a tensile strength, annealed, of 60,000 psi, and elongation 45%. When hard-drawn, the strength is 82,000 psi, and elongation 20%. The leaded naval brass is slightly lower in strength.

Federal specifications for naval brass rod call for 0.5 to 1.5% tin and 0.20 lead. Chamet bronze, of the Chase Brass & Copper Co., has this composition. The naval brass marketed by the American Brass Co. under the name of Tobin bronze contains 59 to 60% copper, 0.5 to 1 tin, and the balance zinc. In rod form it has a fine-grained structure. The tensile strength of the soft rod is 52,000 psi, and of the hard-drawn bar 67,000 psi. The electrical conductivity is 25% that of copper. A Forging bronze used for corrosion-resistant marine

parts, fittings, and hardware, has 58.5% copper, 39.2 zinc, 1 tin, and 1 iron. It forges easily, and produces parts with a tensile strength from 60,000 to 75,000 psi. Bronzes with considerable amounts of tin are difficult to hot-work because of tin sweat, and because low-melting impurities such as lead and bismuth segregate in the grain boundaries.

Forging brass is usually muntz metal containing up to 1.75% lead, with frequently some iron. The Mueller Brass Co. uses alloys with 56 to 63% copper, 0 to 3 lead, and 0 to 3 tin. With the copper content below 56% the brass is brittle; with copper above 63% the wear on dies is high. Brass forgings made in smooth dies are tough and compact and need no polishing, being simply pickled in a nitric acid bath to bring out the color. Forging brass in England is called Hot-stamping brass. The British standard, BES 218, calls for 58% copper, 40.5 zinc, and 1.5 lead. The 60-40 brass modified with lead is also called Extruding brass.

Muntz metal is also modified with small amounts of iron and manganese. Delta metal, first marketed by Alexander Dick in 1883, was a 60-40 brass modified with iron, manganese, and a small amount of lead. An earlier brass known as Aich's metal had 60% copper, 38.2 zinc, and 1.8 iron. Somewhat similar casting brasses were called Gedge's metal and Stegro metal, and a forging alloy was called Macht's metal. Iron above 0.35% forms a separate iron-rich constituent which is stable and gives hardness and high strength to the alloys. The addition of manganese helps to absorb the iron and also hardens the alloy. These alloys were also called High-strength brass, and were employed for such uses as hydraulic cylinders and marine forgings, but are now largely replaced by manganese bronze or aluminum bronze. Durana metal was a forging brass with 1.5% iron and 1.5 aluminum.

**Music wire.** A high-grade, uniform steel originally intended for strings for musical instruments, but now employed for the manufacture of spiral springs. It is the highest grade of spring wire and is made of acid open-hearth steel or electric steel, free from slag or dirt, and low in sulphur and phosphorus. The carbon content is about 0.80%. The tensile strength, when hard-drawn, is from 225,000 to 400,000 psi, but it should be tough enough to bend

180° flat upon itself without cracking, or wind into a close helix with inside diameter 1 to  $1\frac{1}{2}$  times the diameter of the wire. The wire 0.187 in. in diameter has an ultimate strength of 230,000 psi; 0.015 wire has a strength of 400,000 psi. The wire is usually marketed in gage sizes according to the Washburn & Moen and the music-wire gages. Wire below 0.034 in. in diameter (No. 15 gage) is furnished on reels. Larger sizes are in coils. Music wire for springs is from No. 00, which is 0.0085 in. in diameter, to No. 36, which is 0.102 in. The smallest size of music wire, 0.003 in. in diameter, has 38,026 ft per lb. Piano wire, intended for piano strings but much used for springs, is a cold-drawn, high-quality wire formerly only drawn from Swedish billets or rods but now made from American steels. Piano wire ranges in diameter from 0.03 to 0.065 in. Starting with No. 7 rod there may be as many as 40 draws before the finished wire is produced. The tensile strength of piano wire is from 350,000 to 400,000 psi. The Supertensile steel wire developed by the American Steel & Wire Co. for A strings of guitars is a high-carbon steel made by long cold working and heat-treatment. It has a tensile strength of 460,000 psi, permitting a vibrational load of 37.7 lb on a 0.010-in. wire. The Tire cord wire of this company, used for automobile tire plies and extra-thin conveyer belts, has a tensile strength of 350,000 psi. The 0.0059-in. wire is stranded into a  $\frac{1}{32}$ -in. yarn and coated with rubber to make the ply. Steel wire with tensile strengths above 300,000 psi and having tolerances within 0.0002 in. is now regularly made in American mills. Stitching wire, for wire-stitching machines, is carbon steel wire of 0.0475 in. diameter with a tensile strength of 290,000 psi.

**Muslin.** A plain, white cotton fabric with a downy nap on the surface. It has a great variety of uses, and industrially is employed for filtering, sacking, and lining. The full-bleached muslin is usually made of finer yarns than the unbleached. In the cheaper grades it is sometimes heavily sized, but the sizing is removed in washing. For polishing cloths it should be unsized.

**Mustard.** A pungent yellowish powder produced from the seeds of the Black mustard, *Brassica nigra*, and the White mustard, *B. alba*, an annual plant of the turnip family grown in most temperate-climate countries. The ground seeds are treated with water, and the enzyme

action yields a complex sulphur compound with a sharp taste and pungent action. It is used as a condiment, and in medicine as a counterirritant and emetic. It is one of the most ancient of the condiments and has a stimulating effect on the salivary glands. The product from the black mustard is more pungent than that from the white, and ground mustard may be a mixture of the two to give the desired pungency. Mustard oil is a volatile oil obtained from the seeds. It is a powerful vesicant and has a pungent aromatic odor. It is used in medicine and in flavors. Mustard seed which yields on expression the fixed Mustard-seed oil used extensively in India as a food oil and in lubricants is *B. juncea*. It is closely related to rape oil, containing about 50% erucic acid. Another variety of *Brassica* of India yields Jamba oil, which contains 46% erucic acid and is a substitute for rape oil for lubricants.

**Myrobalan extract.** A liquid or solid extract made from the dried, unripe fruit of several species of *Terminalia*, especially *T. chebula* of India and China. The *Phyllanthus emblica* of India also yields the fruit. The dried fruit, which resembles a plum, contains 30 to 40% tannin in the pulp. The fruit is graded and marketed as Myrobalans chiefly on the basis of color, the lighter the color the higher the grade. The best grades of fruit are oval, pointed, and solid in structure. Inferior grades are round and spongy. The Bimlies from Madras are rated best. Liquid myrobalan extract contains 25 to 30% tannin, and solid extract contains about 53%. It is used in tanning light leathers, and gives a quick tan. The natural acidity of myrobalan plumps the leather, but when used alone on heavy hides it makes a porous leather. It is used with other tannins.

**Naphtha.** A light, colorless to straw-colored liquid which distills off from petroleum between 70 and 90°C. The specific gravity is from 0.631 to 0.660, or slightly higher, ranging from  $C_6H_{14}$  to  $C_7H_{18}$ . The lightest of the distillates used as solvents for fats, rubber, and resins approaches petroleum ether; the heaviest distillates approach benzine and gasoline, and are used for fuel. Benzine is a light distillate ranging from  $C_8H_{18}$  to  $C_9H_{20}$ , with specific gravity from 0.635 to 0.660, and boiling point limits from 120 to 150°C. Petroleum ether, or Petroleum spirits, ranges from  $C_5H_{12}$  to  $C_6H_{14}$  and is distilled off between 40 and 60°C. Benzine is used as a solvent, as a



cleaner, and in lighters. Varnolene and White spirit are old names for petroleum ether used as a varnish solvent.

The name naphtha is also applied to various grades of light oils obtained in the distillation of coal tar. These include Solvent naphtha, having a specific gravity of 0.862 to 0.872, with a boiling point below 160°C, and Heavy naphtha, a dark liquid of specific gravity between 0.925 and 0.950, and boiling point between 160 and 220°C. High-flash naphtha for solvent purposes is a petroleum fraction with a specific gravity within the range of the gasolines and a boiling point from 150 to 200°C. Various trade names are given to the light petroleum distillates used as solvents and in paints and varnishes. Naphtholite, of the Globe Chemical Co., has a specific gravity of 0.737, and an initial boiling point at 102°C. Solvesso, of the Esso Marketers, is a hydrogenated distillate in various grades with specific gravities from 0.797 to 0.937. Grade 1 has a boiling range from 93 to 135°C. Stoddard solvent is a standardized fraction of petroleum, or naphtha, used in dry cleaning or as a solvent. It is water white in color, flash point above 100°F, and consists in the distillation fraction not over 410°F with 50% below 350°F.

**Naphthalene.** Also called Tar camphor. A white solid of the composition  $C_{10}H_8$ , which is one of the heavy distillates from coal tar, and may also be obtained from natural gas. Crude naphthalene has a melting point of 70 to 78.5°C. The pure crystalline flakes melt at 79.4°C and boil at 218°C, but vaporize slowly at room temperature. It burns with a smoky flame. It is not soluble in water, but is soluble in benzene and in hot alcohol. The refined product is marketed in balls, flakes, and pellets, largely for use as an insect repellent. The crude is used in making dyestuffs, phthalic anhydride, synthetic resins, chlorinated products, coatings, sealing compounds, and in celluloid. Naphthalene crystals are very transparent to fluorescent radiation, and light produced in thick layers can escape and reach a photo surface. Low pulses can be obtained from the absorption of beta and gamma rays in naphthalene. It is thus used in photo multiplier tubes as a gamma-ray detector.

Halowax, of the Halowax Co., is a noninflammable chlorinated naphthalene used for waterproofing and fireproofing fabrics and cable coverings. Halowax oil is used as a solvent for rubber and resins.

**Monoamyl naphthalene**, used to give plasticity to synthetic resins at low temperatures, is an amber liquid,  $C_{10}H_7C_5H_{11}$ , specific gravity 0.96, and boiling point  $279^{\circ}\text{C}$ . On hydrogenation, naphthalene yields the solvents tetralin and decalin. Tetralin,  $C_{10}H_{12}$ , has a specific gravity of 0.975, and boiling point  $206^{\circ}\text{C}$ . It is a clear liquid that is a good solvent for fats, oils, and resins. It will burn with a bright flame and can also be used as a fuel. The flash point is  $78^{\circ}\text{C}$ . Decalin,  $C_{10}H_{18}$ , is a liquid with specific gravity of 0.884, and boiling point  $190^{\circ}\text{C}$ .

**Neatsfoot oil.** A pale-yellow, inedible oil obtained by boiling the feet of cattle or sheep in water, skimming the oil from the surface, and pressing through a filter. The oil is used for leather finishing, and for lubricants for fine mechanisms. For high-grade cold-test lubricating oil for fine instruments the stearin is pressed out. The specific gravity of neatsfoot oil is 0.916, iodine value 74, and saponification value 197. The oil is noted for its resistance to rancidity. It contains a high percentage, 79%, of oleic acid, and some bone oil which acts as a stabilizer.

**Neon.** A rare gas, symbol Ne, which occurs in minute quantities in the atmosphere with helium and argon. It is procured from the air by liquefaction. When it is energized, it emits light and is used for signs and in glow lamps. The specific gravity, compared with air, is 0.674. It liquefies at  $-245^{\circ}\text{C}$ . It is colorless, but gives a reddish-orange glow in lamps to which an electric current is applied. Neon is also used in voltage-regulating tubes for radio apparatus, and will respond to low voltages. In television the neon lamp will give fluctuations from full brilliancy to total darkness as many as 100,000 times a second. In the atom of the gas neon there are claimed to be 10 negative electrons revolving in regular orbits around one positive nucleus. The ionization, or tearing away of an electron, and the recombination produce the glow. All colored electric advertising signs are often referred to as neon signs, but the colors other than orange are produced by different gases. Argon gives a purple light when an electric current is passed through it. Krypton, an elementary gas, occurring in the air to the extent of 1 part in 1 million, gives a pale-violet light. It liquefies at  $-152^{\circ}\text{C}$ . Xenon, another gas occurring in the air to the extent of 1 part in 11 million, gives a sky-blue

to green light. Krypton and xenon are very inert and will not combine with other elements even at high temperatures. Krypton is used in fluorescent lamps and gives 17% greater brightness than argon. The 3-billion-candlepower aircraft approach lights first used on the Berlin airlift contained krypton. Krypton and xenon are also used instead of mercury vapor in vacuum tubes. These two gases have lower thermal conductivity and lower electrical resistance than argon.

**Nickel.** A silvery-white metal with a yellowish cast first isolated in 1751, but used in alloy with copper since ancient times. Nickel has a specific gravity of 8.84, melts at 2646°F, and is magnetic up to 680°F. It is marketed in grains or powder, in electrolytic sheets, blocks, shot, and in malleable forms. The metal is resistant to corrosion and to most acids except nitric. The electrical conductivity is 16% that of copper. The tensile strength of hard-rolled sheet is 115,000 psi, elongation 5%, and Rockwell B hardness 100. The tensile strength when annealed is 70,000 psi, elongation 45%, and hardness 60. Commercially pure wrought nickel contains some cobalt which alters its physical properties. The nominal composition of Canadian nickel is 99.4% nickel including cobalt, 0.2 manganese, 0.1 copper, 0.1 carbon, 0.15 iron, and 0.05 silicon.

Nickel is difficult to cast when pure as it absorbs oxygen and also dissolves carbon and sulphur. Z nickel, of the International Nickel Co., is a 98% nickel with alloying elements. The tensile strength, hot-rolled, is 105,000 psi, with 15 to 35% elongation. When cold-drawn, the tensile strength is 120,000 to 175,000 psi, elongation 15 to 25%, and Brinell hardness 220 to 340. The electrical conductivity is 12% that of copper. D nickel contains 95.2% nickel and 4.5 manganese. In the annealed state it has a tensile strength of 75,000 psi, elongation 40%, and Brinell hardness 140. Nickel has its greatest use in alloys, particularly in alloy steels, cupronickel, nickel brasses, and German silver. It is also used to make white gold, 15% nickel changing the color of gold to white. Nickel steels have high strength and resistance. Nickel is also used in coinage alloys and in commercial heat-resistant and corrosion-resistant alloys.

More than 85% of the world's nickel production comes from Ontario, Canada, and most of the remainder from the garnierite ores of New Caledonia. The standard ASTM grades of virgin nickel ore

are Electrolytic, containing 99.5% nickel; X shot, containing 98.9; A shot, with 97.75; and Ingot, with 98.5. But electrolytic nickel is available 99.95% pure, including not over 0.04 cobalt. Nickel shot, for adding nickel to iron in the ladle, is a master alloy of nickel and iron containing 50% nickel.

**Nickel alloys.** Any alloy containing nickel as the base metal, or as the chief alloying element. Nickel goes into solution in copper in all proportions and continually raises the melting point of copper alloys. In brasses and bronzes, nickel is used for the color effect and for toughening and strengthening the alloys. Nickel is employed in both ferrous and nonferrous alloys to produce heat-resistant and acid-resistant metals. Nickel-manganese alloys are used for electric-resistance wire. These alloys are also used as Cold-resistant alloys in places where steel or iron would be brittle at low temperatures. AMF alloy, for liquid-air valves, is a French alloy containing 55 to 60% nickel, up to 3 manganese, 0.4 carbon, and the balance iron, which will withstand shocks at low temperatures. A group of Acid-resistant alloys is produced with nickel as the base and silicon as the hardener, with sometimes other elements. A group of acid-resistant alloys marketed by the Burgess-Parr Co. under the names of Illium and Parr metal, are complex alloys. A typical analysis of Illium is nickel, 60.65%; chromium, 21.07; copper, 6.42; molybdenum, 4.67; tungsten, 2.13; silicon, 1.04; aluminum, 1.09; manganese, 1; and a small amount of iron. It is a very dense metal and has been used for chemical pump castings. Illium R has a tensile strength of about 100,000 psi when cold-rolled and annealed, and up to 150,000 psi with hardness 365 when hard-rolled. A corrosion-resistant alloy that is free of copper and iron is Waukesha metal 23 of the Waukesha Foundry Co. It contains 78 to 82% nickel, 7 to 9 tin, 6 to 9 zinc, about 4 lead, and 2 manganese. The castings have a tensile strength of 92,000 psi, elongation 9 to 13%, and Brinell hardness 185 to 200. This alloy is also used as a bearing metal for stainless-steel shafts.

Copper-nickel-iron alloys, used for hardware and plumbing fixtures, are white in color and resistant to acids and corrosion. Aterite, of the Aterite Co., is a group of casting alloys containing 10 to 40% nickel, 30 to 60 copper, 5 to 10 iron, and sometimes up to 5 of zinc or 2 of lead. Grades for wrought metals contain little iron. Alcumite,

of the Duriron Co., is a yellow, copper-base alloy containing nickel, aluminum, iron, and manganese. Hastelloy is the trade name of the Haynes Stellite Co. for a group of corrosion-resistant alloys that have high strength at elevated temperatures. They are marketed as castings, plate, rod, tube, and welding rod. Hastelloy A is particularly resistant to hydrochloric acid. It contains 60% nickel, 20 molybdenum, and 20 iron. It has a specific gravity of 8.8, tensile strength, annealed, of about 115,000 psi, and Brinell hardness 97. It casts easily and resists most acids except nitric. Hastelloy C contains chromium and is resistant to nitric acid and to free chlorine. The tensile strength is 122,500 psi, and Brinell hardness 160 to 210. Hastelloy D contains 90% nickel, 3 copper, 1.5 aluminum, and about 5 silicon. It is resistant to hot sulphuric acid. The tensile strength is 38,000 psi.

Strong and wear-resistant cast irons usually contain nickel, such as Cariron and Bryiron, of the Fillmore Foundry, Inc., and Diamite, of the Weatherly Foundry & Mfg. Co. The former two have about 1.5% nickel, and the last one 4.5% nickel with 1.5 chromium. Many jewelry alloys, for cheap jewelry, contain nickel. An old alloy known as Paris metal and Lutecine, contained 80% copper, 16 nickel, 1 cobalt, 2 tin, and small amounts of iron and zinc. Nickel is added to many aluminum alloys to increase the tensile strength and to improve the finish. For this purpose it is added in the form of a master alloy, Nickel-aluminum, containing 20% nickel and melting at 1418°F.

**Nickel brass.** The alloys that come naturally into this designation are more usually termed nickel silver or are known under a wide variety of trade names. Nickel-silicon brass contains very small percentages of silicon, usually about 0.60%, which forms a nickel silicide,  $\text{Ni}_3\text{Si}$ , increasing the strength and giving heat-treating properties. Rolled nickel-silicon brass, containing 30% zinc, 2.5 nickel, and 0.65 silicon, has a tensile strength of 114,000 psi. Imitation silver, for hardware and fittings, is a nickel brass containing 57% copper, 25 zinc, 15 nickel, and 3 cobalt. The bluish color of the cobalt neutralizes the yellow cast of the nickel and produces a silver-white alloy. Silvel is a nickel brass containing 67.5% copper, 16 zinc, and 6.5 nickel, with sometimes a little cobalt. Nickel brass is an alloy used where white color and corrosion resistance are desired.

Seymourite is the trade name of an alloy of 64% copper, 18 nickel, and 18 zinc, produced by the Seymour Mfg. Co. It has a white color and is corrosion-resistant. Nickeline, used by the Yale & Towne Mfg. Co. for hardware, has 58 to 60% copper, 16.5 nickel, 2 tin, and the remainder zinc. It has high strength, a white color, and casts well. Nickelene is an old name applied to nickel brass of various compositions, but an alloy patented in 1912 under this name had 55% copper, 12.5 nickel, 20.5 zinc, 10 lead, and 2 tin. Most of these alloys have good casting qualities, but they do not machine easily unless they contain some lead. Up to 2% lead does not affect the color and does not decrease the strength greatly. Tuc Tur, of the Tuc Tur Metal Corp., is a nickel brass containing 15% nickel and 22 zinc. Sterlite, of the Sterlite Foundry & Mfg. Co., contains 25% nickel and 20 zinc, with small amounts of iron, manganese, silicon, and carbon. A series of corrosion-resistant nickel brasses is marketed by the American Brass Co. under the name of Ambrac. Ambrac No. 850 contains 75% copper, 20 nickel, and 5 zinc. The tensile strength is 50,000 psi, soft, and 110,000 hard-drawn. Other alloys contain more nickel.

**Nickel bronze.** A name given to bronzes containing nickel, which usually replaces part of the tin, producing a tough, fine-grained, and corrosion-resistant metal. A common nickel bronze containing 88% copper, 5 tin, 5 nickel, and 2 zinc, has a tensile strength of 48,000 psi, elongation 42%, and Brinell hardness 86 as cast. When heat-treated or age-hardened, the tensile strength is 87,000 psi, elongation 10%, and Brinell hardness 196. Small amounts of lead take away the age-hardening quality of the alloy, and also lower the ductility. But small amounts of nickel added to bearing bronzes increase the resistance to compression and shock without impairing the plasticity. A bearing bronze of this nature, U.S. Navy 46B22, for heavy loads at high speeds, contains 15 to 20% lead, 73 to 80 copper, 5 to 10 tin, and 1 nickel. For decorative bronze parts, nickel is used to give a white color. In the hardware industry the old name Chinese bronze is sometimes used for these white alloys, and at least 10% nickel is needed to give a white color. This amount also gives corrosion resistance to the alloy. When more than 15% nickel is used, the bronzes are difficult to machine unless some lead is added. Hardware and plumbing fixtures of these alloys do not require plating. Eclipse

bronze is a white bronze of Sargent & Co. M-M-M alloy, of Manning, Maxwell & Moore, Inc., used for pressure valves for superheated steam, contains 60 to 65% nickel, 24 to 27 copper, 9 to 11 tin, and small amounts of iron, silicon, and manganese. Mercology, of the Merco Nordstrom Valve Co., is a white valve bronze containing 60% copper, 25 nickel, 10 zinc, 1 tin, 2 lead, and 2 iron. It has a tensile strength of 44,000 psi, with elongation 20%.

**Nickel cast iron.** A high-strength cast iron containing nickel. Nickel, like silicon, assists the graphite formation and the carbide decomposition, and therefore reduces chill and acts to eliminate hard carbide spots, chilled edges, and mottled areas. About 1% nickel is equivalent to  $\frac{1}{2}$ % silicon, but the effect of nickel is progressive, and does not make the iron brittle like silicon. Nickel in amounts from 0.5 to 10% will also progressively harden cast iron. A gray cast iron which will have a Brinell hardness of 174 is raised to 350 by the addition of 9% nickel. Since the nickel promotes the formation of the graphite in fine crystals, the iron has a high resistance to wear. Tensile strengths up to 65,000 psi are obtained in these irons. Nickel obstructs the passage of electric currents in iron, and iron with 5% nickel is used for resistance grids. High-nickel iron is also non-magnetic.

Most nickel irons contain small amounts of chromium to increase the chilling power and refine the grain. It also increases the strength and hardness. Ni-Tensyl iron is the trade name of the International Nickel Co. for a nickel cast iron made by adding to the melt a graphitizer of nickel-silicon to cause partial decomposition of the combined carbon. With 1.75% nickel this iron has high strength and a hardness of 320 Brinell. Nicrosilal, developed by the British Cast Iron Research Assoc., contains 5% silicon, 17 nickel, and 3 chromium. It has high-heat distortion resistance, and is used for heat-resistant castings. Lectrocast, of the Detroit Gray Iron Foundry, used for automobile body dies, has 2.75% nickel and 0.70 chromium. Tensloy, of the Ensign Foundry Co., and Novite, of the Novo Engine Co., have about 1.5% nickel and 0.50 chromium. Mitchalloy A, of the Robert Mitchell Co., Ltd., has 2.5% nickel and 0.90 chromium.

High nickel-chromium irons are used for pump and compressor parts handling hot liquids and may contain up to 30% nickel and 5

chromium. Nicroth metal, of the Q. & C. Co., is a heat-resistant nickel-chromium cast iron. Pyrocast is a high-test nickel-chromium cast iron of the Pacific Foundry Co. Niresist, developed by the International Nickel Co., is an alloy cast iron containing Monel metal with also chromium and manganese. A typical analysis range is nickel, 12 to 15%; copper, 5 to 7; chromium, 1.25 to 4; manganese, 1 to 1.5; silicon, 1 to 2; and total carbon, 2.75 to 3.1. The tensile strength is 20,000 to 35,000 psi, with a Brinell hardness 130 to 170. It can be chilled to a hardness of 350 to 400. It has a low coefficient of expansion, 0.0000100 per deg F, or about the same as the aluminum-silicon alloys used for pistons.

Vanadium in nickel irons adds strength and wear resistance. Vanick is the name of a Nickel-vanadium cast iron of the Malleable Iron Fittings Co. Nickel cast irons and Nickel-chromium cast irons are marketed under many trade names, such as Frankite, of the Frank Foundries Corp., Alco Ni-Iron, of the American Locomotive Co., Elfur iron, of the Cramp Brass & Iron Foundry, Tylerite, of the W. S. Tyler Co., Domite, of the Dominion Wheel & Foundry Co., and Maxtensile, of the Farrel-Birmingham Co. The nickel-chromium cast irons may also contain molybdenum for greater hardness and wear resistance. Ni-Chillite, of the Mackintosh-Hemphill Co., is a nickel-chromium-molybdenum chilled cast iron for heavy rolls. Mocasco iron, of the Motor Casting Co., is a wear-resistant iron capable of being cast into thin sections without chill. Mocasco 30, for cylinders, has 1 to 1.35% nickel, 0.25 to 0.30 chromium, and 0.75 molybdenum. Strenes metal is the name of the Advance Foundry Co. for a nickel-chromium-molybdenum cast iron for heavy dies. Durite is a wear-resistant iron of the Birdsboro Steel Foundry & Machine Co. Ironite, of the Kinite Corp., is a chromium-nickel-vanadium cast iron used for cams, gears, and wear-resistant parts.

**Nickel-chromium alloys.** A group of alloys of nickel and chromium employed as heat-resistant metals, for resistance wires, and as corrosion-resistant metals for chemical machinery. An alloy of 80% nickel and 20 chromium will withstand temperatures up to 2100°F without oxidation. Chromel A, of the Hoskins Mfg. Co., has this composition. The resistivity is 650 ohms per cir mil ft, tensile strength 120,000 psi, and melting point 1420°C. Chromel C, with 60%



nickel, 16 chromium, and 24 iron, has an electrical resistivity 10% higher than Chromel A at high temperatures, but its oxidation resistance is limited to 1700°F. It is used for electrical appliance heating wire. Chromel D contains 35% nickel, 18.5 chromium, and the balance iron. Its resistivity at room temperature is 600 ohms per cir mil ft, but its hot resistivity is greater than that of Chromel A. It is for temperatures not over 1200°F.

A group of heat-resistant and corrosion-resistant casting alloys, under the name of Misco alloys, is produced by the Michigan Steel Casting Co. Misco metal contains 35% nickel and 10 chromium, with the balance iron. Misco C contains 29% chromium, 9 nickel, 0.55 manganese, 0.60 silicon, and 0.25 carbon. Miscrome is very resistant to nitric acid. It contains 28% chromium with no nickel. Centricast alloys, of this company, are these corrosion-resistant alloys centrifugally cast for pipes. A wide range of alloys for heat-resistant parts are marketed by the Electro-Alloys Div., American Brake Shoe Co., under the name of Thermalloy. Thermalloy 72, for temperatures to 2000°F, has 12 to 14% chromium and 58 to 63 nickel. Thermalloy 40 is a general-use machinable alloy to resist temperatures from 1200 to 1500°F. It contains about 26% chromium and 12 nickel. Chemalloy F32M, of this company, is primarily for parts to resist chemical action. It has 26 to 29% chromium, 3 to 6 nickel, and 1 to 1.5 molybdenum. It has high strength at elevated temperatures, is resistant to sulphur atmospheres, and is used for parts for refineries and pulp mills.

A group of heat-resistant and acid-resistant nickel-chromium alloys is produced by the Standard Alloy Co. under the name of Standard-alloy. Another group is marketed by the Cooper Alloy Foundry Co. under the names of Sweetaloy and Cooper alloys. Cooper alloy S-16 has 14 to 20% chromium and 65 nickel; Cooper alloy S-21A is this combination with 3% molybdenum and 1.5 silicon. Cimet, of the Driver-Harris Co., used for mine pump parts, has 26% chromium, 10 nickel, and the balance iron. Gridnic alloys, of this company, are nickel-chromium alloys used for radio grids. Nirex, of the same company, has 80% nickel, 14 chromium, and 6 iron. In annealed sheet form it has a tensile strength of 90,000 psi with elongation 50%. Chromel No. 502 has 36% nickel, 20 chromium, and the balance iron. It is used for furnace fixtures, either rolled or cast. Inconel,

developed by the International Nickel Co., used for dairy and food equipment, contains 79.5% nickel, 13 chromium, 6.5 iron, 0.08 carbon, and slight amounts of copper, manganese, and silicon. The tensile strength of the hot-rolled plate is 100,000 to 140,000 psi with elongation 20 to 40%, and Brinell hardness 160 to 240. Heat-treating boxes of this alloy give furnace service life of 12,000 hr at 2000°F. Inconel X, a wrought alloy for gas turbine blades, contains 70 to 73% nickel, 15 chromium, 2.5 titanium, 0.70 to 1.20 columbium, 0.40 to 1 aluminum, 5 to 9 iron, 0.30 to 1 manganese, 0.5 max silicon, 0.20 max copper, and 0.08 max carbon. It has a tensile strength of 160,000 psi, retains 90% of its strength at 900°F, and 80% up to 1100°F. The specific gravity is 8.3, and the melting range is 2540 to 2600°F. It can be age-hardened to 400 Brinell, but loses its hardness at 1500°F.

Nickel-chromium-iron alloys, with silicon and other elements forming complex alloys, are employed for acid-resistant and corrosion-resistant castings and wrought metals for high temperatures. Durimet, of the Duriron Co., Inc., is marketed in various grades normally containing 19.5 to 23% nickel, 18 to 22 chromium, 2.75 to 3.75 silicon, 0.50 to 0.75 manganese, 1 to 1.5 molybdenum, and 0.25 to 0.45 copper. Durimet 20 contains 29% nickel, 20 chromium, 1.75 molybdenum, 3.5 copper, 1 silicon, and 0.07 max carbon. The heat-treated castings have a tensile strength of 65,000 to 75,000 psi, elongation 35 to 50%, and Brinell hardness 120 to 150. It is especially resistant to sulphuric and mixed acids. This alloy is produced as Esco 20 by the Electric Steel Foundry Co., as Misco 20 by the Michigan Steel Castings Co., and as Utilloy 20 by the Utility Electric Steel Foundry. Carpenter stainless 20 is this alloy in wrought forms with slightly less copper and more molybdenum. The tensile strength of the wrought bar is 85,000 psi, elongation 35 to 50%, and hardness 150 to 180 Brinell. Chemalloy N4, of the Electro-Alloys Div., used as a stain-resistant metal for food equipment, contains 30% nickel, 5 chromium, 5 silicon, and the balance iron. It will resist oxidation to 1400°F. Rezistal, of the Crucible Steel Co., is marketed in many grades resistant to heat, acids, and corrosion. They include stainless steels and special composition nickel-chromium alloys. Rezistal 2600, formerly known as Atha's 2600 alloy, contains 22% nickel, 8 chromium, 1.75 silicon, 1 copper, 0.70 manganese, and

0.25 carbon. It is nonmagnetic, resistant to acids, and is easily machinable.

**Nickel-chromium steel.** Steel containing both nickel and chromium, usually in a ratio of 2 to 3 parts nickel to 1 chromium. The 2:1 ratio gives great toughness, and the nickel and chromium are intended to balance each other in physical effects. The steels are especially suited for large sections which require heat treatment, because of the deep and uniform hardening power. Hardness and toughness are the characteristic properties of these steels. Nickel-chromium steel containing 1 to 1.5% nickel, 0.45 to 0.75 chromium, and 0.38 to 0.80 manganese, is used throughout the carbon ranges for casehardened parts and for forgings where high tensile strength and great hardness are required. Steel with from 3 to 5% nickel, 1.8 to 2.5 chromium, and 0.30 to 0.40 carbon is employed for heavy armor plate, while armor-piercing projectiles are made from steel containing 0.50% nickel, 2.5 chromium, and 0.50 carbon.

Low nickel-chromium steels, but with more carbon, from 0.60 to 0.80%, are used for drop-forging dies and other tools. R.D.S. steel, of the Carpenter Steel Co., is an oil-hardening, tough tool steel containing 1.75% nickel, 1 chromium, 0.50 manganese, and 0.75 carbon. An industrial steel of this company, Carpenter No. 5-317, contains the same amounts of nickel and chromium, but 0.50 carbon and less manganese. It is oil-hardening, and used for gears, shafts, and shock-resisting parts. The tensile strength is up to 295,000 psi. Samson steel, of this company, used for machinery parts for severe service, contains 1.25% nickel, 0.60 chromium, 0.50 manganese, and various amounts of carbon. The 0.40 carbon steel, when heat-treated, has a tensile strength of 240,000 psi and Brinell hardness 440. Beaver steel, of the Colonial Steel Co., used for water-quenched forging-die blocks, contains 1.5% nickel, 0.75 chromium, 0.60 manganese, and 0.55 carbon. Colona steel, of the same company, used for oil-quenched forging dies, has the same nickel and chromium content, but somewhat more manganese and carbon. Nikro-Trimmer steel, of this company, used for hot trimming dies, has higher carbon, 0.85%, but only small amounts of nickel and chromium, 0.30 to 0.55%, respectively. Simplex steel, of the Crucible Steel Co. of America, used for forgings, has 1.25% nickel and 0.60 chromium.

In the low-carbon, casehardening grades, for gears, it has a tensile strength of 90,000 psi. SAE steel 3330, containing 3.5% nickel and 1.5 chromium, when oil-tempered, has a tensile strength of 205,000 psi and elongation 13%. Quality steel is the trade name of Quality Steels, Ltd., for nickel-chromium steels in various grades.

Nickel-chromium steels may have temper brittleness, or low impact resistance, when improperly cooled after heat-treatment. A small amount of molybdenum is sometimes added to prevent this brittleness. Encem steel, of W. T. Flather, Ltd., is a molybdenum steel of this type. Miraculoy, of the Sivyer Steel Castings Co., contains 1.25% nickel, 0.65 chromium, 0.40 molybdenum, and 1.55 manganese. The tensile strength is 115,000 psi with elongation 18% and Brinell hardness 275. Miscoloy No. 60, of the Michigan Steel Casting Co., is another steel of this type. A nickel-chromium Coin steel, used by the Italian Government for coins, was a stainless type containing 22% chromium, 12 nickel, and some molybdenum.

Low-carbon nickel-chromium steels are water-hardening, but those with appreciable amounts of alloying elements require oil quenching. Air-hardening steels contain up to 4.5% nickel and 1.6 chromium, but are brittle unless tempered in oil to strengths below 200,000 psi. The alloy known as Krupp analysis steel contains 4% nickel and 1.5 chromium. The steel under the name of Millaloy, used by Doelger & Kirsten, Inc., for heavy shear blades, is of this analysis with 0.40% carbon. Blades hardened to 530 Brinell have an ultimate strength of 312,000 psi and elongation 11%. Nikrome is a nickel-chromium steel of Joseph T. Ryerson & Son, Inc. Nikrome M contains 2.25% nickel, 1 chromium, and 0.45 molybdenum, with 0.40 carbon. It is characterized by very high strength and uniform hardening, and can be machined up to 450 Brinell. H.T.M. Steel, of this company, is a 2% nickel steel with chromium and molybdenum. Nykrom is a steel of W. T. Flather, Ltd. Ohioloy is a nickel-chromium steel of the Ohio Steel Foundry Co. All of the nickel-chromium steels require special heat-treatment to bring out their best qualities, and all are difficult to machine.

**Nickel-cobalt alloys.** A group of alloys containing 20 to 30% cobalt and 70 to 80 nickel. Nickel has a yellowish cast and cobalt a blue cast; alloys of the two metals are almost pure white in luster

and resemble silver. They are expensive, because of the high cost of cobalt, but the two metals are codeposited in an electroplating bath to form an alloy deposit on iron, steel, or nonferrous metals. The alloy is harder than either nickel or cobalt alone, and is also more corrosion-resistant. Another type of nickel-cobalt complex alloy is Konal, developed by the Westinghouse Electric Corp., as a heat-resistant and acid-resistant alloy. It contains 73% nickel, 17.5 cobalt, 6.5 iron, 2.5 titanium, and 0.2 manganese. At a temperature of 600°C this alloy has a tensile strength of 66,000 psi. At ordinary temperatures the strength is 100,000 psi. It was developed for radio-tube filaments.

**Nickel copper.** An alloy of nickel and copper employed for adding nickel to nonferrous alloys. A 50-50 nickel copper has a melting point of 2330°F and dissolves readily. Nickel-copper shot of this composition is marketed for ladle additions to iron and steel. The Copper-nickel master alloy designated in Federal specifications contains 60% nickel, 33 copper, 3.5 manganese, and may contain up to 3.5 iron. Such an alloy is used for alloying high-strength bronzes. Copper-nickel alloy is also used for special purposes. A grade of Thermalloy, of the Electro Alloys Co., used as a temperature-sensitive magnetic metal for magnetic shunts in watt-hour meters, has 66.5% nickel, 30 copper, and 2 iron. The permeability falls off with increase in temperature and compensates for errors due to temperature changes.

**Nickel-molybdenum iron.** A group of alloys used for high acid resistance. They may contain up to 40% molybdenum, which takes the place of the chromium used in the more common corrosion-resistant alloys. The most usual alloy in this class contains about 20% iron, 20 molybdenum, 60 nickel, and small amounts of carbon. This alloy is very resistant to hydrochloric and sulphuric acids, but for high general acid resistance the iron content should be below 10%. Iron adds hardness and stiffness to the alloys, but decreases the acid resistance. Manganese improves the workability, but more than 3% decreases the acid resistance. With chromium the alloys are almost as resistant to corrosion as the noble metals. The alloys cast easily, and the 20-20-60 alloy is readily machinable. It can be hot-rolled into sheet, or cold-rolled. The melting point is 1300°C, and weight is 0.315 lb per cu in. The tensile strength, forged, is 118,000 psi

and Brinell hardness 207. This alloy is resistant to all acids except nitric. Chemalloy H1, of the Electro-Alloys Div., for severe acid resistance such as for valve and pump parts, contains 21% molybdenum, 21 iron, and the balance nickel.

**Nickel-molybdenum steel.** An alloy steel which is most used in compositions of 1.5% nickel and 0.15 to 0.25 molybdenum, with varying percentages of carbon up to 0.50%. These steels are characterized by remarkably uniform properties, are readily forged and heat-treated. Molybdenum produces toughness in the steels, and in the casehardened steel gives a very tough core. Roller bearings are made of this class of steel. A steel used by the Ingersoll Steel & Disc Co. for hand-shovel blades contains an average of 0.45% carbon, 0.50 manganese, 1.35 nickel, and 0.40 molybdenum. When hot-rolled and heat-treated, it has a tensile strength of 240,000 psi and elongation 6%. Superalloy steel, of this company, is SAE 3160. A 5% nickel steel with 0.30% carbon and 0.60 molybdenum has a tensile strength of 175,000 to 230,000 psi, with elongation 12 to 22%, depending upon the heat-treatment. Molybdenum is more frequently added to the steels containing also chromium, the molybdenum giving air-hardening properties, reducing distortion, and making them more resistant to oxidation.

**Nickel ores.** Nickel occurs in minerals as sulphides, silicates, and arsenides, the most common being Pyrrholite, or Magnetic pyrites, a sulphide of iron of the theoretical formula  $\text{Fe}_{11}\text{S}_{12}$ , but carrying nickel in considerable proportion. The chief sulphide ore deposit at Sudbury, Ontario, Canada, contains sulphides of iron, nickel, and copper. The ore is partly roasted to remove sulphur, and smelted to a matte containing about 45% iron. This is then bessemerized to a matte containing 75 to 80% nickel and copper. Some of the product is used as Monel metal without separating the natural alloy. The extensive ore deposits at Lynn Lake, Manitoba, yield an ore averaging 1.74% nickel and 0.75 copper. The Garnierite, or Noumeite, of New Caledonia is a nickel silicate containing also iron and magnesium. It is amorphous and earthy, of an apple-green color, with a specific gravity of 2.2 to 2.8, and hardness of 3 to 4. The ore contains about 5% nickel, and is smelted with gypsum to a matte of sulphides of nickel and iron, the sulphur coming from the gypsum. This is then

bessemerized, and the matte crushed, roasted to oxide, and reduced to nickel.

Millerite is a minor ore of nickel occurring in Europe and in various parts of the United States. It is a Nickel sulphide,  $\text{NiS}$ , containing theoretically 64.7% nickel. It is found usually in radiating groups of slender crystals with a specific gravity of 5.6, hardness 3.5, and of a pale-yellow color and metallic luster. Niccolite,  $\text{NiAs}$ , is a minor ore containing theoretically 43.9% nickel, usually with iron, cobalt, and sulphur. It is found in Canada, Germany, and Sweden. The mineral occurs massive, with a specific gravity of 7.5, hardness 5 to 5.5, and a pale-copper color. Nickel is also produced as a by-product from copper ores.

**Nickel silver.** A name applied in the machine industries to an alloy of copper, nickel, and zinc, which is practically identical with alloys known in the silverware trade as German silver. Packfong, meaning White copper, is an old name for these alloys. The very early nickel silvers contained some silver and were used for silverware. Wessell's silver contained about 2%, and Ruolz silver about 20%. Baudoin alloy, a French metal, contained 72% copper, 16 nickel, 1.8 cobalt, 2.5 silver, and the balance zinc.

Nickel silver is made in regular grades of 5 to 30% nickel, with up to 70% copper, and the balance zinc. Nickel whitens brass and makes it harder and more resistant to corrosion, but the alloys are more difficult to cast because of shrinkage and absorption of gases. They are also subject to fire cracking and are more difficult to roll and draw than brass. The most common nickel silver is the 18% nickel alloy with 55 to 65% copper, and the balance zinc. The higher copper grades are used for parts where there is much fabricating. As a spring material, with 55% copper, this alloy has a tensile strength of 110,000 psi, and Brinell hardness 160, when cold-rolled. The 12% alloy is a dense white metal, readily machinable, and much used for cast plumbing fixtures. Scovill nickel silver for soft-temper extrusions has 13% nickel, 43 copper, and 44 zinc. It contains alpha grains in an amorphous beta matrix. Benedict metal, of the American Brass Co., has 12.5% nickel, with 2 parts copper to 1 zinc. The cast metal has a strength of 35,000 psi with elongation 15%. The higher nickel alloys have more permanent white finish for parts sub-

ject to corrosion. Ambrac 854, of the American Brass Co., is a wrought metal with 65% copper, 30 nickel, and 5 zinc. Pope's Island white metal, of this company, used for jewelry, has 67% copper, 19.75 nickel, and 13.25 zinc. Victor metal is an alloy of 50% copper, 35 zinc, and 15 nickel, used for cast fittings. It is a white metal with a yellow shade. It casts easily and machines well.

For threaded parts and for casting metals, the nickel silvers usually contain some lead for easier machining. Federal specifications for casting metals call for 65% copper, 20 nickel, 4 tin, 5 lead, and 6 zinc. The White nickel brass, used for automotive cast parts for trim, is a standard 18% nickel alloy with or without lead. Silveroid, an English alloy for this use, is a cupronickel without zinc. An English alloy for tableware, under the name of Newloy, contains 35% nickel, 64 copper, and 1 tin. The Stainless nickel used for silverware by Viners, Ltd., has 30% nickel, 60 copper, and 10 zinc, and is de-oxidized with manganese copper, using borax as a top flux.

**Nickel steel.** Steel containing nickel as the predominating alloying element. The first nickel steel produced in the United States was made in 1890 by adding 3% nickel in a bessemer converter. The first nickel-steel armor plate, with 3.5% nickel, was known as Harveyized steel. Small amounts of nickel steel, however, had been used since ancient times, coming from Meteoric iron. The nickel iron of meteorites, known in mineralogy as Taenite, contains about 26% nickel.

Nickel added to carbon steel increases the ultimate strength, elastic limit, hardness, and toughness. It narrows the hardening range but lowers the critical range of steel, reducing danger of warpage and cracking, and balances the intensive deep-hardening effect of chromium. The nickel steels are also of finer structure than ordinary steels, and the nickel retards grain growth. When the percentage of nickel is high, the steel is very resistant to corrosion. Above 20% nickel the steel becomes a single-phase austenitic structure and appears under the microscope like a single metal. The steel is nonmagnetic above 29% nickel, and the maximum value of permeability is at about 78% nickel. The lowest expansion value of the steel is at 36% nickel. The percentage of nickel employed usually varies from 1.5 to 5%, with up to 0.80% manganese. The bulk of nickel steels contain 2



and 3½% nickel. They are used for armor plate, structural shapes, rails, heavy-duty machine parts, gears, automobile parts, and ordnance.

The standard ASTM Structural nickel steel used widely for building construction is an open-hearth containing not over 3.25% nickel, 0.45 carbon, and 0.70 manganese. This steel has a tensile strength from 85,000 to 100,000 psi and a minimum elongation 18%. An automobile steel used by one of the largest companies contains 0.10 to 0.20% carbon, 3.25 to 3.75 nickel, 0.30 to 0.60 manganese, and 0.15 to 0.30 silicon. When heat-treated, it has a tensile strength up to 80,000 psi and an elongation 25 to 35%. Forgings for locomotive crankpins containing 2.5% nickel, 0.27 carbon, and 0.88 manganese have a tensile strength of 83,000 psi, elongation 30%, and reduction of area 62%. A Nickel-vanadium steel, used for high-strength cast parts, contains 1.5% nickel, 1 manganese, 0.28 carbon, and 0.10 vanadium. The tensile strength is 90,000 psi and elongation 25%. Univan steel, of the Union Steel Casting Co., for high-strength locomotive castings, is a nickel-vanadium steel of this type. Unionalloy steel, of this company, is an abrasion-resistant steel.

The Federal specifications for 3½% nickel carbon steel calls for 3.25 to 3.75% nickel, and 0.25 to 0.30 carbon. This steel has a tensile strength of 85,000 psi and elongation 18%. A hot-rolled 3½% nickel medium-carbon steel, SAE 2330, when oil-quenched develops a strength up to 220,000 psi, and Brinell hardness from 223 to 424, depending upon the drawing temperature. Standard 3½ and 5% nickel steels are regular products of the steel mills, though they are often sold under trade names. Steels with more than 3.5% nickel are too expensive for ordinary structural use. Steels with more than 5% nickel are difficult to forge, but the very high-content nickel steels are used when corrosion-resistant properties are required. Nicloy, of the Babcock & Wilcox Tube Co., used for tubing to resist the corrosive action of paper-mill liquors and oil-well brines, contains 9% nickel, 0.10 chromium, 0.05 molybdenum, 0.35 copper, 0.45 manganese, 0.20 silicon, and 0.09 max carbon. The heat-treated steel has a tensile strength of 110,000 psi, with elongation 35%.

**Nickel sulphate.** A crystalline compound,  $\text{NiSO}_4 \cdot 7\text{H}_2\text{O}$ , used in nickel plating and for blackening brass and zinc. It is the most widely used salt for nickel-plating baths. It is known in the plating industry

as single nickel salts. It is prepared by dissolving nickel or nickel hydroxide in sulphuric acid. Nickel sulphate is sold in the form of crystals about the size of peas, and pea green in color. The specific gravity is 1.98, and the melting point is  $100^{\circ}\text{C}$ . It is soluble in water. Double nickel salt is Nickel ammonium sulphate,  $\text{NiSO}_4 \cdot (\text{NH}_4)_2 \cdot \text{SO}_4 \cdot 6\text{H}_2\text{O}$ , used for baths for plating on zinc. Nickel chloride,  $\text{NiCl}_2 \cdot 6\text{H}_2\text{O}$ , a green crystalline material soluble in water, is used with boric acid for nickel plating. It gives a finer grained, smoother, harder, and stronger nickel coating than with the nickel sulphate electrolyte. The bath is easier to control, and the power required is less. Nickel carbonate is another salt of nickel used for electroplating. It comes in green crystals of the composition  $2\text{NiCO}_3 \cdot 3\text{Ni}(\text{OH})_2 \cdot 4\text{H}_2\text{O}$ . It is not soluble in water, but is soluble in acids and in solutions of ammonium salts. Nickel carbonyl,  $\text{Ni}(\text{CO})_4$ , used for nickel plating by gas decomposition, is a liquid. When heated in a closed oven as a gas with hydrogen as the carrier, nickel is deposited at a temperature of  $356^{\circ}\text{F}$  to plate parts of wood, metal, or glass. It is a strong reducing agent, and will explode when mixed with oxygen.

**Nickel-tantalum alloy.** Nickel containing a percentage of tantalum in alloy. The usual composition is 70% nickel and 30 tantalum. The alloy is hard, but is easily rolled or drawn into wire. It is nonmagnetic and does not oxidize when heated to a high temperature. It is prepared by heating at a white heat a highly compressed mixture of the two metals in powdered form, and is formed by diffusion rather than fusion. The metal is used for electrical-resistance wires or for electrical apparatus.

**Nitric acid.** Also called Aqua fortis, and Azotic acid. A colorless to reddish fuming liquid of the composition  $\text{HNO}_3$ , having a wide variety of uses for pickling metals, etching, and in the manufacture of nitrocellulose, pyroxylin, plastics, dyestuffs, and explosives. It has a specific gravity of 1.502 (95% acid), boiling point of  $86^{\circ}\text{C}$ , and is soluble in water. Its fumes have a suffocating action, and it is highly corrosive and caustic. Fuming nitric acid is any water solution containing more than 86% acid and having a specific gravity above 1.480. Nitric acid is made by the action of sulphuric acid on sodium nitrate, or purified Chilean saltpeter, and condensation of the fumes. It is also made synthetically directly from ammonia. The acid is sold

in various grades, depending on the amount of water. The strengths of the commercial grades are 38, 40, and 42°Bé containing 67.2% acid. C.P., or reagent grade, is 43°Bé, with 70.3% acid, very low in iron, arsenic, or other impurities. It is usually shipped in glass carboys. Anhydrous nitric acid is a yellow fuming liquid containing a small amount of Nitrogen pentoxide,  $N_2O_5$ , to stabilize against water absorption. It is a violently reactive oxidizing agent and powerful nitriding agent. Nitrogen tetroxide,  $N_2O_4$ , is a dark-red, poisonous, corrosive liquid of specific gravity 1.5, and boiling point 21.15°C, used as a nitrating agent. It is also used as an oxidizer for rocket fuels, as it contains 70% oxygen. Mixed acid, or Nitrating acid, is a mixture of nitric and sulphuric acids used chiefly in making nitrocellulose and nitrostarch. Standard mixed acid contains 36% nitric and 61 sulphuric, but other grades are also used.

**Nitrocellulose.** A compound made by treating cellulose with nitric acid, using sulphuric acid as a catalyst. Since cotton is almost pure cellulose, it is the usual raw material. Waste cotton and cotton linters are employed after thoroughly scouring and digesting in a weak solution of soda. The cellulose molecule will unite with from 1 to 6 molecules of nitric acid. Trinitrocellulose,  $C_{12}H_{17}O_7(NO_3)_3$ , contains 9.13% nitrogen, and is the product used for plastics, lacquers, adhesives, and celluloid. It is classified as cellulose nitrate. The higher nitrates, or Pyrocellulose, are employed for making explosives. It was originally called Guncotton, and the original United States government name for the explosive was Indurite, from the Indian Head Proving Ground. It was called Cordite in England. The nitrated cellulose is mixed with alcohol and ether, kneaded into a dough, and squeezed through orifices into long multitubular strings which are cut into short cylindrical grains. Solid grains become smaller as they burn, so that there would be high initial pressure and then a decreasing pressure of gases. When the multitubular grains burn, the surface becomes greater and thus there is increasing pressure. FNH powder, or Flashless powder, is nitrocellulose which is nonhygroscopic and which contains a partially inert coolant, such as potassium sulphate, to reduce the muzzle flash of the gun.

**Nitrogen.** An element, symbol N, which at ordinary temperatures is an odorless and colorless gas. The atmosphere contains 79% nitro-

gen in the free state. It is nonpoisonous and does not support combustion. Small quantities of nitrogen are used in incandescent lamps to prevent arcing. Nitrogen atmospheres are also used for bright annealing of steel. It can be combined with many metals to form nitrides and is thus applied to the hardening of steel, the usual source for this purpose being from ammonia. Nitrogen in small amounts in steel inhibits grain growth at high temperatures. It refines the grain and increases the strength and corrosion resistance of high-chromium steels. The natural nitrates, soda niter and niter, are employed for the making of nitric acid and explosives, but for these uses they may be replaced by atmospheric nitrogen, which has been produced in increasing quantities. Fixation of nitrogen is a term applied to any process whereby nitrogen from the atmosphere is transferred into nitrogen compounds, or Fixed nitrogen, such as ammonia. Calcium cyanamide,  $\text{CaCN}_2$ , is made by reacting atmospheric nitrogen with calcium carbide in a kiln. It is used for fertilizer and as a chemical raw material. A nitrogen-containing gas, developed by the General Electric Co. under the name of Drycolene for furnace atmospheres for heat-treating steel and for sintering, contains 78%  $\text{N}_2$ , 20%  $\text{CO}$ , and 2%  $\text{H}_2$ . It is produced by burning hydrocarbon gases and air, removing the moisture, and passing through incandescent charcoal to convert any  $\text{CO}_2$  to  $\text{CO}$  and  $\text{H}_2$ .

**Nitroglycerin.** A heavy, oily liquid known chemically as Glyceryl trinitrate and having the empirical formula  $\text{C}_3\text{H}_5(\text{NO}_3)_3$ . It is made by the action of nitric acid on glycerin in the presence of sulphuric acid or some other substance having an affinity for water. It is a highly explosive compound, detonating upon concussion. Liquid nitroglycerin when exploded forms carbonic acid,  $\text{CO}_2$ , water vapor, nitrogen, and oxygen; 1 lb is converted into 156.7 cu ft of gas. The temperature of explosion is about 6280°F. For use as a commercial explosive it is mixed with absorbents, usually kieselguhr or wood flour, under the name of Dynamite. Cartridges of high density explode with a greater shattering effect than those of low density. By varying the density and also the mixture of the nitroglycerin with ammonium nitrate, which gives a heaving action, a great diversity in properties can be obtained.

Dynamites are rated on the percentage, by weight, of the nitro-

glycerin that they contain. In Extra dynamite half of the nitroglycerin is replaced by nitrate of ammonia. It is not so quick and shattering, but is useful in earth excavation. Durox is an Ammonium dynamite marketed by E. I. du Pont de Nemours & Co., Inc. Agritol is a low-density ammonium dynamite of the same company for blasting stumps and boulders. Gelatin dynamite is made by dissolving a special grade of nitrocotton in nitroglycerin. This type has less fumes, and is thus adapted for underground work. Its plasticity also makes it more adaptable for loading solidly in holes. It is marketed as straight gelatin or as Ammonium gelatin. Blasting gelatin is a strong and quick grade, and is waterproof. Gelobel is a gelatin dynamite, and Monobel is an ammonium dynamite marketed by Du Pont for mine blasting. The Gelodyn explosive of the Atlas Powder Co. is a combination of ammonium gelatin dynamite that is plastic, gives a shattering effect, and does not produce excessive fumes. It is used for construction blasting.

**Nondeforming steel.** Also called Nonshrinking steel. A group of alloy steels which have the characteristic that they do not easily deform, or go out of shape, when heat-treated. This property makes them suitable for making dies, gages, or tools that must be accurate. The usual nondeforming steel contains from 1 to 1.75% manganese, with or without chromium or other alloying elements. The carbon content is the same as tool steels of the same grade. The phosphorus, sulphur, and silicon impurities are kept as low as possible. The steels are oil-hardening, and do not have the tough core of ordinary tool steels. They have low resistance to shock and are thus not suited to bending or forming dies, except when they have additional alloying elements.

The nondeforming steel marketed by the Cyclops Steel Co., under the name of Wando, contains 1.05% manganese, 0.50 chromium, 0.50 tungsten, and 0.95 carbon. Invaro, of the Firth-Sterling Steel Co., is an oil-hardening steel containing 1.15% manganese, 0.90 carbon, 0.50 tungsten, and 0.50 chromium. Mansil die steel, of Henry Disston & Sons, Inc., has the same composition. It is deep-hardening, and is used for blanking dies, broaches, reamers, and gages. Mangano, of the Latrobe Electric Steel Co., contains about 1.60% manganese, 0.20 chromium, and 0.95 carbon. Stentor, of the

Carpenter Steel Co., is a nondeforming tool steel containing 1.6 manganese, 0.25 silicon, and 0.90 carbon. It hardens at a low temperature range, 1400 to 1440°F, which aids in avoiding warpage. Vega steel, of this company, is an air-hardening nondeforming steel that hardens uniformly at low temperatures even in large sections and does not require pack hardening. It contains 0.70% carbon, 2 manganese, 1 chromium, 1.35 molybdenum, and 0.30 silicon. It hardens to 61 Rockwell C from a temperature of 1550°F. Exl-Die steel, of the Columbia Tool Steel Co., has 1.15% manganese, 0.90 carbon, 0.50 chromium, and 0.50 tungsten. Saratoga, of the Allegheny Ludlum Steel Co., and Amcoh, of A. Milne & Co., have about the same composition. Truform, of the Jessop Steel Co., is an oil-hardening high-manganese steel with a low coefficient of expansion, used for making cutters and dies. Deward, of the Allegheny Ludlum Steel Co., contains 1.55% manganese, 0.90 carbon, and 0.30 molybdenum. Paragon steel, of the Crucible Steel Co., has about this amount of manganese with 0.50 to 0.75% chromium and 0.25 vanadium. Kiski steel, of the Braeburn Steel Co., is a similar steel.

Some of the air-hardening steels are classed as nondeforming. Bethlehem A-H steel contains 2% manganese, 1.5 chromium, 1 molybdenum, and 1 carbon. It machines easily when annealed and gives a hardness of 62 Rockwell C when air-hardened. Bethlehem A-H5 is a die steel that has high resistance to distortion and is also wear-resistant and shock-resistant. It contains 1% carbon, 5.25 chromium, 1.1 molybdenum, 0.25 vanadium, and 0.60 manganese. It anneals to 212 Brinell and air-hardens to Rockwell C62. Carpenter No. 485 is an air-hardening steel for dies and tools. It has 5% chromium, 1 molybdenum, 0.20 vanadium, 0.70 manganese, 0.20 silicon, and 0.95 carbon. Carpenter No. 883 is a tougher tool steel for forging dies and bulldozer dies. It has 5% chromium, 1.35 molybdenum, 0.45 vanadium, 1.10 silicon, 0.35 manganese, and 0.40 carbon. Airtem steel, of the Lehigh Steel Co., used for blanking and forming dies, has 5.25% chromium, 1.25 molybdenum, 1 silicon, 0.50 manganese, 0.30 vanadium, and 1.30 carbon. It is also shock-resistant. Air-kool steel, of the Crucible Steel Co. of America, used for blanking and trimming dies and gages, has 5.25% chromium, 1.15 molybdenum, 0.50 vanadium, and 0.95 carbon. Sagamore steel, of the Allegheny Ludlum Steel Co., has 5% chromium,

1 molybdenum, 0.25 vanadium, and 1 carbon. Ontario steel, of this company, is a steel for greater resistance to abrasion. It contains 12% chromium, 0.80 molybdenum, 0.25 vanadium, and 1.5 carbon. Airvan steel, of the Firth-Sterling Steel Co., has 4% chromium, 0.50 manganese, 1 molybdenum, 0.40 vanadium, and 0.95 carbon. It is used for blanking and forming dies. Chromovan steel, of this company, is a nondeforming, wear-resistant tool steel containing 12.5% chromium, 1.6 carbon, 0.80 molybdenum, and 1 vanadium. It is used for thread rolling and coining dies. Invaro, of the same company, is an oil-hardening tool steel for intricate dies, taps, and special tools. It contains 1.15% manganese, 0.50 chromium, 0.50 tungsten, and 0.90 carbon. Hargus steel, of the Ziv and Wire Co., for blanking dies, reamers, and gages, contains 1% manganese, 0.35 nickel, and 1.0 carbon.

**Nonmagnetic steel.** Steel and iron alloys used where it is important that no magnetic circuits be set up or magnetic effects be induced. Manganese steel containing 14% manganese is nonmagnetic and casts readily but is not machinable. Nickel steel containing high nickel is also nonmagnetic. Many mills produce regularly nonmagnetic steels containing from 20 to 30% nickel. Manganese-nickel steels and manganese-nickel-chromium steels are nonmagnetic and may be arranged to combine desirable features of the nickel and manganese steels. A nonmagnetic steel of the Jessop Steel Co. has 10.5 to 12.5% manganese, 7 to 8 nickel, and 0.25 to 0.40 carbon. The electrical resistance is 70 microhms per cu cm compared with 5 to 7 for brass. It has low magnetic permeability and low eddy-current loss, can be machined readily, and work-hardens only slightly. The tensile strength is 80,000 to 110,000 psi, elongation 25 to 50%, and specific gravity 8.02. It is austenitic and cannot be hardened. The 18-8 austenitic chromium-nickel steels are also nonmagnetic. The nonmagnetic alloy used for watch gears and escapement wheels is not a steel but is a Cupronickel-manganese containing 60% copper, 20 nickel, and 20 manganese. It is very hard, but can be machined with diamond tools.

**Nonshattering glass.** Also referred to as Shatterproof glass, Laminated glass, or Safety glass, and when used in armored cars it is known as Bulletproof glass. A material composed of two sheets of

plate glass with a sheet of transparent resinoid between, the w. molded together under heat and pressure. When subjected to a severe blow, it will crack without shattering. The first of these was a German product marketed under the name of Kinonglas, which consisted of two clear glass plates with a cellulose nitrate sheet between, and was first used for protective shields against chips from machines. Nonshattering glass is now largely used for automobile and car windows. The original cellulose nitrate interlining sheets had the disadvantage that they were not stable to light and became cloudy. Cellulose acetate was later substituted. It is opaque to actinic rays and prevents sunstroke but has the disadvantage of opening in cold weather, permitting moisture to enter between the layers. The acrylic resins are notable for their stability in this use; in some cases they are used alone without the plate glass, especially for aircraft windows. Polyvinyl acetal resins, as interlinings for safety glass, are weather resistant and will not discolor and are now used extensively. Flexseal, of the Pittsburgh Plate Glass Co., is a laminated plate glass with a vinyl resin interplate having an extension for sealing into the window frame. It will withstand pressure of 20 psi with a 1/8-in. plastic interplate, and is used for aircraft windows. Duplate is the trade name of the Duplate Corp. for a nonshattering glass. Standard Bulletproof glass is from 1 1/2 in., 3 ply, to 6 in., 5 or more ply.

**Nutmeg.** The brown, round, wrinkled seed of the plumlike fruit of the evergreen tree *Myristica fragrans*, native to the Moluccas but now grown extensively also in Grenada. The bright-red aril covering of the seed is called Mace. The trees average about 20 lb of kernels per year, but a large tree may bear as many as 10,000 nutmegs annually. The average yield in Grenada is taken as 1,500 lb of green nutmegs per acre per year, giving 720 lb of dry sound nutmegs and 150 lb of mace per acre. The nutmeg tree grows best on tropical islands at a height of 500 to 1,500 ft above sea level. It begins to bear at 6 years, and will bear for a century. The ripe fruit splits, and the seeds fall to the ground. Nutmeg is a delicately flavored spice for foodstuffs, but in large amounts is highly toxic. Mace has a finer but weaker flavor and is used as a savory. Nutmeg butter is a solid yellow fat obtained from the rejected nutmegs of the spice trade. To obtain the fat the kernels are roasted and ground before extraction. The nut-



meg contains about 40% of the fat. It is used chiefly in ointments. Nutmeg oil is an essential oil extracted from the nutmeg and used in medicine, in flavoring tobacco, and in dentifrices. It is also called Myristica oil and is high in Myristicin, which is a yellow poisonous oil of the composition  $C_3H_5 \cdot C_6H_2(O_2CH_2)OCH_3$ .

**Nux vomica.** The seeds of the ripe fruit of the deciduous tree *Strychnos nux vomica* of India, Ceylon, and Australia, used as the source of the alkaloids Strychnine and Brucine. The powdered seed may also be used. The fruits contain three to five hard grayish seeds which yield 1 to 1.25% strychnine alkaloid and about the same amount of brucine. Strychnine is an odorless, crystalline, intensely bitter powder of the composition  $C_{21}H_{22}N_2O_2$ . It is a spinal stimulant and in quantity is a violent convulsive poison. It is used in proprietary and prescription medicines of the tonic class, and also in rat poisons. For medicinal use it is used mostly in the form of Strychnine sulphate which is easily soluble in water. Brucine is a bitter crystalline alkaloid of the composition  $C_{23}H_{26}N_2O_4$  with similar characteristics but much less active. It is also used as a denaturant for rapeseed oil and other industrial oils. The woody vine Woorali, *S. toxifera*, of the Amazon and Orinoco valleys, from which the arrow poison Curare was obtained, contains strychnine.

**Nylon.** A group of synthetic plastics which are long-chain polymeric amides in which the amide groups form an integral part of the main polymer chain, and which have the characteristic that when formed into a filament the structural elements are oriented in the direction of the axis. Nylon produced by the reaction of adipic acid and hexamethylene diamene forms fine filament fibers of silklike appearance, great strength, elasticity, and toughness. The fine fibers are spun into yarns for weaving and knitting. Nylon fibers are used to blend with silk, and crimped and heat-set nylon fibers are blended with wool to make fine blankets. Flalon, of Burgess-Berliner Assoc., is a Nylon flannel of 15-denier crimped fibers carded on both faces. It has the appearance of cotton flannel, but is greatly superior in heat resistance and wear resistance. Raynile, of Hewitt-Robins, Inc., is a rayon-nylon fabric with nylon traverse threads. It is flexible and has about twice the strength of cotton fabric. It is used for conveyor belts.

Nylon monofilament fiber is used for brushes, surgical sutures, tennis strings, and fishing leaders. Exton, of E. I. du Pont de Nemours & Co., Inc., is a monofilament fiber for brushes. The single filaments are also called Monofil. It is more durable than natural bristles for brushes. Nylon is also used as an extrusion coating for insulation on electrical wires. It has a high softening point, 450°F, and because of its property of taking on an orderly arrangement of the long-chain molecules in drawing, the fiber has a higher tensile strength than most textile fibers. The specific gravity of the filament is 1.068, and tensile strength 53,600 psi. The molded material has a specific gravity of 1.14, tensile strength 9,000 psi, flexural strength 12,600 to 14,600 psi, compressive strength 15,000 psi, and dielectric strength of about 400 volts per mil. The molded material is used for electrical parts where the high softening point is valued. The colored molding powder is used for buttons, combs, dishes, and equipment parts. The molded or machined material is also used for pressure valve seats. Nylon valve seats on Navy torpedoes withstand an air pressure of 2,800 psi. Nylatron G, of the Polymer Corp., is a graphite-impregnated nylon in the form of rods and strip for making gears, bearings, and packings.

**Oak.** The wood of a large variety of oak trees, all of the natural order *Cupuliferae*, genus *Quercus*. European oak, under various names, such as Austrian oak and British oak, are from two varieties of the tree *Q. robur*. The wood is light brown in color, with a coarse, open grain, firm texture, and weight of about 45 lb per cu ft. American red oak is from the tree *Q. rubra* or *Q. falcata*. It is also called Black oak, although black oak is from the *Q. velutina*, and the Red oak of the Lake states is *Q. borealis*. The heartwood is reddish brown, and the sapwood whitish. The Southern red oak of the Gulf Coast, a valued wood for furniture and cabinetwork, is the Shumard oak, *Q. shumardii*, also known as Schneck oak and Texas oak. The Nuttall oak, *Q. nuttallii*, of the lower Mississippi Valley, is also called red oak. American White oak is from the tree *Q. alba* of the eastern states. The heartwood is brown, and the sapwood white. The grain of these species is coarse, but the texture is firm. Post oak, of the southern states, is *Q. stellata*. Chestnut oak, of the Appalachian range, is *Q. montana*, but this name is also applied to the Chinquapin

oak, *Q. muehlenbergii*, a large tree which grows profusely over a wide area of the eastern half of the United States, and was early valued for railroad ties and heavy construction timbers. The Overcup oak, *Q. lyrata*, is an important tree from New Jersey to Texas. Scarlet oak, of Pennsylvania, is *Q. coccinea*. Western white oak, *Q. garryana*, has a more compact texture and straighter grain. American oaks are widely distributed in the United States and Canada. Spanish oak, *Q. oblongifolia*, is native to California and New Mexico. The grain is finer and denser. There are more than 400 species of oak on the North American continent. What is probably the largest pure stand of oak in the world is in Costa Rica. It is made up of immense trees of Copey oak, *Q. copeyensis*, the trees being up to 8 ft in diameter with clean boles to 80 ft to the first limb. The wood has a hardness between that of white and live oaks, and the bark has a high content of tannin.

Oak is used for flooring, furniture, cask staves, and where a hard, tough wood is needed. For cabinetwork the boards are variously sawed at angles and quarters to obtain grain effects known as Quartered oak. Fumed oak is not a kind of oak, but a finish produced by the action of ammonia vapor. Burr oak, or Pollard oak, also known as Burrwood, is the wood of the decapitated European oak trees, *Q. pedunculata* and *Q. sessiliflora*, of Great Britain. A pollard tree is one whose head has been cut for ornamentation purposes. The growth in height is permanently arrested and innumerable branches shoot out from the trunk, which produce humps, or burrs, with the grain of the wood running in all directions. Burr oak is valued for ornamental work. Burr oak of the northern and central United States is not a pollard oak but is a name for the tree *Q. macrocarpa*. The commercial red and white oaks have an average gravity when kiln-dried of 0.69. The compressive strength perpendicular to the grain is 1,870 psi, and shearing strength parallel to the grain of 1,300 psi.

The woods often called oaks in the Southern Hemisphere are not true oaks. The Australian oaks are from a variety of trees, and Chilean oak is from a species of beech. Beef oak, of Australia, is a hard, heavy, brownish wood from the tree *Grevillea striata*. It has an irregular grain. She oak is from the Australian tree *Casuarina stricta*, and Swamp oak is from *C. suberosa*. These woods are lighter in weight than oak. Silky oak, used for cabinetwork, is a brownish wood

that has a uniform texture and can be quartersawn to show attractive figuring. It is from the tree *Cardwellia sublimis* of Australia.

Oak extract, which is an important tanning material for the best grades of heavy leather, is chiefly from the bark of the Swamp chestnut oak, *Q. prinus*, but also from the white oak and red oak. The Tanbark oak of California is the tree *Lithocarpus densiflora*. The extract of the Scarlet oak, *Q. coccinea*, is dark in color and is known as Quercitron extract. The bark of the tanbark oak yields 10 to 14% tannin, but the extract contains 25 to 27% tannin. Valonia consists of the acorn cups of the oak *Q. aegilops* of Asia Minor and the Balkans. Smyrna valonia contains 32 to 36% tannin which produces a light-colored, lightweight leather with a firm texture and bloom. When used alone, however, valonia makes a brittle leather, and is thus always used in blends. Valonia is marketed as cups or as extract, the latter containing about 60% tannin.

**Oakum.** A substance used for calking the seams of vessels and wooden tanks, or for water pipes. It consists of old hemp ropes untwisted, pulled into loose fiber, and treated with tar. The hemp employed is from the true hemp, *Cannabis sativa*, coming in normal times from Russia, Italy, and India either as old rope or new fiber. The old rope is used because it is cheaper than new fiber, but new tow may be blended with the rope. The highest grade of Marine oakum is made entirely of new tow fibers. Sunn fiber may be substituted for hemp. Only inferior grades are made with jute fibers. Oakum is marketed in balls or on spools or in coiled rope form.

**Oats.** An important grain which is the seed of the tall plant *Avena sativa*. The grain is surrounded by a hull, and grows in many spikelets as a spreading or one-sided panicle inflorescence. It can be grown farther north than any other grain except rye, and on poor soils. Although it is one of the most nutritious of grains, most of the oats grown in the United States are used for animal feed. Rolled oats and Oatmeal are used as cereal foods and for some bakery products, but the grain is not suitable for bread making. Oat hulls are used for the production of furfural and other chemicals. The largest production of oats is in the United States and Russia, but large quantities are produced in Canada, western Europe, and Argentina. It is the chief grain crop of Scotland. The yield per acre in the United States is

about 30 bu, but it is twice that figure in Great Britain. Oats are often called by the Spanish name *Avena* in international trade. Turkish oats, cultivated in central Europe, are from the species *A. orientalis*. The Horse gram, used as a substitute for oats in India, is from the plant *Dolichus bifloris*. The Gram, from the *Cicer arietinum*, is an important food grain in India.

**Ochre.** A compact form of earth used for paint pigments and as a filler for linoleum. It is an argillaceous and siliceous material, often containing compounds of barium or calcium, and owing the yellow, brown, or red colors to hydrated iron oxides. The tints depend chiefly upon the proportions of silica, white clay, and iron oxide. Ochres are very stable as pigments. They are prepared by careful selection, washing, and grinding in oil. They are inert, and are not affected by light, air, or ordinary gases. They are rarely adulterated, because of their cheapness, but are sometimes mixed with other substances to alter the colors. Chinese yellow and many other names are applied to the ochres. Golden ochre is ochre mixed with chrome yellow. White ochre is ordinary clay. A large part of the American ochre is produced in Georgia. Sienna is a brownish-yellow ochre found in Italy and Cyprus. The material in its natural state is called Raw sienna. Burnt sienna is the material calcined to a chestnut color. Indian red and Venetian red are hematite ochres.

Vandyke brown is a deep-brown pigment made originally from lignitic ochre from Cassel, Germany. It was named after the Dutch painter Van Dyck, and is also called Cassel brown, Cassel earth, and Rubens brown. It is also obtained from low-grade coals of Oklahoma and California. Imitation Vandyke brown is made from a mixture of lampblack, yellow ochre, and iron oxide. Cologne earth is a Vandyke brown made from American clays which are mixtures of ochre, clay, and bituminous matter, roasted to make the color dark. Yellow ochre and Brown ochre are limonite, but Yellow iron oxide is made in Germany by the aeration of scrap iron in the presence of copperas. Umber is a brown siliceous earth colored naturally with iron oxides and manganese oxide. It comes chiefly from Italy and Cyprus. For use as a pigment it is washed with water and finely ground. It is inert and very stable. Cyprus umber is a rich coffee-brown color and as a pigment has good covering qualities. It is a modified marl with

impregnations of iron and manganese. Burnt umber is redder in color than umber, and is made by calcining the raw umber. Caledonian brown and Cappagh brown are varieties of umber found in Great Britain.

**Oilcloth.** A fabric of woven cotton, jute, or hemp, heavily coated with turpentine and resin compositions, usually ornamented with printed patterns, and varnished. It was employed chiefly as a floor covering, but a light, flexible variety having a foundation of muslin is used as a covering material. This class comes in plain colors or in printed designs. Oilskin is a cotton or linen fabric impregnated with linseed oil to make it waterproof. It was used for coverings for cargo and for waterproof coats, but has now been replaced by coated fabrics. Oiled silk is a thin silk fabric impregnated with boiled or blown linseed oil which is oxidized and polymerized by heat. It is waterproof, very pliable, and semitransparent. It was much used for linings, but has now been replaced by fabrics coated with synthetics.

**Oils.** A large group of fatty substances which are divided into three general classes: vegetable oils, animal oils, and mineral oils. The vegetable oils are either fixed or volatile oils. The fixed oils are present in the plant in combined form, and are largely glycerides of stearic, oleic, palmitic, and other acids, and they vary in consistency from light fluidity to solid fats. They nearly all boil at 500 to 600°F, decomposing into other compounds. The volatile, or essential, oils are present in uncombined form and bear distillation without chemical change. Oils are found in all plants, particularly in the seeds, and in nearly all parts of animal bodies. Fish oils are thick, with a strong odor. Vegetable and animal oils are obtained by pressing, extraction, or distillation. Oils that absorb oxygen easily and become thick are known as drying oils and are valued for varnishes, because on drying they form a hard, elastic, waterproof film. Oils and fats are distinguished by consistency only, but waxes are not oils. Mineral oils are derived from petroleum or shale and are classified separately. The most prolific sources of vegetable oils are palm kernels and copra. About 2,500 lb of palm oil is produced per acre annually, and the yield of coconut oil per acre from plantation plantings is 1,200 lb. This compares with 350 lb of oil per acre from peanuts and 200 lb

per acre from soybeans. Under comparable aggressive plantation work, from 10 to 20 times more palm and coconut oil can be produced per acre than peanut or soybean oil.

Fish oils are obtained from the fat of the cod, herring, sardine, salmon, and sprat by boiling the fish and skimming the oil from the surface. The oil is of pale or brownish color and has an offensive odor. The specific gravity is about 0.930. It is of the nondrying class, and used for lubricants, leather dressing, soaps, oil baths for heat-treating steel, and for fractionating to reblend in paint oils and other products. It is sometimes bleached white. Japan fish oil consists of mixtures of the oils of Japanese sardines and herrings. Fish meal is the by-product scrap used for cattle and poultry feed and fertilizer. Fish oils are also used directly in poultry feeds to add vitamins A and D, especially the inferior grades of cod-liver oil and tuna-liver oil. Fish solubles is a name for the condensed liquor obtained from evaporating the residue liquor or Stickwater, from fish-oil plants and canneries. Fish solubles are marketed as a 50% solids concentration, which contains B vitamins and vitamins G and B<sub>12</sub> in addition to protein. It is mixed with Alfalfa leaf meal, and the mix is sold as an animal feed.

Blown oils are fatty oils that have been oxidized by blowing air through them while hot, thereby thickening the oil. They are mixed with mineral oils to form special heavy lubricating oils such as marine engine oil, or are employed in cutting oils. They are also used in paints and varnishes, as the drying power is increased by the oxidation. The flash point and the iodine value are both lowered by the blowing. The oils usually blown are rapeseed, cottonseed, linseed, fish, and whale oils. The Blown fish oils of the Archer-Daniels-Midland Co., used for paints, enamels, and printing inks, are pre-oxidized and destearinized, and have specific gravities from 0.980 to 1.025. The Cystol oils of this company are kettle-boiled fish oils for paints.

**Oilstone.** A fine-grained, slaty silica rock used for sharpening edged tools. The bluish-white and opaque white oilstones of fine grain from Arkansas are called Novaculite, and received their name because they were originally used for razor sharpening. They are composed of 99.5% chalcedony silica and are very hard with a fine

grain. Novaculite is a deposit from hot springs. It is fine-grained and the ordinary grades are employed for the production of silica refractories. Arkansas oilstones are either hard or soft and have a waxy luster. They are shipped in large slabs or blocks. Washita oilstone, from Hot Springs, Ark., is a hard, compact white stone of uniform texture. Onachita stones come in larger and sounder pieces but are coarser than the Arkansas. Water-of-Ayr stone, also known as Scotch hone, is a fine sandstone used with water instead of with oil. Artificial oilstones are also produced of aluminum oxide. India oilstone was originally blocks of emery, but the name now may refer to aluminum oxide stones.

**Oiticica oil.** A drying oil obtained from the kernels of the nuts of the tree *Licania rigida* of northeastern Brazil. The oil contains about 80% Licanic acid, which, like the Eleostearic acid of tung oil, gives a greater drying power than is apparent from the iodine value. The specific gravity is 0.944 to 0.971, saponification value 187 to 193, and iodine number 142 to 155. The properties as a varnish oil are much like those of tung oil, both producing wrinkled films when applied pure, and both lacking high gloss. Cicoil is a name for a treated oiticica oil with improved qualities. The oiticica nuts are 1 to 2 in. long with the kernel about 60% of the nut, and yielding about 60% oil. The average yield per tree is 350 lb of nuts, but a full-grown tree may yield ten times that amount. Another species of the tree *L. crassifolia*, of Surinam, yields an oil similar to oiticica. Mexican oiticica is from the nuts of another species of tree and is called Cacahuanache oil. The kernels yield 69% of light-colored heavy oil.

**Oleic acid.** Also called Red oil, and Elaine oil. An organic acid having a complex composition, represented empirically by the formula  $C_8H_{17}CH:CH(CH_2)_7COOH$ . It is used to make soluble oils and cutting compounds, in which it forms Sodium oleate,  $C_{17}H_{33}COONa$ . It is also used in the manufacture of oil-soluble colors, soaps, and in treating textiles. Oleic acid is found in most fats in combination with glycerol, particularly in liquid fats, or oils, such as olive oil, oleo oil, cottonseed oil, and coconut oil. It can be separated from fats by saponification and is obtained by distillation. It is an oily liquid with a specific gravity of 0.890, boiling point  $286^{\circ}C$ , and



melting point 14°C below which it forms colorless needles. It is soluble in alcohol. The two commercial grades of oleic acid, yellow and red, are known as saponified and distilled red oil. Ahcolein 810, of Arnold, Hoffman & Co., Inc., is a clear, distilled red oil with only a mild fatty odor, used for textile finishing.

**Olive oil.** A pale greenish oily liquid extracted from the ripe fruit of the olive tree, *Olea europaea*, a small evergreen grown largely in the Mediterranean countries but also in California and in Argentina. The fruits are eaten ripe (purple) and green. They are rich in oil, and vast quantities are crushed for oil. The oil contains 69 to 85% oleic acid, 7 to 14 palmitic acid, 4 to 12 linoleic acid, with some stearic, arachidic, and myristic acids. The specific gravity is 1.912, iodine value 85, and saponification value 190. The best grades of the oil are used for food chiefly as a salad and cooking oil, and in canning sardines, but some is used in the manufacture of castile soaps. The industrial oil consists of the Olive oil foots obtained in the third pressing or in the last extraction with carbon bisulphide, and is used for finishing textiles, degumming silk, and in soaps. Florence oil is a grade of Italian olive oil. In Italy olive oil is also known as Luccu oil. Synthetic olive oil, or Olive-infused oil, is used entirely as a food-stuff. It is made from highly refined corn oil by infusing the corn oil with about 20% of a paste made of finely ground, partly dehydrated ripe olives ground with a small amount of corn oil. The olive-infused oil has the flavor of olive oil, and also contains carotene, or vitamin A, contained in the olive pulp. Other fractionated oils reblended to give high oleic acid content are also used as substitutes for olive oil. Olevene, of Jacques Wolf & Co., is a sulphonated synthetic oil used instead of olive oil for treating textiles.

Avocado oil, or Alligator pear oil, is similar to olive oil in that it contains 77% oleic acid, 10.8 linoleic, 6.9 palmitic, and 0.6 stearic acid. It is practically odorless and tasteless, and is high in vitamins. It is also rich in lecithin, and is valued in cosmetics because it is penetrating like lanolin. It also contains Mannoketoheptose, a high sugar which is nonfermentable. The oil is obtained from the ripe fruit of the avocado, *Persea americana*, a small tree of which more than 500 varieties grow profusely in tropical America. In California, where the fruit is grown for market, it is also known as Calavo.

**Olivine.** A translucent mineral, usually occurring in granular form, employed as a refractory. The formula is usually given as  $(\text{Mg} \cdot \text{Fe})_2 \cdot \text{SiO}_4$ , but it is a solid solution of Forsterite,  $2\text{MgO} \cdot \text{SiO}_2$ , and Fayalite,  $2\text{FeO} \cdot \text{SiO}_2$ . The fayalite lowers the refractory quality, but forsterite is not found alone. The mineral is also called Chrysolite, and the choice transparent stones used as gems are called Peridot. Dunite deposits in Washington and North Carolina carry up to 90% olivine which has only 5 to 15% fayalite. It is olive-green in color, vitreous, with a hardness of 6.5 to 7 and a specific gravity 3.3 to 3.5. As a refractory it is neutral up to about  $1600^\circ\text{C}$  but may then react with silica. The fayalite fuses out at  $2700^\circ\text{F}$ , making the material porous and subject to attack by iron oxide. The melting point of forsterite is  $3470^\circ\text{F}$ . When used mixed with chrome ore, the low-fusing elements form a black glass which presents a nonporous face. Some refractory material marketed as forsterite may be olivine blended with magnesite, or may be serpentine treated with magnesite. Forsterite firebrick in the back walls of basic open-hearth steel furnaces gives longer life than silica brick but only two-thirds that of chrome-magnesite brick. The thermal expansion of olivine is lower than that of magnesite. Olivine sand is substituted for silica sand as a foundry sand where silica is expensive. There are large deposits of olivine in the Pacific Northwest. When used as a foundry sand, it is noted that the heat-resisting qualities decrease with particle size. Olivine contains from 27 to 30% magnesium metal, and is also used to produce magnesium by the electrolysis of the chloride. Magnesium-phosphate fertilizer is made by fusing olivine with phosphate rock at  $1600^\circ\text{C}$ , tapping off the iron, and spray-cooling and crushing the residue. It contains 20% citric-acid soluble phosphate, 14 MgO, 29 CaO, and 23  $\text{SiO}_2$ , and is useful for acid soils.

**Onyx.** A variety of chalcedony silica mineral differing from agate only in the straightness of the layers. The alternate bands of color are usually white and black, or white and red. Onyx is artificially colored in the same way as agate. It is used as an ornamental building stone, usually cut into slabs, and for decorative articles. Onyx marble is limestone with impurities arranged in banded layers. American onyx comes largely from Arizona, California, and Montana. Mexican onyx is banded limestone obtained from stalactites in

caves. These materials are cut into such articles as lamp stands. Argentine onyx is a dark-green or a green-yellow translucent stone of great decorative beauty. In the United States it is called Brazilian onyx and is used for book ends, lamp bases, ink stands, and ornaments. Opalized wood is an onyxlike petrified wood from Idaho. It is cut into ornaments.

**Opacifiers.** Materials used in ceramic glazes and vitreous enamels primarily to make them nontransparent, but opacifiers may also enhance the luster, control the texture, promote craze resistance, or stabilize the color of the glaze. An opacifier must have fire resistance so as not to vitrify or decrease the luster. Tin oxide is a widely used white opacifier, and up to 3% also increases the fusibility of the glaze or enamel. Titanium oxide adds scratch hardness and high acid resistance to the enamel. It also increases the flow, making possible thinner coats which minimize chipping. Opacifiers may also serve as the pigment colors. Thus, cobalt oxide gives a blue color, and platinum oxide gives a gray. Lead chromate gives an attractive red color on glazes fired at 900°C, but when fired at 1000°C the lead chromate decomposes and a green chromium oxide is formed. If the glaze is acid, the basic lead chromate is altered and the color tends to green. Lufax 77A, of the Rohm & Haas Co., is a crystalline zirconia which provides nuclei for the formation of zirconia crystals from the molten enamel, adding gloss and opacity and stabilizing the color on the blue side. Antimony oxide as an opacifier gives opaque white enamels of great brilliance but is expensive and is poisonous. The zirconium opacifiers have a wide range of use from ordinary dishes to high-heat electrical porcelain and sanitary-ware enamels. The amount of zirconium oxide used is a minimum of 3%. The opacifiers may be in prepared form with lead oxide or other materials to give particular characteristics. Opax, of the Titanium Alloy Mfg. Co., is a zirconium oxide with small percentages of silica, sodium oxide, and alumina. It is used for hard-glaze dinnerware and wall-tile glazes. Zircopax is zirconium silicate,  $\text{ZrSiO}_4$ , with 33.5% silica in the molecule. It gives color stability and craze resistance. Superpax, of this same company, is a finely milled zirconium silicate powder with an average particle size less than 5 microns. In white ceramic glazes very small amounts will give opacity. Ultrax opaci-

fier, of the Metal & Thermit Corp., is a refined zirconium silicate. Lead oxide is used to lower the melting point of a glaze. Matte effects are obtained by adding barium oxide, magnesia, or other materials to the opacifier.

**Open-hearth steel.** Steel made by the process of melting pig iron and steel or iron scrap in a lined regenerative furnace, and boiling the mixture with the addition of pure lump iron ore, until the carbon is reduced. The boiling is continued for a period of 3 or 4 hr. The process was developed in 1861 by Siemens in England. The furnaces are made in sizes from 10 to 300 tons capacity, and contain regenerative chambers for the circulation and reversal of the gas and air. The fuels used are natural gas, fuel oil, coke-oven gas, or powdered coal. Both the acid- and basic-lined open-hearth furnaces are used, but most steel made in the United States is basic open hearth. Ganister is used as a lining in the acid furnaces, and magnesite in the basic.

An advantage of the open-hearth furnace is the ability to handle raw materials that vary greatly and also to employ scrap. Iron low in silicon requires less heating time. The duplex process consists in melting the steel in an acid bessemer furnace until the silicon, manganese, and part of the carbon have been oxidized, and then transferring to a basic open-hearth furnace where the phosphorus and the remainder of the carbon are removed. Open-hearth steel is of uniform quality. The open-hearth steel bars used by one large company contain 0.08 to 0.18% carbon, 0.55 max manganese, 0.05 phosphorus, and 0.06 sulphur. With 0.12% carbon, open-hearth steel has a tensile strength of 55,000 psi and elongation 27%; the same steel with 0.18% carbon has a tensile strength of 68,000 psi and elongation 23%. Shell steel, for heavy projectiles that must burst into many pieces, is mostly open-hearth steel that has been resulphurized.

**Opium.** The dried juice from the unripe capsules of the poppy plant, *Papaver somniferum*, cultivated extensively in China, India, and the Near East, but also growing wild in many countries. The opium poppy is an annual with white flowers. After the petals drop off, the capsules are cut and the juice exudes and hardens. The crude opium is a brownish mass. It contains Morphine, Codeine, and nearly 20 other alkaloids which are used in medicine.

Laudanum is an alcohol solution of opium. Amidone is a Ger-

man synthetic morphine. It is a diphenyl dimethylamino heptanone, is stronger than morphine as a painkiller, and, like morphine, is an exhilarant and is habit-forming. The English drug Heptalgin is a similar morphine substitute. Poppy-seed oil is a colorless to reddish-yellow liquid of specific gravity of about 0.925 and iodine number 157 used as a drying oil in artists' varnishes. The cold-pressed white oil is used locally as an edible oil. The very dark grades are used in soaps and in paints. The oil from the seed does not contain opium.

**Optical glass.** A highly refined glass, usually a flint glass, of special composition, or made from rock crystal, used for lenses and prisms. It is cast, rolled, or pressed. In addition to the regular glassmaking elements, silica and soda, optical glass contains barium, boron, and lead. The highly refractory glasses contain abundant lead oxide or barium oxide, and the low-refracting glasses contain abundant silica or boron oxide. A requirement of optical glass is transparency and freedom from color. Traces of iron make the glass greenish, while manganese causes a purple tinge. First-quality optical glass should contain a minimum of 99.8%  $\text{SiO}_2$ . Borax is used in purifying and in increasing the strength and brilliance of the glass. Besides the control of chemical composition, careful melting and cooling are necessary to obtain fine transparency, and then intense polishing. The pouring temperature is about  $1200^\circ\text{C}$ . The best optical glass has a transparency of 99%, compared with 85 to 90% for ordinary window glass. A Borate glass with lanthanum and tantalum oxides but no silica is used for airplane-camera lenses and for eyepieces for wide-angle field glasses. It has a high refractive index and a low dispersion. Beryllium fluoride glass of the American Optical Co. is made by substituting beryllium fluoride for silicon dioxide. It has a low refractive index with low color dispersion, and light travels faster through it than through ordinary optical glass. It has the disadvantage that it is hygroscopic.

**Ore.** A metal-bearing mineral from which a metal or metallic compound can be extracted commercially. Earths and rocks containing metals that cannot be extracted at a profit are not rated as ores. Ores are named according to their leading useful metals. The ores may be oxides, sulphides, halides, or oxygen salts. A few metals also

occur native in veins in the minerals. Ores are usually crushed and separated and concentrated from the Gangue with which they are associated, and then shipped as Concentrates based on a definite metal or metal oxide content. The metal content to make an ore commercial varies widely with the current price of the metal, and also with the content of other metals present in the ore. Normally, a sulphide copper ore should have 1.5% copper in the unconcentrated ore but, if gold or silver is present, an ore with much less copper is workable. Likewise, low-grade lead ores can be worked if silver is recoverable. Low-grade manganese and other ores become commercial when the prices are high.

**Osmium.** A rare metal, symbol Os, having the highest specific gravity, 22.50, and a very high melting point, 4890°F. Osmium forms a solid-solution alloy with platinum. Compared with iridium it has more than double the hardening power in platinum, but it volatilizes so readily into the poisonous tetroxide that it is seldom used to replace iridium in platinum alloys. With iridium, however, it is used as an alloy for fountain-pen tips under the name of Osmiridium. Osmium is not affected by the common acids and is not dissolved by aqua regia. The metal is sold by the troy ounce, 1 cu in. weighing 11.86 troy oz.

**Osnaburg cloth.** Heavy, coarse cloth of plain weave made from waste and scraps of cotton mills, or from low-grade short-staple cotton. It is employed to replace burlap for wrapping and baling and is a standard material in 7.8-oz weight for inside sacks for burlap flour sacks. In checks and stripes the cloth is used for protective coverings, often waterproofed.

**Oxalic acid.** An organic acid of the composition  $(\text{COOH})_2 \cdot 2\text{H}_2\text{O}$ , employed in writing inks, metal polishes, as a bleaching agent for leather and textiles, mordant in dyeing, a detergent, and as a stain remover for fabrics and porcelain. It occurs in colorless crystals with a specific gravity of 1.653 and melting point of 101.5°C. It is soluble in water and in alcohol. Oxalic acid is obtained by the action of nitric acid on sugar or strong alkalies on sawdust or by heating sodium formate and treating the resulting oxides with sulphuric acid.

**Oxamide**,  $(\text{CONH}_2)_2$ , is a stable anhydrous derivative with a high melting point,  $419^\circ\text{C}$ . It is a white crystalline powder used in flameproofing and in wood treating.

**Oxygen.** The most important and abundant of the elements. Its chemical symbol is O. It constitutes about 89% of all water, 33% of the earth's crust, and 21% of the atmosphere. It combines readily with most of the other elements, forming their oxides. It is a colorless and odorless gas and can be produced easily by the electrolysis of water, which produces both oxygen and hydrogen, or by chilling air below  $-300^\circ\text{F}$  by the Linde-Frankl process which produces both oxygen and nitrogen. The specific gravity is 1.1056. It liquefies at  $-113^\circ\text{C}$  at 59 atm. Liquid oxygen is a pale, steel-blue, transparent, mobile liquid. Oxygen is the least refractive of all gases. It is the only gas capable of supporting respiration, but is harmful if inhaled pure for a long period. In small quantities it is an exhilarant. Oxygen has many commercial uses and is marketed in steel cylinders under a pressure of 2,000 psi. The chief use is for oxyacetylene welding and metal cutting. For welding it should be at least 99.5% pure. Ozone is an allotropic form of oxygen and is composed of three atoms of oxygen,  $\text{O}_3$ . It is formed by electric discharges in the air, or during the evaporation of water, particularly of spray in the sea. It has a peculiar odor, which can be detected in 500,000 parts of air. Ozone is a powerful oxidizer, destroying most organic compounds and bleaching vegetable colors. Pure ozone is an irritant poison, but in minute quantities in the air is purifying and healthful. As an oxidizer in the rubber industry it is known as Activated oxygen.

Oxygen for bleaching and oxidizing purposes may be obtained from compounds that readily yield the gas, such as the liquid Hydrogen peroxide,  $\text{H}_2\text{O}_2$ , or the granular solid Sodium peroxide,  $\text{Na}_2\text{O}_2$ . The C.P. grade of hydrogen peroxide is a colorless liquid with 90%  $\text{H}_2\text{O}_2$  and 10 water. It contains 42% active oxygen by weight, and one volume yields 410 volumes of oxygen. Albione, of E. I. du Pont de Nemours & Co., Inc., is a hydrogen peroxide, and Solozone is a sodium peroxide having 20% available oxygen. Ingolin was a German name for hydrogen peroxide used as a rocket fuel. As a primary fuel its disassociation gives only 994 Btu per lb, but as a secondary fuel it provides oxygen and produces temperatures to

2200°C, which can be reduced by adding water. Other Peroxides or Superoxides are also used industrially. These are compounds in which two oxygen atoms are singly linked, and their oxidizing power depends upon their degree of stability. They break down into pure oxygen gas and a more stable reduced oxide. Tetrabutyl hydroperoxide, an organic peroxide, is a powerful oxidizing agent used as an accelerator in curing rubbers, as a drying agent in oils, paints, and varnishes, and as a combustion aid for diesel fuel oils. The commercial 60% solution in water has a boiling point of 82°C and specific gravity of 0.859. Urea peroxide,  $(\text{CO} \cdot \text{NH}_2)_2\text{O}_2$ , is a white crystalline material with 16% by weight of active oxygen, used in bleaching, polymerization, and in oxidation processes. Magnesium peroxide,  $\text{MgO}_2$ , Calcium peroxide,  $\text{CaO}_2$ , and Zinc peroxide,  $\text{ZnO}_2$ , are stable white powders insoluble in water, containing, respectively 14.2, 13.6, and 7.4% active oxygen. They are used where the oxidation is required to be at high temperatures as in food processing. Uniperox, of the Union Oil Co. of California, is a peroxide of the composition  $\text{C}_7\text{H}_{13}\text{OOH}$ , made from petroleum fractions. At low temperatures it is stable, but at 110°C the decomposition is exothermic and rapid. It is used as a diesel fuel additive to raise the cetane number, and also as a polymerization catalyst for synthetic resins.

**Ozokerite.** Also known as Mineral wax, and as Earth wax. A natural paraffin found in Utah and in central Europe, and used as a substitute or extender of beeswax, and in polishes, candles, printing inks, crayons, sealing waxes, phonograph records, and insulation. Ozokerite is a yellowish to black, greasy solid, melting at 55 to 110°C and having a specific gravity of 0.85 to 0.95. It is soluble in alcohol, benzol, and naphtha, but not in water. The wax occurs in rocks, which are crushed, and the wax melted out. The latter is then refined by boiling, treating with an alkali, and filtering. The refined and treated ozokerite is called Ceresin and is white to yellow in color and odorless. The melting point is up to 142°F. It is used for waxed paper, polishes, candles, and compounding.

A similar wax, called Montan wax, or Lignite wax, is produced in Germany from lignite. Montan wax is white to dark brown in color, and has a melting point of 80 to 90°C, usually 83 to 85°C. The wax is obtained from the powdered lignite by solvent extraction with a



mixture of benzene and ethyl alcohol and subsequent removing of the bitumen by oxidation with chromic acid. The brown coals of Oklahoma and Texas also contain as much as 13% montan wax. IG wax S is extracted and purified montan wax, but IG wax V is a synthetic substitute consisting of the octadecyl ether of vinyl alcohol,  $C_{17}H_{34}CH_2 \cdot O \cdot CH:CHOH$ . Montan wax is valued for leather finishes, polishes, phonograph records, insulation compounds, and as a hard wax in candles. The mineral waxes are sold in white, waxy cakes, or in flakes.

**Paint.** A general name to designate a solution of a pigment in water, oil, or organic solvent, used to cover wood or metal articles either for protection or for appearance. Paints always contain pigments; the solution of gums or resins, known as varnishes, are not paints, although their application is usually termed painting. Enamels and lacquers, in the general sense, are under the classification of paints, but specifically the true paints do not contain gums or resins. Stain is a varnish containing enough pigment or dye to alter the appearance or tone of wood in imitation of another wood, or to equalize the color in wood. It is usually a dye rather than a paint. Enamel paint is also a pigment in varnish. The vast bulk of paint is made with about 65% pigment by weight and 35 vehicle. The best House paint for outside work consists of high-grade pigment and linseed oil, with a small percentage of turpentine as a thinner and drier. The volatile thinner in paints is for ease of application, the drying oil determines the character of the film, the drier is to speed the drying rate, and the pigment gives color and hiding power.

Paints are marketed in many grades, some containing pigments extended with silica, talc, barytes, gypsum, or other material; fish oils, or inferior semidrying oils in place of linseed oil; and mineral oils in place of turpentine. Metal paints contain basic pigments such as red lead, ground in linseed oil, and should not contain sulphur compounds. Red lead is a rust-inhibitor, and is a good primer paint for iron and steel, though it is now largely replaced by chromate primers. White lead has a plasticizing effect which increases adhesion. It is stable and not subject to flaking. Between some pigments and the vehicle there is a reaction which results in progressive hardening of the film with consequent flaking or chalking, or there may be a

development of water-soluble compounds. Linseed oil reacts with some basic pigments, giving chalking and flaking. Fading of a paint is usually from chalking. The composition of paints is based on relative volumes since the weights of pigments vary greatly, although the custom is to specify pounds of dry pigment per gallon of oil. A 28-lb red-lead paint contains 20.3 lb of red lead per gal and weighs 25.9 lb per gal.

Bituminous paints are of coal-tar or asphalt products, dissolved in mineral spirits, and used for the protection of pipes, and for waterproofing cement. Battery paint is usually asphalt or gilsonite in a petroleum solvent. It forms a heavy, chemical-resistant and water-resistant film. Aluminum paint is made with aluminum flake powder in a base of linseed oil, varnish, gloss oil, or synthetic lacquer. It gives a silvery appearance. As it reflects 70% of the light and radiates heat poorly, it is valued for painting tanks, chimneys, and ovens. Since sand does not adhere to it, it is used also for painting foundry patterns. Aluminum paint for outside work is in a spar varnish. In lacquers the powder does not leaf, and the paint dries to a hard, metallic surface with a frosted effect useful for some finishes. The Permite paint of Aluminum Industries, Inc., is aluminum powder in a silicon resin. It will withstand temperatures to 1000°F, and is used for painting stacks and steam lines. When aluminum is used in asphalt paints for tanks and roofing, the aluminum pigment leaf comes to the surface of the paint to form a reflective shield. The Sil-Var paint of Service Industries is a paint of this kind. Sericite mica flake is sometimes mixed with aluminum flake as an extender or to give a different color tone. Asbestos may also be mixed with aluminum. The Lumiclad roofing paint of the Asbestos Mfg. Corp. is aluminum flake and asbestos powder in an oil-resin vehicle.

An English paint known as Leadoid, used as a protection against gamma rays, is made with a pigment of colloidal lead suspended in an oxidizing oil. By repeated spraying heavy coats are built up to give better protection than an equal thickness of lead. The Liquid stainless steel of the Lockrey Co. is made with a finely flaked stainless-steel powder in a synthetic resin and solvent vehicle for brushing on metal or wood to give a decorative and durable finish. Road-marking paints were formerly made with Manila copal, but may now be made with synthetics. The Traffic paint of the Hercules Powder Co. is made

with chlorinated rubber and Pentolyn. It dries rapidly and gives long wear life.

Water paints may consist of gypsum or whiting with zinc oxide, lithopone, or other material, and with water as the vehicle and glue for adhesion. Kalsomine is an old name for wall paint made with whiting and glue and some linseed oil. Water colors may be added. Whitewash is a cheap white paint made from slaked lime, salt, whiting, and glue, or sometimes quicklime and water alone. It will not withstand weathering. Modern water paints may be made with pigments and extenders in a casein solution. These are more water-resistant and more durable than glue paints. A different type of higher quality water paints is the group of Resin emulsion paints. They are water emulsions of oil-modified alkyd resins and leave tough films of resin on evaporation of the water. With pigments and extenders they form adhesive and resistant paint films. They are sometimes also added to glue or casein water paints to improve the quality. Alabastine, of the Alabastine Co., is a washable casein paint. Gelva paint, of the Shawinigan Products Corp., consists of the pigment suspended in a water solution of polyvinyl resin with a wetting agent. It dries quickly to a durable, water-resistant film.

Luminous paints are made with radium, mesothorium, or with sulphurated compounds. The hiding power of a paint is defined as that quantity which must be applied to a given area of a black and white background to obtain nearly uniform complete hiding. The hiding power is obtained almost entirely from the pigment. Paint removers, for removing old paint from surfaces before refinishing, are either strong chemical solvents or strong caustic solutions. The first type is often very effective in removing the paint but may raise the grain of the wood and discolor it.

**Palladium.** A rare metal found in the ores of platinum, symbol Pd. It resembles platinum, but is lighter in weight and has a more beautiful silvery luster. It is only half as plentiful but is less costly. The specific gravity is 12.16 and the melting point is 1549°C. The Brinell hardness of the annealed metal is 49. It is highly resistant to corrosion and to the action of acids. Like gold, it dissolves in aqua regia. It alloys readily with gold and is employed in some grades of white gold. It also forms solid solutions with platinum, and the

alloys are harder than either of the constituent metals. These alloys are easily workable and are employed for electrical contacts, instruments, and jewelry. Palladium is also used as a plating metal for such articles as electrical appliances. It is plated on steel over a thin undercoat of silver. Palladium powder is used as a catalyst in the hydrogenation of alkaloids, vitamins, and other compounds. Palladium leaf is palladium beaten into an extremely thin foil used for ornamental work like gold leaf on pocketbooks, picture frames, and decorative surfaces. It has a white color and is resistant to tarnishing even when exposed to sulphur atmospheres. A book of 500 sheets, or 35 sq ft of leaf, weighs less than  $\frac{1}{4}$  oz. Palladium-silver alloys are used for fountain-pen nibs. A dental alloy to replace gold contains 20 to 30% palladium, up to 15 copper, and the remainder silver. Palladium sponge absorbs much hydrogen and is used for gas lighters.

**Palm oil.** An oil obtained from the fleshy covering of the seed nuts of several species of palm trees, chiefly *Elaeis guineensis*, native to tropical Africa. The tree attains a height of about 60 ft, and the nuts occur in large bunches similar to dates. The fruit is of an elongated ellipse shape, about  $1\frac{1}{2}$  in. long, enclosing a single kernel. The fleshy part carries about 65% oil, which is a semisolid fat. The iodine value is about 55, and the saponification value 205. West African palm oil has four grades: Edible, with 11% max free fatty acid; Soft, with 18% max; Semihard, with 35% max; and Hard, with more than 35%. The high-grade edible oil is from fresh unfermented fruits. Fresh palm oil has an agreeable odor and a bright-orange color, but the oil often has a rancid stench and is of varying colors. The oil is used as a fluxing dip in the manufacture of tin plate, for soaps, candles, and margarine. Palm oil for tin-plate dip may be mixed with cottonseed or mineral oils. Palm oil contains 50 to 70% Palmitic acid,  $C_{15}H_{31}COOH$ , which in the form of glyceride is an ingredient of many fats. When isolated, it is a white crystalline powder of specific gravity 0.866, and melting point  $64^{\circ}C$ , soluble in hot water. Palmitic acid is used in soap, treating textiles, and in lubricating oils. Usually 10% glycerin is recovered from palm oil in the making of soaps, or in splitting to obtain the acids. Palm kernel oil is an edible oil from the kernels of the palm nut. It is different in characteristics from palm oil. It contains about 50% lauric acid, 15

myristic acid, 16 oleic acid, and 7 palmitic acid, together with capric and caprylic acids found in coconut oil, while palm oil is very high in palmitic and oleic acids. The specific gravity is 0.873, iodine number 16 to 23, saponification value 244 to 255, and melting point 24 to 30°C. The American species of palm oil is from the dwarf tree *E. melanococca* growing from Mexico to Paraguay and called Noli palm in Colombia. The pulp of the nuts yields 30% of an oil similar to African palm oil. The tall Paraguayan palm *Acrocomia sclerocarpa* has the fruit also in bunches, and the pulp yields 60% of oil very similar to palm oil.

**Papain.** The dried extract, or enzyme, obtained from the fruit and sap of the papaya tree, *Carica papaya*, of tropical America, East Africa, and Asia. It is marketed as a dry, friable powder, and it is a proteinlike material of complex structure containing a sulphate. The tree grows to a height of 25 ft without branches and is crowned with large leaves. The melonlike fruit grows out from the trunk, and has orange-colored flesh. It is eaten raw like a melon, but as it spoils rapidly it is not easily shipped. The Papaya is called Pawpaw in Florida. Papain is used in beverages, and in medicine as a digestive aid. It is also used in beer manufacture to remove protein haze, for degumming silk, as a meat tenderizer, and for softening wool that is to be used in mixed fabrics.

**Paper.** The name given to cellulose made into paste form from plant sources and rolled into thin sheets, used as a material for writing, printing, and wrapping. It may be considered as a thin felting of fibers bonded by a water-soluble cellulose formed on the fiber surfaces, to which a coating material such as clay may be added with starch or other sizing material. The original Egyptian paper, known as Papyrus, was made from the stems of the rush *Cyperus papyrus* growing along the Nile. It was made in sheets, sometimes as long as 130 ft. The Chinese process of papermaking from hempen and linen rags was brought to the Near East when the Arabs took Samarkand in 704 A.D. The papers used in Medieval Europe were Charta damascena, from the Arab factory at Damascus, and Charta bombycina, from the factory at Bombyce near Antioch, both sold in reams, from the Arabic word razmah.

There are many varieties and grades of paper, depending upon

the source of the cellulose and the method of manufacture. Wood is a lignified form of cellulose, and the wood is chipped and cooked with chemicals to dissolve out the lignin. The material so treated is known as Chemical wood pulp to distinguish it from Mechanical wood pulp used for making wallboard and newsprint paper, the latter requiring some chemical pulp to give fiber and strength. There are four processes for producing chemical pulp: the sulphite, with calcium sulphite; the soda, with caustic; the sulphate, with sodium sulphate; and the magnesium bisulphite. Book paper is usually a mixture of sulphate and soda pulp, the latter process producing a bulky pulp. Wrapping paper is a strong, coarse paper made usually from mixed pulps. Kraft paper is a heavy, brown, sulphate pulp paper of high strength, sized with rosin, used for wrapping or as building paper. Manila paper is a strong wrapping paper originally made from Manila hemp, but the name is now applied to any strong chemical wood pulp or mixed pulp paper of Manila color. Absorbent paper, such as for Blotting paper and Filter paper, is made from spongy bulky fibers, such as poplar, or is loosely felted fiber. But filter paper for filtering corrosive gases and chemicals is made with extremely fine glass fiber matted into thin sheets on regular paper machines. This type of glass paper is also used for electrical insulation.

Granite paper is made by the addition of colored fibers to the pulp or by adding several shades of dyed pulp to the regular stock. Oatmeal paper, used chiefly for wallpaper, has a flaky finish produced by washing a solution of wood flour over the sheet on the forming wire in the paper machine. The wood flour may be natural or dyed in colors. Cartridge paper is 50-80-lb Manila paper, waxed on one side, originally used for muzzle-loading cartridges, but now employed where a stiff, waterproof material is needed.

Cotton is nearly pure cellulose and makes an excellent paper material. Old cotton rags are thus scoured and used for papermaking. Linen rags are also used and produce a fine grade of writing paper. The best quality Writing and Printing papers are 50, 75, or 100% rag papers. Bond paper is a hard-finished writing paper. Highly rolled and coated printing papers are called Super-calendered papers. They are used for printing fine-screen half tones. In England this paper is called Art paper. Fine linen Ledger paper is made with

100% white rags. Good quality bond Typewriter paper may have 80% white rags. These papers are sold by weight per ream, a ream usually consisting of 500 sheets of a specified size in inches.

Glassine is a transparent thin paper used for envelope windows and for sanitary wrapping. It is made of sulphite pulp subjected to long-continued beating and supercalendered. Glassoid is a more highly finished transparent paper. Onionskin paper is a lightweight highly finished transparent writing paper made transparent by hydration of the pulp in the beaters. Glassine and other transparent papers are now often made water-resistant by adding a urea-formaldehyde resin to the pulp. Tissue paper is a very thin, almost transparent paper. It may be an ordinary wood-pulp paper or be made of special combinations, and may be loosely felted to give absorbent qualities, or have a hard, smooth surface for wrapping paper. Silicone tissue, for wiping lenses and automobile windshields, is a soft tissue paper treated with silicone resin. Albanene tracing paper, of Keuffel & Esser Co., is a thin rag paper treated with a transparent synthetic resin. It takes ink readily and erases easily.

To make paper smooth-surfaced and resistant to the spreading of inks, sizing materials such as resins, starch, alum, and glue are used. Fillers, such as China clay, are used to give body, weight, opacity, and strength to the paper. Paper may be partly waterproofed with a copper-ammonium solution and hot-rolled or starch-coated paper may be given water resistance by adding a melamine-formaldehyde resin to the starch, which also adds brightness and smoothness to the paper. A type of Waterproof paper, or Rubberized paper, is made by coating paper with rubber latex to which has been added a mineral filler and a creaming agent such as metallic soap. It has about the same appearance as ordinary writing paper, and will take writing well. Wet-strong paper is specially processed paper in which the water resistance is due to the processing and interlocking of the fibers as well as to impregnation with a small amount of synthetic resin. Resistall, of the L. L. Brown Paper Co., is a paper of this type. But some wet-strong papers are made by adding a urea-formaldehyde resin, or Hycar rubber. It is used for maps, documents, and for wrapping. The Anti-Adhesive paper of the Central Paper Co., for interleaving sticky materials and for box linings, is a kraft paper treated with a silicone resin. The Kastek paper of the Plastic Film Corp., for water-

proof wrapping, is 30- to 100-lb paper with a very thin film of polyethylene or vinyl resin bonded to the surface. The Washable wallpaper of Richard E. Thibaut, Inc., has a 0.00088-in. Lumarith cast film laminated to the paper.

Fish paper is a thin hard paper impregnated with zinc chloride and is used for electric insulation. Insulating paper, commonly called Varnished paper, is a standard material for insulation of electrical equipment. It is usually bond or kraft paper coated on both sides with black or yellow insulating varnish. The thicknesses are 0.002 to 0.020 in., with dielectric strengths of 500 to 2,000 volts per mil. Special insulating varnishes of high dielectric strength are now marketed for this purpose. Arc-resistant Laminating paper of high dielectric strength is paper impregnated with melamine formaldehyde resin mixed with hexamethenediamine. Flameproofed paper is paper treated with ammonium sulphate and ammonium and sodium phosphates. Metallized paper, of Smith Paper, Inc., used for capacitors, is a lacquer-coated kraft paper with a thin layer of zinc deposited on one side. Aluminum-coated paper is made in a similar manner.

Building paper, used for sheathing houses, is a heavy kraft paper, plain or rosin-sized. Specially treated building papers are also marketed under trade names. The Barrier paper of the Presstite Engineering Co., for lining storage rooms, is kraft paper saturated with gilsonite, asphalt, and wax. It is odorless and black in color. Weatherite, of Johns-Manville, is a kraft building paper treated with a black waterproofing. Copperskin is an insulating construction material made by facing 1-oz electrosheet copper on one or two plies of heavy building paper impregnated with bitumen. Cop-O-Top, of the Chase Brass & Copper Co., and Copper-kote, of the Cheney Co., are similar materials. Sisalkraft, of the Sisalkraft Co., is a waterproof building paper made with sisal fibers. Fibreen, of this company, is a tough, strong, flexible, waterproof paper used for wrapping bundles of steel and other heavy products. It is made of two layers of kraft paper reinforced with two crossed layers of sisal fibers embedded in asphalt, and the whole combined under heat and pressure. Brown-skin is a waterproof sheathing paper of the Angier Corp. of high-strength building paper impregnated with a bituminous compound and crimped to give it stretch and resiliency. Sta-Tite, of this com-



pany, is a building paper composed of three sheets of kraft paper with layers of asphalt between, in which are set a layer of crossed cords and one of parallel cords. Burlap-lined paper, used for wrapping leather and machinery, is heavy kraft paper coated with asphalt to which 4- to 10-oz burlap is stuck.

**Paper plants.** Cellulose for papermaking is obtained from a wide variety of plant life, made directly into Paper pulp, or obtained from old rags which were originally made from vegetable fibers. Animal fibers incorporated into some papers are fillers for special purposes and not papermaking materials. The papyrus of Egypt was made from a reed, but the Baobab of India was from the *Adamsonia digitata*. The famous Rice paper of China comes largely from the *Tetrapanax papyrifera*, but the so-called rice paper used for cigarettes in the United States is made from linseed fiber. Cigarette paper is also made in the United States from ramie and sunn hemp. The distinction between cigarette paper and the tissue paper used for wrapping is that it must be free of any substance that would impart a disagreeable flavor to the smoke and it must be opaque, pure white, burning at the same rate as tobacco, and tasteless. Wood pulp is now the most important papermaking material. Spruce is the chief wood used for the sulphite process, but hemlock and balsam fir are also used. Aspen and other hardwoods are used in the soda process, and also southern pine. Hemlock, spruce, tamarack, pine, and fir are used for the sulphate process. Spruce and fir are the notable Pulpwoods of the Northwest. Western hemlock, balsam, and spruce are the chief pulpwoods of Canada. Yellow pine is extensively used in the United States, especially for kraft paper, paperboard, and book paper. Poplars are also used for pulpwood. In England fine printing papers are made by the soda process from Esparto grass. It gives a soft, opaque, light paper, although the cellulose content is less than 50%. Esparto is the plant *Stipa tenacissima* of the dry regions of North Africa. In Tunisia it is called Alfa. It grows to a height of about 3 ft, with cylindrical stem. The fine, light fibers, about  $\frac{1}{2}$  in. long, are from the leaves. Some grades of cardboard and some newsprint are made from straw. Deluwang paper of the East Indies is made from the scraped and beaten bark of the Paper mulberry tree, *Broussonetia papyrifera*. It is an ancient industry in Java, and the

paper is used for lampshades and fancy articles. Under the name of Tapa cloth the sheets were dyed and used as a muslinlike fabric by the Polynesians. The strips are welded together by overlapping and beating together the wet material.

**Papier maché.** Comminuted paper or paper pulp made into a paste with a binder, and molded into the desired form. It is then painted or enameled, or the paste itself may be dyed. Papier maché, originated in France in 1740, was widely employed for toys, dishes, and novelties before the invention of the synthetic molding materials. It is easy to mold, but has little strength and is not suited for mechanical parts. Dishes and novelties now made of paper stock are usually made directly from the wood pulp.

**Paraffin.** A general name often applied to paraffin wax, but more correctly referring to a great group of hydrocarbons obtained from petroleum. Paraffin compounds begin with methane,  $\text{CH}_4$ , and are sometimes called the methane group. The substances in the series have the general formula  $\text{C}_n\text{H}_{2n+2}$ , and include the gases methane and ethane, and the products naphtha, benzine, gasoline, lubricating oils, jellies, and the common paraffin. The name paraffin indicates little affinity for reaction with other substances. In common practice the name is limited to the waxes that follow petroleum jelly in the distillation of petroleum. These waxes melt at from 40 to 60°C, and consist of the hydrocarbons between  $\text{C}_{22}$  and  $\text{C}_{27}$ ; the refined waxes may range up to 90°C. They burn readily in the air. Paraffin occurs to some extent in some plant products, but its only commercial source is from natural petroleum. Chlorinated paraffin is a pale to amber-colored, odorless, soft wax or viscous oil of specific gravity 0.900 to 1.50. It is flame-resistant, and is used in treating paper and textiles. Chlorowax, of the Diamond Alkali Co., is a chlorinated paraffin for adhesive, fire-resistant, and water-resistant compounds. It is a cream-colored powder containing 69 to 73% chlorine, and is insoluble in water but soluble in organic solvents. Clorafin 42, of the Hercules Powder Co., is an amber-colored viscous liquid chlorinated paraffin containing 42% chlorine. Clorafin 70 is a yellow solid containing 70% chlorine and softening at 90 to 100°C. The former is used as a plasticizer in resins and for coatings; the latter is for flame-proofing and waterproofing textiles.

**Paraffin oil.** The drip oil from the wax presses in the process of extracting paraffin wax from the wax-bearing distillate in the refining of petroleum. The oil is treated, redistilled, and separated into various grades of lubricating oils from light to heavy. They may be treated and bleached with sulphuric acid, and neutralized with alkali. When decolorized with acid and sold as filtered, they are brilliant liquids, but are not suitable as crankcase lubricants, or in places where they may be in contact with water, since the sulpho compounds present cause emulsification. The specific gravities of paraffin oils are between 21 and 26°Bé. Triton oil is a 100% pure paraffin oil produced by the Union Oil Co. of California.

**Paraffin wax.** The first distillate taken from petroleum after the cracking process is known as wax bearing, and is put through a filter press and separated from the oils. The wax collected on the canvas plates is called Slack wax, and contains 50% wax and 50 oil. This is chilled to free it from oil. The yellow wax is filtered to make a white semitranslucent refined wax, which is odorless and tasteless. Paraffin wax is soluble in ether, benzine, and essential oils. Match wax has a melting point of 105 to 112°F; white crude wax, 111 to 113°F; yellow crude, 117 to 119°F; and special white, 124 to 126°F. The refined waxes are in various melting-point ranges from 115 to 136°F, and are used for coating paper and for blending in coating and impregnating compounds. They are also used in candles and other products. The refined paraffin wax used for molded goods and for rubber compounding is a white solid having a melting point of 122°F and a specific gravity 0.903. Borneo wax has a very high melting point and a hard crystalline structure which makes it valuable for coatings and for high-quality candles. By treatment of the American wax to remove the lower melting constituents a higher melting point and harder crystalline structure approaching that of the Borneo wax is obtained. This is known as Microcrystalline wax. Aristowax, of the Union Oil Co. of California, is a treated wax of this kind with melting points from 145 to 165°F. Petrolite wax, of the Petrolite Corp., is a microcrystalline wax with melting point at 195°F. Sunwax, of the Sun Oil Co., is a microcrystalline wax in two grades, a brown with melting point of 175°F, and a yellow with melting point of 185°F. Wax tailings is the name for the distillate

that comes from petroleum after the wax-bearing distillate is removed. It contains no wax, but at ordinary temperatures looks like beeswax. It is very adhesive and is employed in roofings and for waterproof coatings. Arwax, of the American Resinous Chemicals Corp., is a concentrate of butyl rubber or polyethylene in microcrystalline paraffin for mixing with paraffin wax paper-coating compounds to improve grease resistance, increase tensile strength, and give greater flexibility. Advawax 2575, of the Advance Solvents & Chemical Corp., is paraffin wax mixed with polyisobutylene, used for paper coatings. It makes coatings of good flexibility and high moisture resistance.

**Parchment.** Originally, goat or sheep skin specially tanned and prepared with a smooth hard finish for writing purposes. It was used for legal documents, maps, and fancy books, being more durable than the old papers. Parchment now is usually Vegetable parchment. It is made from a base paper of cotton rags or alpha cellulose called Waterleaf which contains no sizing or filling materials. The waterleaf is treated with sulphuric acid which converts a part of the cellulose into a gelatinlike Amyloid. When the acid is washed off, the amyloid film hardens on the fibers and in the interstices of the paper. The strength of the paper is increased, and it will not disintegrate even when fully wet. The paper now has a wide usage in food packaging as well as for documents as a competitor of the resin-treated wet-strong papers. The wet strength and grease resistance are varied by differences in acid treatment and subsequent sizing. Patapar, of the Paterson Parchment Paper Co., is a vegetable parchment marketed in many grades. Parchment papers are also waterproofed by dipping in the solution of copper hydroxide and ammonium hydroxide known as Schweitzer's reagent, and then hot-rolling. Vellum is a thick grade of writing paper made from high-grade rag pulp to imitate calfskin.

**Pasteboard.** A class of thick paper used chiefly for making boxes and cartons, and for spacing and lining. It may be made by pasting together several single sheets, but more usually by macerating old paper and rolling into heavy sheets. It may also be made of straw, certain grasses, and other low-cellulose paper materials, and is then known as Strawboard. Colloquially, the term pasteboard applies to any paper-stock board used for making boxes. Cardboard is usually

a good quality of chemical pulp or rag pasteboard used for cards, signs, or printed material, or for the best quality boxes. Ivory board, for art printing and menu cards, is a highly finished cardboard clay-coated on both sides. Bristol board is a high-class white cardboard, supercalendered with china clay, or it may be made by pasting together sheets of heavy ledger paper, but the name is also applied to any high-grade printing or drawing board over 0.006 in. thick. Index bristol is always made solid on a Fourdrinier machine to prevent splitting in use or warping. The original board made in Bristol, England, was made in this way. Jute board, used for folding boxes, is a regular product of the paper mills, and is a strong solid board made of kraft pulp. Chipboard is a cheap board made from mixed scrap paper, used for boxes and book covers. When made with a percentage of mechanical wood pulp, it is called Pulpboard. A heavy rope-pulp paper or board, usually reddish in color and used for large expansion filing envelopes, is called Paperoid.

**Pattern woods.** Sugar pine is the most widely used wood for patterns employed in all kinds of foundry work in the United States. It replaces eastern white pine, which is scarcer and now usually more costly. Poplar is used for patterns where a firmer wood is desired; cherry or maple is employed where the pattern is to be used frequently or will be subject to severe treatment. Densified wood is also used for patterns required to be very wear-resistant. The densified wood marketed for this purpose by the Pioneer Foundry & Mfg. Co. in sheets up to a thickness of 2 in. has a specific gravity of 1.35, and is strong in all directions. Mahogany is used for small and intricate patterns where a firm texture and freedom from warpage are needed. However, for small castings made in quantities on gates, aluminum or brass is more frequently used.

**Peanut oil.** Also known as Groundnut oil. A pale-yellow oil with a distinctive nutty taste and odor, obtained from the pressing of the seed kernels of the peanut, a legume of the genus *Arachis*, of which there are many species. It was native to Brazil, brought to Africa in slave ships and thence to the United States. It is now grown in many countries. The Spanish peanut, cultivated in temperate climates, has small seeds, while the common variety, *A. hypogaea*, known in the United States as the Virginia peanut, has pods up to 1½ in. long

with seeds twice the length of the Spanish varieties. The Spanish peanut, however, is easily grown and gives a high yield per acre. The Brazilian peanut, *A. nambyquarae*, has pods up to 3 in. in length. Vast quantities of peanuts are roasted and marketed as food nuts or for confections or ground to make edible Peanut butter. The best grades of cold-pressed oils are marketed as edible oils, but the oil is also used industrially for soaps, in diesel-engine fuels, and for blending in lubricating and varnish oils. The Arachidic acid,  $\text{CH}_3(\text{CH}_2)_{18}\text{COOH}$ , contained in the oil to the extent of 4%, however, makes a hard soap. The oil also contains 52 to 62% oleic, 21 to 25 linoleic, besides palmitic, stearic, and lignoceric acids. The specific gravity is from 0.916 to 0.922, saponification value 189 to 196, and iodine value 83 to 101. The oil known as Arachis oil, or as Katchung oil when imported from the Orient, is from the peanut *A. hypogaea*. It is used in lubricating, for varnishes, and for softening leather. Peanut meal, left after extraction of the oil, is sold as stock feed, or that from the final extraction of the inedible oil is used for fertilizer.

**Peat.** An earthy mass formed by the rapid accumulation of quick-growing mosses and plants, and valued as a fuel in countries where fuels are expensive. Large quantities are used for fuel in Finland, Switzerland, Ireland, and some other countries. In Russia large amounts are used to produce fuel gas and for processing the tar into chemicals. In the United States it is used for fertilizer, insulation, and packing. The dried Peat moss is used for making insulating board. Peat bogs, or beds, are found mainly in moist districts in temperate climates. The top layers are only slightly decayed, are brown in color, and of low specific gravity. But at greater depths peat is nearly black and is very compact. The reserves of peat are very large in the states bordering on the Great Lakes, those in the state of Minnesota alone being estimated at 7,000 million tons. Fresh peat often contains as high as 80% moisture and must be dried before use. Wick-low dried peat contains about 71% volatile matter, 27% being fixed carbon, and 28% coke. The calorific value of peat is about 5,000 Btu. It is sometimes semicarbonized and made into fuel briquettes. Charred peat is peat that has been subjected to a temperature to cause partial decomposition. It is marketed as fertilizer. Peat is also distilled, yielding mainly gas and a high percentage of tar. Peat wax,

extracted from peat in England, is a hard wax with characteristics similar to montan wax, and is a substitute for it.

**Pentaerythritol.** A tetrahydric alcohol of the composition  $\text{HOH}_2\text{C} \cdot \text{C}(\text{CH}_2\text{OH})_3$  produced by the condensation of formaldehyde and acetaldehyde. It is a white, crystalline solid melting at about  $262^\circ\text{C}$ . The commercial grade is 85 to 90% pure. It is employed for the production of explosives, plastics, drying oils, and chemicals. Pentaerythritol will combine with the fatty acids of vegetable oils to form esters that are superior to linseed oil as drying oils. Combined with the fatty acids of linseed oil, it will give a drying oil that will dry completely in 6 hr compared with 16 hr for a bodied linseed oil, and as a varnish oil it gives higher gloss and greater water resistance. Synthetic waxes are also made by combining pentaerythritol with long-chain, saturated, fatty acids, and these waxes have higher melting points than beeswax or carnauba wax, but do not have the natural gloss of carnauba. Pentawax 177, of the Heyden Chemical Co., is a pentaerythritol stearate. It is a light-brown wax melting at  $53^\circ\text{C}$ , used for coating paper, in printing inks, and in cosmetics. Pentamull 126 of this company is an ester of pentaerythritol and oleic acid. It is an amber-colored oil used as an emulsifying agent. Pentex is a technical grade of pentaerythritol containing 85% mono pentaerythritol and the balance higher polymers. It produces fast-drying and glossy varnishes. The Pentalyn resins of the Hercules Powder Co., used to replace copals in varnishes, are pentaerythritol esters of rosin. Pentalyn 802A is a phenol-modified pentaerythritol rosin ester for gloss printing inks and traffic paints. It is pale in color, and has high resistance to chemicals and wear.

**Pepper.** One of the oldest and most important of the spices. Black pepper, the common household spice, is the ground, dried, unripe fruit of the evergreen shrub or vine, *Piper nigrum*, of India and Malaya. There are two grades of Indian pepper, Alleppey and Telli-cherry; the latter is bolder and heavier and the more expensive grade. The fruits are small, berrylike drupes. They change in ripening from green to bright red to yellow. When dry the unripe berries are reddish brown or black. The vine comes into full production in 3 years and lives for 20 to 30 years. A vine yields 5 to 10 lb of pepper. White pepper, preferred for the preparation of commercial foods, is

from the nearly ripe berries. It has a yellow to gray color. Pepper is used as a condiment and stimulates the flow of gastric juices. White pepper is not as pungent as black pepper. Commercial pepper is often a blend of the two kinds. Pepper oil, used for flavoring, is a yellowish essential oil of specific gravity 0.873 to 0.916 with a pepper-like odor and flavor but not pungent like pepper. It is extracted from the common pepper berries. Pepperoyal, of the Griffith Laboratories, is pepper flavor extracted from black pepper and converted to minute soluble globules that disperse easily in foodstuffs. Long pepper, highly esteemed in some countries for preserves and curries, is more aromatic and is sweeter than common pepper. It is from the tiny fruits of the climbing plant *P. retrofractum* of Malaya and the *P. longum* of India and the East Indies. Ashanti pepper, of West Africa, is from the vine *P. guineense*, also known as Guinea pepper, although this name is applied to Grains of Paradise which are the pungent peppery seeds of the perennial herb *Aframomum melegueta* of West Africa, used for flavoring and in medicine. The seeds are also called Alligator pepper, and Melegueta pepper, and are used as pepper in Europe, but the plant is of the ginger family. Cubeb is the dried unripe fruit of the climbing vine *P. cubeba* of India, East Indies, and West Indies. The berries resemble those of black pepper, but have a strong peculiar odor, and a bitter aromatic taste. Cubeb is used in medicine and cigarettes. Cubeb oil is from the berries, which yield 10 to 16% of the colorless to pale-green oil with a pepperlike odor. It is used in perfumery and in soaps. Paprika is the ground dried fruit of the *Capsicum annum* of Europe and America. When full, red, ripe pods are used, and the seeds, cores, and stems are removed, a uniform maximum red color is produced. Yellow pods give low red value. Paprika is used as a condiment. Chili pepper is from the smaller podlike berries of species of *Capsicum* which grow as small trees or shrubs. It is a tropical plant. The ground fruits as a condiment are known as Red pepper, or Cayenne pepper. In medicine it is known as Capsicum, and is used as a carminative and as a source of vitamin P. It is also used in soft drinks in place of ginger.

**Peppermint.** An oil distilled from the perennial herb *Mentha piperita* which grows in the temperate climate of America, Europe, and



Asia. The oil has a pleasant odor and a persistent cooling taste and is valued as a flavor and in soaps, tooth pastes, perfumes, and pharmaceuticals. The oil contains Menthol,  $C_{10}H_{20}O$ , which is extracted for use as an antiseptic, in perfumery, and in medicine for colds and as an antispasmodic and anodyne. Japanese peppermint is from the *M. arvensis* grown extensively in Japan, Brazil, and the United States. The oil is less fragrant, and is used for the production of menthol as it has a higher menthol content. The plant is propagated from roots and grows to a height of 2 to 3 ft. It is cut when it blooms and partly cured like hay. The crude oil is obtained by steam distillation; the menthol is obtained by freezing and recrystallization, with a yield of 50% menthol crystals to total crude oil. The residue oil is called Cornmint oil. It retains the peppermint flavor and is used in perfumery and flavoring. Spearmint is from the *M. viridis*, grown largely in Michigan. The oil is sharper in odor and taste and used chiefly in chewing gums. Pennyroyal oil is distilled from the dried leaves and tops of the small annual plant *Hedeoma pulegioides* or *M. pulegium* which grows in eastern United States. The oil is a counterirritant and is used in liniments. It is also used in insect repellents and for the production of menthol. The plant yields 0.7% oil, and the oil will yield 65% menthol with a melting point of 33 to 35°C, or 40% of 42°C menthol. Horsemint oil is from the plant *M. canadensis*, used for the production of thymol. Menthol and menthol substitutes are also synthesized from coal-tar hydrocarbons. Cyclonol, of W. J. Bush & Co., Inc., is a derivative of cyclohexanol. It lacks one H and one CH of the structural formula of menthol, but has the characteristic odor and cooling effect.

**Perfume oils.** Volatile oils obtained by distillation or by solvent extraction from the leaves, flowers, gums, or woods of plant life, although a few are of animal origin. Perfumes have been used since earliest times, not only for aesthetic value, but also for antiseptic value and for religious purposes. Simple perfumes usually take their name from the name of the plant, but the most esteemed perfumes are blends, and the blending is considered a high art. It is done by tones imparted by many ingredients. Some oils with repugnant odors have an attractive fragrance in extreme dilution and a persistence which is valued in blends and for stabilization. Some oils with heavy

odors, such as coumarin, are used in dilution to give body. Since many of the odors come directly from esters, aldehydes, or ketones, they can be made synthetically from coal-tar hydrocarbons and alcohols. In general, the aldehyde odors are fugitive, and some become acid in the presence of light or oxygen. Ketones are more stable. Esters are usually stable, but some are saponified in hot solution and cannot be used for soaps. Some esters, made from complex high alcohols, are used to give a fresh top note to floral perfumes. Linalyl acetate, produced from citral, is an example. Acid perfumes neutralize free alkali and cannot be used in soaps. Phenol odors alter the color of soaps, and the odor may also become disagreeable.

Some odors are never extracted from the flowers, but are compounded. Crab apple, for example, which is a peculiarly sweet odor, is compounded of 16 oils, including bois de rose, ylang ylang, nutmeg oil, jasmine, musk, heliotropin, coumarin, and others. Wisteria, or Glycine, is the honeylike odor of the mauve and white flowers of the climbing plant *Wisteria sinensis*. The oil is never extracted but is compounded from geranium, Peru balsam, benzoin, bois de rose, and synthetics. Some oils, such as Lavender, from the flowers of the *Lavandula vera*, have no value when used alone but require skillful blending to develop the pleasant odor. Apple and peach odors are Allyl cinnamate.

Fixatives are used for the finer perfumes. They are essential oils that are less volatile and thus delay evaporation. The animal oils, such as musk and civet, are of this class, and also the balsam oils. Some evil-smelling distillates from chemical manufacture may also be used as fixatives. Musk is from the male musk deer of Tibet. It is one of the most expensive of materials. It has not been chemically appraised, and is thus much adulterated. Synthetic musk is as powerful as the natural. The synthetic musk of E. I. du Pont de Nemours & Co., Inc., is called Astrotone. Ambrette oil has a strong musklike odor distilled from the Musk seed, or Amber seed, of the plant *Hibiscus abelmoschus* of Ecuador, India, and Egypt. Civet is an odorous yellow fluid from the civet cat of tropical Asia and Abyssinia. Civettone is a liquid with a clean odor and easily soluble in alcohol, distilled from civet. Patchouli oil is one of the best fixatives for heavy perfumes. It is a powerfully odorous viscous liquid obtained by distilling the fermented leaves of the shrub *Pogostemon patchouli*

of India, China, and the Philippines. The odor resembles sandalwood. Cassie is a valuable oil with an odor similar to violet obtained by maceration in oil of the flowers of the shrub *Acacia farnesiana* of the Mediterranean countries and the West Indies. It is used to scent pomades and powders.

Attar of rose is one of the most ancient and popular of perfume oils. The name is derived from the Persian Atar, and is sometimes incorrectly given as Otto or Ottar but with the same pronunciation. The finest attar of rose is from Bulgaria, where it is distilled from the flowers of the Damask rose, *Rosa damascena*. The fresh oil is colorless, but turns yellowish green. About 20,000 lb of flowers are needed to make 1 lb of essence, and it is so valuable that it is usually adulterated with geraniol or synthetic rose. In France the oil is obtained from the *R. centifolia*. Rose water is the scented water left after distillation, or is made by dissolving attar in water. The Otto of boronia of Australia is a high-grade rose oil.

Geranium oil is obtained from the leaves or flowers of the *Pelargonium graveolens* of the Mediterranean countries and other species of geranium. It is used as an adulterant or substitute for rose oils in perfumes and soaps. Zdravetz oil is a geranium oil from the *P. macrorrhizum* of Cyprus, used in rose bouquet and lavender perfumes. Many geranium and rose oils are derived from geraniol obtained from citronella and other oils. A synthetic rose-geranium is Diphenyl methane,  $(C_6H_5)_2CH_2$ , a colorless solid melting at about 25°C. Geraniol is a colorless liquid with a sweet, delicate rose odor. Vetiver, a very sweet-scented oil used in high-grade perfumes and in medicine, is distilled from the roots of the Khuskhus plant *Vetiveria zizanioides* native to India but now grown in other tropic and subtropic countries. Opopanax, used in incense and in medicine, is an oleoresin from the roots of the *Pastinaca opopanax* of the Orient and British Somaliland. Frankincense, used in incense and perfumes, and in medicine under the name of Olibanum, is a gum resin from the tree *Boswellia carterii* of the Sudan and Somaliland. It comes in hard yellow grains. Kiou-nouk, used as a fixative, is a clear yellowish semiliquid obtained from olibanum. Mecca balsam, used in oriental types of perfume, is a greenish oleoresin from the plant *Commiphora opobalsamum* of Arabia. It has the odor of rosemary. Rosemary is an oil distilled

from the fresh flowering tops of the sweet-smelling evergreen shrub *Rosemarinus officinalis* of the Mediterranean countries. It is used in eau de cologne, soaps, and medicine. Jasmine oil, a highly valued perfume material, is from the fragrant flowers of the shrub *Jasminum grandiflorum*, a species of jasmine grown in southern France especially for perfume. The oil is extracted from the fresh flowers by enfleurage. A synthetic Jasmine-rose oil, which also has a Peach-apricot flavor and a sweet taste, is Benzyl propionate,  $\text{CH}_3\text{CH}_2\text{COOCH}_2\text{C}_6\text{H}_5$ . It is a liquid boiling at  $220^\circ\text{C}$ , and is used in perfumes and as a flavor.

Lavender oil, used with rosemary in eau de cologne, and also as Lavender water in a mixture of the oil in water and alcohol, is obtained from the flowers of the shrub *Lavandula officinalis* of southern Europe. The dried flowers are fragrant and are used in sachets. Spike lavender is an inferior oil from the plant *L. latifolia* of France and Spain. It is used in perfumes and sometimes as a food flavor. Bay oil, or Myrcia oil, used in the toilet alcohol known as Bay rum, and also in perfumes, is distilled from the leaves of the bay tree, *Pimenta acris*, of the West Indies, 60 lb of leaves yielding 1 lb of oil, and 1 gal of bay oil being used to 100 gal of rum to make bay rum. It contains a high percentage of eugenol, and has a spicy odor and flavor.

Carnation oil is obtained by solvent extraction or by enfleurage from the flowers of the *Dianthus caryophyllus* of which there are more than 2,000 varieties grown in the Mediterranean countries. The less highly cultivated plants give the richest perfumes. Violet oil is derived by solvents or maceration in hot oils from the flowers of the blue and purple varieties of *Viola odorata*. Synthetic violet is made from ionone derived from lemongrass oil. The true violet odor is Irone, a complex 7-ring compound. It can be obtained from the iris root and is one of the most odoriferous materials obtained from plants. Orris is the dry root of the *Iris florentina*, and the powdered root is used in violet powders and as a flavor. Oak moss was one of the perfumes of ancient Egypt. It is obtained from the lichen *Evernia prunastri* and *E. furfuracea* growing on oak and spruce trees of southern Europe. The resinous extract has the odor of musk and lavender. It is used as a fixative in perfumes of the poppy type. Rue oil, used

for sweet-pea perfume, is distilled from the plants *Ruta graveolans* of France and *R. montana* of Algeria.

**Perilla oil.** A light yellow oil obtained from the seeds of the plant *Perilla ocimoides* of China and Japan, and employed in varnishes, core oils, printing ink, and linoleum. It dries to a harder, tougher, and glossier film than linseed oil. The specific gravity is about 0.935, iodine value 200, and saponification value 191. It contains 41 to 46% linolenic acid, 31 to 42 linoleic, and 3 to 10 oleic acid. In Japan it is called Egoma oil. A disadvantage is its property of forming globules, but this is overcome by boiling or blowing the oil. The blown oil is rapid-drying and is more weather-resistant than linseed oil.

**Permeability alloys.** A general name for iron-nickel alloys possessing a magnetic susceptibility much greater than iron. An early alloy determined by experiment was made up theoretically of 78.5% nickel, 21.5 iron, but with other elements approximately as follows: carbon, 0.04%; silicon, 0.03; cobalt, 0.37; copper, 0.10; and manganese, 0.022. It is produced by the Western Electric Co., sometimes with chromium or molybdenum, under the name of Permalloy, and is used in magnetic cores for apparatus that operates on feeble electric currents, and in the loading of submarine cables. It has very little magnetic hysteresis.

Supermalloy, developed by the Bell Laboratories for transformers, contains 79% nickel, 15 iron, 5 molybdenum, and 0.5 manganese, with total carbon, silicon, and sulphur kept below 0.5%. It is melted in vacuum, and poured in an inert atmosphere. It can be rolled to a thinness of 0.00025 in. The alloy has an initial permeability 500 times that of iron. The Sendust alloys, used in Japan during the shortage of nickel and cobalt, contained iron, silicon, and aluminum. They had high permeability. Mumetal, of the Telegraph Construction & Maintenance Co., Ltd., has 76% nickel, 6 copper, and 1.5 chromium. Permafy is a French alloy of this type. It has a lower initial permeability than the plain nickel-iron type, but has a higher resistivity to keep down eddy-current losses. Perminvar, of the Western Electric Co., is an alloy containing 45% nickel and 25 cobalt, intended to give a constant magnetic permeability for variable magnetic fields. A-metal is a nickel-iron alloy containing 44% nickel and a

small amount of copper. It is used in transformers and loud-speakers to give nondistortion characteristics when magnetized. Permax is a French high-permeability alloy of nickel and iron with small additions of manganese and other elements.

Permenorm, first produced in Germany as Orthonel and developed at the U.S. Naval Ordnance Laboratory, contains 50% nickel and 50 iron. It is subjected to drastic rolling in one direction followed by a heat-treatment to obtain chemical combination of the nickel and iron. It has a grain orientation which, when subjected to a magnetic field, produces a square hysteresis loop indicating instantaneous magnetization. It is used as a core material and as a magnetic amplifier. Deltamax, of the Arnold Engineering Co., is this material.

Conpernik, of the Westinghouse Electric Corp., contains equal amounts of nickel and iron with no copper. It is called constant permeability nickel, and has little permeability variation. It differs from Hipernik of the same company only in heat-treatment. When heat-treated, Hipernik has higher permeability than silicon transformer steel up to flux density of about 10 kilogausses. Both alloys are used in transformer cores. Hipereco, of this company, contains 35% cobalt, 64 iron, and 1 chromium. It is ductile and easy to roll to extremely thin strip for instrument parts. The heat-treated metal has high permeability and low hysteresis loss, but in this condition it has low tensile strength and is brittle. Vicalloy, developed by the Bell Laboratories, is a high-permeability alloy containing 36 to 62% cobalt, 6 to 16 vanadium, and the balance iron. It is cast and hot-swaged, then drawn into wire or tape as fine as 0.002 in. It retains high permanent magnetism.

Iron-nickel permeability alloys are used as loading by wrapping a continuous layer around the full length of the cable. When nickel-copper alloys are used, they are employed as a core for the cable. Magnetostrictive alloys are iron-nickel alloys which have the characteristic that they will resonate when the frequency of the applied current corresponds to the natural frequency of the alloy. They are used in radios to control the frequency of the oscillating circuit. Temperature compensator alloys are iron-nickel alloys with about 30% nickel. They have the characteristics that they are fully magnetic at  $-20^{\circ}\text{F}$  but lose the magnetic permeability in proportion to rise in temperature until at about  $130^{\circ}\text{F}$  they are nonmagnetic. Upon cooling they

regain permeability at the same rate. They are used in shunts in electrical instruments to compensate for errors due to temperature changes in the magnets.

**Persimmon wood.** The wood of the common persimmon trees *Diospyros virginiana*, of the southeastern United States, and the Black persimmon, *D. texana* of western Texas. It is used for shuttles, golf-stick heads, and tools, and takes a fine polish. The tree belongs to the ebony family, of which there are listed about 160 species. The persimmon is a small tree not over 50 ft high and 12 in. in diameter. The wood is very hard, strong, and compact, and retains its smoothness under long rubbing. The sapwood is light brown in color, 2 to 5 in. wide, and the heartwood is black but very small, like a pencil in a 6-in. tree. The weight is 49 lb per cu ft. The fruit is cultivated for food, and there are only limited quantities of the wood. A fine wood used for fancy articles is Olive wood, from the olive fruit tree of California. It is yellow with beautifully streaked dark lines.

**Petitgrain.** An essential oil obtained by distillation of the leaves and small twigs of the Bitter orange tree, *Citrus aurantium*, native to tropical Asia, but now grown in other countries. In Spain, it is known as the Seville orange. Paraguay is the chief producer of high-grade petitgrain, which is one of the best fixatives for fine perfumes and is also used in flavoring extracts. One pound of petitgrain is obtained from 100 to 150 lb of leaves. The fruits of the tropical bitter orange are large and of the finest golden appearance, but the pulp is very acid. The juice is used only for blending in orange drinks. It contains a dilactone, Limonin, which gives it a bitter taste. The rind is used in Marmalade and Candied orange peel. An essential oil distilled from the rind is known as Curaçao, and is used in perfumery and in Curaçao liqueur. The flowers are very fragrant, and from them Neroli oil is distilled. Neroli is used in perfumery blends and for mixing with synthetic perfumes. Neroli Portugal is inferior, and comes from the sweet orange *C. sinensis* by extraction. Orange oil, obtained by expression from the ripe rind of the sweet orange, is a less valuable oil. Bergamot oil is from the rind of the fruit of the small spiny tree *C. bergamia* of Italy. It has a soft sweet odor, and is used in perfume blends and in soaps. The golden-yellow pear-shaped fruit has an acid inedible pulp.

**Petrolatum.** A jellylike substance obtained in the fractional distillation of petroleum. Its composition is between  $C_{17}H_{36}$  and  $C_{21}H_{44}$ , and it distills off above  $303^{\circ}\text{C}$ . It is also called Petroleum jelly. It is used for lubricating purposes and for compounding with rubber and resins. When highly refined for the pharmacy trade, it is used as an ointment. The specific gravity is from 0.820 to 0.865. It is insoluble in water but readily soluble in benzine and in turpentine. For lubricating purposes it should be refined by filtration only and not with acids, and not adulterated with paraffin. The melting point should be between  $115$  and  $130^{\circ}\text{F}$ . Petrolatum of Grade O, used as a softener in rubber, is a pale-yellow, odorless semisolid of specific gravity of 0.84 and melting point  $115$  to  $118^{\circ}\text{F}$ . Sherolatum is petrolatum jelly of the Sherwood Petroleum Co., Inc., and Vaseline is petroleum jelly of the Chesebrough Mfg. Co.

**Petroleum.** A heavy liquid, inflammable mineral oil stored under the surface of the earth, and originally formed as the by-product of the action of bacteria on marine plants and animals. It consists chiefly of carbon and hydrogen in the form of hydrocarbons, including most of the liquids of the paraffin series,  $C_5H_{12}$  to  $C_{16}H_{34}$ , together with some of the gases,  $\text{CH}_4$  to  $\text{C}_4\text{H}_{10}$ , and most of the solids of the series from  $C_{17}H_{36}$  to  $C_{27}H_{56}$ . It also contains hydrocarbons of other series; the residue contains sulphur, nitrogen, and oxygen. Petroleums from different localities differ in composition, but tests of oils from all parts of the world give the limits as 83 to 87% carbon, 11 to 14 hydrogen, with sulphur, nitrogen, and oxygen in amounts from traces to 3%. Mexican and Texan oils are high in sulphur. The crude oil is split by distillation into naphtha, gasoline, kerosene, lubricating oils, paraffin, and asphalt. It may also be split by cracking, that is, by subjecting to violent heating in the absence of air. This process yields a higher proportion of volatile products because of the breaking down of the more complex molecules by the high heat. Liquefied petroleum gases, including Propane, Butane, Pentane, or mixtures, are marketed under pressure in steel cylinders as Bottled gas. Propane,  $\text{CH}_3\text{CH}_2\text{CH}_3$ , is used in cook stoves. Butane, which has an additional  $\text{CH}_2$  group, is used to enrich illuminating and heating gas. Propane and butane gases have heating values from 2,800 to 3,000 Bru per cu ft. Liquid gas is also used for



internal-combustion engines, as a solvent, and for making many chemicals. Pyrogen is the trade name of a gas obtained during the process of recovering gasoline from natural gas. It is marketed in cylinders for use in flame cutting torches. Road oil, used on dirt roads, is a heavy residue oil from the refineries.

White mineral oil is petroleum highly refined to color. Russian and Rumanian oils with high naphthene content were particularly suitable for this refining and the oil was called Russian oil. Pennsylvania paraffin-base oils and Texas asphaltic-base oils are difficult to refine to color and give high losses. The American White Russian oil is refined from Mid-continent and Gulf Coast oils which contain high naphthenes. It is used as a laxative and as a carrier of many drugs. It is also used in wool spinning, and is valued for soluble oils as it is self-emulsifying. Highly refined white mineral oils, with unsaturated hydrocarbons removed, are used also as plasticizers for brittle plastics to add flexibility.

Petroleum from Baku was used from ancient times for lighting purposes, and the Bolivian oil was used in the sixteenth century for burning. The first commercial wells in the United States were opened in 1859 at Titusville, Pa. The chief production of petroleum is in Mexico, United States, Russia, Rumania, Asia Minor, Peru, and northern South America, but large reserves exist in many other places. About half the world production of crude petroleum is in the Western Hemisphere, but the largest single field is in the Persian Gulf area, with known reserves above 40 billion barrels. Only about 1% of the total American production of crude oil is from the Pennsylvania field, but about one-quarter of the motor lubricating oil is from Pennsylvania crude oil.

**Pewter.** A very old name for tin-lead alloys used for dishes and ornamental articles, but now referring to the use rather than to the composition of the alloy. Tin was the original base metal of the alloy, the ancient Roman pewter having about 70% tin and 30 lead, although iron and other elements were present as impurities. Pewter, or Latten ware, of the sixteenth century contained as high as 90% tin, and a strong and hard English pewter contained 91% tin and 9 antimony. This alloy is easily cold-rolled and spun, and can be hardened by long annealing at 225°C and quenching in cold water and

tempering at 110°C. Pewter is now likely to contain zinc and antimony, and very much less tin; when the proportion of tin is below about 65%, the alloys are unsuited for vessels to contain food products, because of the separation of the poisonous lead. Antimony as an alloying product is also undesirable in food containers because of its poisonous nature; when the tin is low, antimony is needed to make the metal susceptible to polishing. Best pewter, used for high-class articles, contains 100 parts tin, 8 antimony, 2 bismuth, and 2 copper. Triple has 83 parts tin, 17 antimony, or some lead to replace part of the antimony. Pewter should have a peculiar bluish-white luster when polished. It can be spun easily. Pewters containing much lead are dark in color and must be plated.

Britannia metal is a type of latten ware which also usually contains copper. The color is silvery-white with a bluish tinge, or with a yellowish tinge if the copper is high. The ordinary composition is quite similar to some babbitts, 89% tin, 7.5 antimony, and 3.5 copper. It takes a fine polish and does not tarnish easily. It is easily worked by stamping, rolling, or spinning, or may be cast. Some zinc may be used in the casting alloys. English Britannia metal has 94% tin, 5 antimony, and 1 copper. Hanover white metal contains 87% tin, 7.5 antimony, and 5.5 copper. Dutch white metal has 81.5% tin, 8.5 antimony, and 9.5 copper.

Queen's metal is a Britannia metal containing a small amount of zinc. A typical composition is 88.5% tin, 7 antimony, 3.5 copper, and 1 zinc. The zinc helps to strengthen the alloy. Minoform is another grade containing up to 9% zinc and up to 1 iron. When zinc is used in these metals, the antimony is lowered because both metals tend to make the alloy brittle. Ashberry metal, for tableware, contains some nickel and aluminum. Tutanic metal, a German utensil alloy, had 88 to 92% tin, up to 3 copper, and 6 to 7.5 lead. Ludensheid plate had 72% tin, 24 antimony, and 4 copper, with a trace of lead to increase fluidity. Wagner's alloy and Koeller's alloy were names for utensil alloys, the latter containing some bismuth to improve the casting.

**Phenol.** Also known as Carbohc acid. A colorless to white crystalline substance of sweet odor, having the composition  $C_6H_5OH$ , obtained from the distillation of coal tar and as a by-product of coke

ovens, or made synthetically from benzol. It is used for the production of plastics, syntans, dyes, pharmaceuticals, and flavors. Phenol melts at about  $43^{\circ}\text{C}$  and boils at  $183^{\circ}\text{C}$ . The pure grades have melting points of 39, 39.5, and  $40^{\circ}\text{C}$ . The technical grades contain 82 to 84% and 90 to 92% phenol. The crystallization point is given as  $40.41^{\circ}\text{C}$ . The specific gravity is 1.066. It dissolves in most organic solvents. By melting the crystals and adding water, liquid phenol is produced, which remains liquid at ordinary temperatures. Phenol has the unusual property of penetration of living tissues and forms a valuable antiseptic. It is thus used industrially in cutting oils and compounds and in tanneries. Santobrite, of the Monsanto Chemical Co., is chlorinated phenol, or Sodium pentachlorophenol, used as a preservative. Biolite is a formulation of Santobrite used for slime and mildew control in laundries and in paper-pulp manufacture.

**Phenol-formaldehyde resin.** A synthetic resin made by the reaction of phenol and formaldehyde, and employed as a molding material for the making of mechanical and electrical parts. Its high dielectric strength, resistance to acids and alkalies, hardness, and imperviousness to moisture make it suitable for such products as clock cases, electric switch parts, plating barrels, pump vanes, utensil handles, and ornamental parts. The reaction of the chemicals under heat and pressure produces a product physically resembling a resin but chemically dissimilar. This polymerization process is only partly carried out in the original resinoid, so that the material can be mixed with a filler and molded to form before the final set is given by heat and pressure.

The reaction was known as early as 1872 but was not utilized commercially until much later. A condensation product of 50 parts phenol and 30 parts 40% formaldehyde made under English patent of 1905, was called Resinite, and was originally offered as a substitute for celluloid. Various modifications were made by other inventors. Redmanol was one of the first of the American products by the Bakelite Corp. Juvelite was made in Germany by condensing the phenol and formaldehyde with the aid of mineral acids, and Laccain was made under an English patent by using organic acids as catalysts. A Russian phenol resin, under the name of Karbolite, employed an

equal amount of Naphthalene-sulphonic acid,  $C_{10}H_7SO_3H$ , with the formaldehyde.

Phenol-formaldehyde resins are transparent, brittle, soluble in alcohols, but insoluble in water, turpentine, or benzol. They are usually mixed with wood flour or other filler, which makes them less expensive and also more pliable and resistant to fracture. They can be easily dyed to any color, or pigments can be incorporated. The tensile strength of the resinoid is about 7,000 psi, and the specific gravity is 1.27; in the molded product the strength is much higher, depending upon the type and quantity of filler employed. Wood-flour filler material is usually supplied in the form of dry, granular powder for molding. The molded product will not melt at any temperature, but begins to char at about 570°F. It is highly resistant to acids, oils, water, and alkalis. The molding is usually done at 350°F and 2,000 psi pressure.

The molded article takes the high finish of the dies. The specific gravity with wood filler is 1.34 to 1.52, tensile strength 6,000 to 11,000 psi, compressive strength 25,000 to 36,000 psi, and dielectric strength 300 to 500 volts per mil. With mineral fillers the specific gravity is higher, the resistance is greater, the strength is lower. Resinox 6952, of the Monsanto Chemical Co., is a phenolic molding compound with a fine fibrous filler which gives very high impact strength. The molded products have a specific gravity of 1.35, tensile strength of 6,000 to 7,000 psi, and flexural strength 12,000 to 13,000 psi. Resinox 10900 is a mica-filled phenolic molding powder that gives fast cure and produces products of specific gravity 1.71, tensile strength 6,000 psi, flexural strength 9,000 psi, and dielectric strength 450 volts per mil. Moldarta, of the Westinghouse Electric Corp., is a phenol-formaldehyde molding plastic in natural amber, black, or pigmented colors, with cellulose or mineral fillers. For high-impact molded parts, the filler is in macerated or chopped form which gives strength intermediate between the molded and laminated plastics.

Phenol resins may also be cast and then hardened by heating. The cast resins usually have a higher percentage of formaldehyde and do not have fillers. They are poured in sirupy state in lead molds and hardened in a slow oven. Crystallin, of the Crystallin Products Corp., Opalon, of the Monsanto Chemical Co., and Phenalin, of E. I. du Pont de Nemours & Co., Inc., are cast plastics. Catalin, of the

*American Catalin Corp.*, is a cast phenol plastic. *Ivoricast*, of *West Coast Enterprises*, is a shock-resistant cast phenolic plastic with wood flour filler which cures at low heat. *Prystal* is the name of water-clear Catalin, and *Bois glacé* is Catalin-coated wood for desk tops. *Fiberlon* is a cast phenol plastic of the *Fiberloid Corp.* *Marblette* is a cast plastic of the *Marblette Corp.*

Laminated plastics are made with paper, linen, or canvas. The kraft paper usually has a 35% impregnation of the resin. Rag paper, linen, and canvas bases have higher impregnations. Rods are made by machining from the molded sheets, which gives parallel cords, or by winding sheet stock on a wire and molding when the wire is withdrawn. Bakelite laminated has a specific gravity of 1.32 to 1.41, hardness 30 to 40 Brinell, compressive strength 30,000 to 43,000 psi, and dielectric strength 400 to 900 volts per mil. A typical paper-base laminated plastic will have a tensile strength of 12,500 psi, compressive strength 35,000 psi, and dielectric strength 700 volts per mil. A laminated plastic with a fine-weave fabric will have a tensile strength of 9,000 psi, compressive strength 35,000 psi, and dielectric strength 200 to 500. The process of making all the laminated plastics is much the same. The laminations are cut from materials that have been previously impregnated with a resin varnish and dried. The number of laminations is determined by the thickness of the sheet desired. Heat and pressure are applied to the piled-up laminations in the press to complete the chemical reaction and bind the material into a hard, dense, and insoluble solid. Spauldite is a laminated material of the *Spaulding Fibre Co., Inc.* The paper-base materials for insulating purposes are made in sheets down to  $\frac{1}{84}$  in. in thickness. Dilecto is a laminated material of the *Continental-Diamond Fibre Co.* Phenrok is a group of laminated phenolic materials made to Federal specifications. The use of matted cotton fibers instead of fabric gives higher impact strength. Synthane L-RF, of the *Synthane Corp.*, is a laminate of this type in thicknesses of board from  $\frac{1}{32}$  to 2 in.

The materials known as Micarta, of the *Westinghouse Electric Corp.*, used for gears and electrical parts, Textolite, of the *General Electric Co.*, Phenolite, of the *National Vulcanized Fibre Co.*, and Formica, of the *Formica Co.*, are Bakelite laminated, although molders and producers of laminated products do not usually confine them-

selves to one type of resin, and the same trade name may also indicate other synthetic resins. The variegated designs of Micarta and Formica panels are made by placing the design on paper or fabric as the outside lamination. The Farlite of the Farley & Loetsch Mfg. Co. has a thin metal sheet under the decorative design of the outside lamination to dissipate heat and prevent blistering or discoloration from heated articles when used for table or counter tops. Formica is also produced with asbestos paper and cloth bases. Luxwood, of the Formica Co., for furniture making, is  $\frac{1}{16}$ -in. laminated plastic with photographic reproductions of wood grain on the face, while Beautywood is this material in thicker sizes for wall panels. Fabroc is Bakelite combined with asbestos. Tenazit is the name of Textolite material produced in Germany. Celeron is the name of a group of laminated plastics of the Continental-Diamond Fibre Co. Synthane is a laminated plastic of the Synthane Corp. Haveg, of the Haveg Corp., is a phenol resin containing asbestos fibers. It is acid-resistant and heat-resistant to temperatures up to 265°F.

The phenol-formaldehyde resins are sold under many trade names such as Bakelite, of the Bakelite Corp., and Durez, of the General Plastics Corp., and many in turn are marketed under other trade names by the molders. Makalot, of the Makalot Corp., Colasta, of the Colasta Corp., Reynolite, of the Cutler-Hammer, Inc., Indur, of the Reilly Tar & Chemical Corp., are names for molded products, powders, and laminating varnishes. Phenol resins are used in liquid form for cements, waterproof coatings, and as binders for abrasive wheels. For adhesives the resins are plasticized with gums or natural resins and dissolved in a solvent. The formaldehyde may be replaced in some products to make similar molding materials with somewhat different characteristics, such as Phenol-furfural and Phenol-hexamine resins. Acrolite is the trade name of a dark-colored resin made by the action of phenol on glycerol. Rockite is a phenol plastic marketed in powder form by F. A. Hughes & Co., Ltd. Other English phenol resins are Tufnol, of Ellison Insulations, Ltd., Dekorit and Leukorit, of Uhlhorn Bros. Some German molding resins are Futurit, Resistan, Faturan, and Herolith. For use in paints and varnishes, the phenol resins are modified with rosin or ester gum, or with other synthetic resins. Amberol, of the Resinous Products & Chemical Co., is a series of modified resins of this type for varnishes

and printing inks. Paranol, of the Paramet Chemical Co., is a modified resin. The Hycar-phenolic resin of the General Electric Co. is a phenol resin blended with Hycar powder. It makes molded products of great toughness and resiliency. Plio-Tuf, of the Goodyear Tire & Rubber Co., is also a blend of phenol resin with a butadiene-styrene rubber. It molds easily and produces parts of great toughness and low water absorption. It was originally marketed as Tuf-Lite.

**Phonolite.** Also known as Clinkstone. An aluminum-potassium-silicate mineral used in the production of glass, and in Germany for the production of aluminum. Phonolite is a variety of feldspar. It varies greatly in composition, the best of the Eifel Mountains mineral containing 20 to 23% alumina, 7 to 9  $K_2O$ , 6 to 8  $Na_2O$ , and 50 to 52 silica. A variety of this mineral, Nepheline, from the Kola Peninsula, is used in Russia to produce aluminum, with soda and potash as by-products. Nepheline syanite from Peterborough Co., Ontario, Canada, is used in the ceramic industry in pottery, porcelain, and tile to increase translucency and reduce warpage and crazing. From 3 to 5% added to structural clay increases the mechanical strength. As a substitute for potash feldspar in wall tiles, it increases the fluxing action and lowers the fusing point. Agalmatolite, a name derived from the Greek words meaning Image stone, is the massive form of phonolite from which the Chinese carve figures and bas-reliefs. It has a soft greasy feel, and varies in color.

**Phosgene.** The common name for Carbonyl chloride,  $COCl_2$ , a colorless, poisonous gas made by the action of chlorine on carbon monoxide. It was used as a poison war gas, called D-stoff by the Germans and Collongite by the French. But it is also used in the manufacture of metal chlorides and anhydrides, pharmaceuticals, perfumes, and other chemicals. It liquefies at  $8.2^\circ C$ , and solidifies at  $-118^\circ C$ . It is decomposed by water. When chloroform is exposed to light and air, it decomposes into phosgene. One part in 10,000 parts of air is a toxic poison. For chemical warfare it is compressed into a liquid in shells. Lacrimite, also a poison war gas, is thiophosgene mixed with stannic chloride. Diphosgene,  $ClCOOC \cdot Cl_3$ , called Green cross, Superpalite, and Perstoff, is an oily liquid boiling at  $128^\circ C$ . It is an intense lachrymator, has an asphyxiating odor, and is a lung irritant.

**Phosphor bronze.** Originally called Steel bronze when first produced at the Royal Arsenal in Vienna. It was 92-8 bronze deoxidized with phosphorus and cast in an iron mold. It is now any bronze deoxidized by the addition of phosphorus to the molten metal. It may or may not contain residual phosphorus in the final state. Ordinary bronze frequently contains cuprous oxide formed by the oxidation of the copper during fusion. By the addition of phosphorus, which is a powerful reducing agent, a complete reduction of the oxide takes place, and the resulting bronze has higher strength. Phosphor bronze is not usually a special alloy but is a deoxidized bronze, and all grades of bronze can be converted into it. But when there is residual phosphorus in the metal, the bronze is harder. Phosphor-bronze casting metals for bearings usually contain lead. ASTM Grade B phosphor bronze has 4.0 to 5.5% tin, 2.5 to 4 lead, and 0.03 to 0.25 phosphorus. A foundry alloy known as Standard phosphor bronze contains about 80% copper, 10 tin, and 10 lead, with about 0.25 phosphorus. When chill-cast, it is fine-grained and has a tensile strength up to 33,000 psi, Brinell hardness 65, and weight 0.325 lb per cu in. One large automotive company lists this metal as Phosphor casting bronze. The phosphor-bronze ingot metal of this composition marketed by H. Kramer & Co. contains 0.50 to 1% phosphorus, part of which is absorbed in the melting and casting. The residual phosphorus is 0.25%.

Anaconda phosphor bronze, a wrought metal marketed by the American Brass Co., is in grades containing from 5 to 10% tin and 90 to 95 copper. The 90-10 grade for springs has high resistance to fatigue. Seymour phosphor bronze of the Seymour Mfg. Co., used for springs, has 95% copper, 4.75 tin, and 0.25 phosphorus. Carobronze, of the Wrought Bearing Metals, Inc., has 91.2% copper, 8.5 tin, and 0.3 phosphorus. It is produced in hard-drawn tubes and rods to give greater wear resistance and higher impact value than cast bronze for bearings. Corvic bronze, of the Chase Brass & Copper Co., has 98.5% copper, 1.5 tin, and 0.30 phosphorus. The tensile strength of the spring material is 95,000 psi, and the electrical conductivity is 42% that of copper. Telnic bronze of this company contains 1% nickel, 0.20 phosphorus, 0.5 tellurium, and the balance copper. The phosphor bronze marketed by Revere Copper & Brass, Inc., in sheet, plate, and strip, contains 1.25 to 10% tin with not



over 0.05% residual phosphorus. The soft material with hardness to Rockwell B75 has tensile strengths from 40,000 to 73,000 psi, while the hard metal, with Rockwell B hardness from 75 to 104, has tensile strengths from 90,000 to 129,000 psi. Anaconda special phosphor bronze, used for screw-machine parts, contains 88% copper, 4 tin, 4 zinc, and 4 lead. It is free-cutting and has high strength. Hard-drawn phosphor-bronze wire may have a tensile strength exceeding 120,000 psi. White phosphor bronze, for bearings, contains 72% lead, 12 antimony, 15 phosphor tin, and 1 copper.

**Phosphor copper.** An alloy of phosphorus and copper, used instead of pure phosphorus for deoxidizing brass and bronze alloys, and for adding phosphorus in making phosphor bronze. It comes in 5, 10, and 15% grades and is added directly to the molten metal. It serves as a powerful deoxidizer, and the phosphorus also hardens the bronze. Even slight additions of phosphorus to copper or bronze increase the fatigue strength. Phosphor copper is made by forcing cakes of phosphorus into molten copper and holding under until the reaction ceases. Phosphorus is soluble in copper up to 8.27%, forming  $\text{Cu}_3\text{P}$ , which has a melting point of  $707^\circ\text{C}$ . A 10% phosphor copper melts at  $850^\circ\text{C}$ , and a 15% at  $1022^\circ\text{C}$ . Alloys richer than 15% are unstable. Phosphor copper is marketed in notched slabs or in shot. In Germany Phosphor zinc is used as a substitute to conserve copper. Metallophos is a name for German phosphor zinc containing 20 to 30% phosphorus. The name phosphor copper is also applied to commercial copper deoxidized with phosphorus and retaining up to 0.50% phosphorus. The electrical conductivity is reduced about 30%, but the copper is hardened and strengthened. Phosphor tin is a master alloy of tin and phosphorus used for adding to molten bronze in the making of phosphor bronze. It usually contains up to 5% phosphorus and should not contain lead. It has an appearance like antimony, with large glittering crystals, and is marketed in slabs. Federal specifications call for 3.5% phosphorus, with not over 0.50% impurities.

**Phosphoric acid.** Also known as Orthophosphoric acid. A colorless, sirupy liquid of the composition  $\text{H}_3\text{PO}_4$  used for pickling and rustproofing metals, for the manufacture of phosphates, pyrotechnics, and fertilizers, as a latex coagulant, as a textile mordant, as an acidu-

lating agent in jellies and beverages, and as a clarifying agent in sugar sirup. The specific gravity is 1.834, melting point  $42.35^{\circ}\text{C}$ , and it is soluble in water. The usual grades are 90, 85, 75%, technical 50%, and dilute 10%. Nielite D, of Nielco Laboratories, is phosphoric acid with a rust inhibitor, used as a nonfuming pickling acid for steel.

**Phosphorus.** A nonmetallic element, symbol P, widely diffused in nature, and found in many rock materials, in ores, in the soil, and in parts of animal organisms. Commercial phosphorus is obtained from phosphate rock by reduction in the electric furnace with carbon, or from bones by burning and treating with sulphuric acid. Phosphate rock occurs in the form of land pebbles and as hard rock. It is plentiful in the Bone Valley area of Florida, and also comes from Tennessee and some other states. Vast quantities are mined in French Morocco and Tunisia. Large deposits are found on many of the Pacific Islands, the Christmas Island resources being estimated at 30 million tons and those on Nauru at 100 million tons. It is a calcium phosphate high in  $\text{P}_2\text{O}_5$ . The mineral Apatite, from Virginia, Brazil, and French Oceania, is also a source of phosphorus, containing up to 20%  $\text{P}_2\text{O}_5$ , with iron oxide and lime. The Egyptian rock contains 62 to 70% tricalcium phosphate. The Superphosphate used for fertilizers is made by treating phosphate minerals with concentrated sulphuric acid. It is not a simple compound, but may be a mixture of Calcium acid phosphate,  $\text{CaHPO}_4$ , and calcium sulphate. Natural rock phosphate in finely ground form is also used as a fertilizer for legume crops.

Phosphorus is important in foundry work because of its property of combining and greatly modifying the characteristics of metals, and because of its deoxidizing power, especially in nonferrous metals. It is added to the latter in the form of phosphor copper or phosphor tin. Small amounts in steel increase the strength and resistance to corrosion and also decrease the tendency of steel sheets to stick together. But larger amounts promote cold-shortness in the steel.

There are two forms of phosphorus, yellow and red. The former, also called White phosphorus,  $\text{P}_4$ , is a light-yellow waxlike solid, phosphorescent in the dark and exceedingly poisonous. Its specific gravity is 1.83 and it melts at  $44^{\circ}\text{C}$ . It is used for smoke screens in

warfare and for rat poisons and matches. Yellow phosphorus is produced directly from phosphate rock in the electric furnace. It is cast in cakes of 1 to 3 lb each. Red phosphorus is a reddish-brown amorphous powder, having a specific gravity of 2.296 and a melting point of 725°C. Red phosphorus is made by holding white phosphorus at its boiling point for several hours in a reaction vessel. Both forms ignite easily. Phosphorus sulphide,  $P_4S_3$ , may be used instead of white phosphorus in making matches. Phosphoric oxide,  $P_2O_5$ , is used as an opalizer in glass. Phosphorus is an essential element in the human body, a normal adult person having about 1.4 lb of it in the system. Flour and other foodstuffs are fortified with Ferric phosphate,  $FePO_4 \cdot 2H_2O$ . Tricalcium phosphate,  $Ca_3(PO_4)_2$ , is used as an anticaking agent in salt, sugar, and other food products and to provide a source of phosphorus.

**Phthalic anhydride.** A white, crystalline material of the composition  $C_6H_4(CO)_2O$ , with a melting point of 130.8°C, soluble in water and in alcohol. It is made by oxidizing naphthalene, or it is produced from orthoxylene derived from petroleum. It is used in the manufacture of alkyd resins, for the production of dibutyl phthalate and other plasticizers, dyes, and many chemicals. Chlorinated phthalic anhydride is also used as a compounding medium in plastics. It is a white, odorless, nonhygroscopic stable powder containing 50% chlorine. It gives higher temperature resistance and increased stability to plastics. Niagathal is a chlorinated phthalic anhydride of the Niagara Alkali Co. Maleic anhydride,  $(CHCO)_2O$ , is a white crystalline solid used to replace phthalic anhydride in alkyd resins to increase the hardness for baking enamels and to resist yellowing. Azelaic acid is a strong organic acid,  $COOH(CH_2)_7COOH$ , used as a substitute for phthalic anhydride to react with glycerin to form alkyd resins less hard and brittle than those made with phthalic anhydride. It melts at 96°C, and is soluble in hot water.

**Piassava.** Also called Para grass and Monkey grass. A coarse, stiff, and elastic fiber obtained from a species of palm tree, *Leopoldinia piassaba*, of Brazil, used for making brushes and brooms. The plant has long beards of bristlelike fibers, which are combed out and cut off the young plants. These fibers sometimes reach a length of 4 ft. The long, finer fibers are made into cordage, and the coarser ones are

used for brushes. Piassava is very resistant to water. The fiber for brush manufacture is separated into three classes: the heavy fibers being known as Bass, the medium as Bassine, and the fine as Palmyra. The bass is used for heavy floor sweeps. The fiber of the palm *Attalea funifera* which grows in the state of Bahia, Brazil, and is also called piassava, is a harder and stronger material than the piassava of Amazonas. It is used for marine cordage, and is resistant to salt water. A substitute for piassava is Acury, from the leaves of the palm *A. phalerata* of Matto Grosso. It is used for cordage and brushes, and the coarser fibers are used for brooms.

**Pickling acids.** Acids used for pickling, or cleaning castings or metal articles. The common pickling bath for iron and steel is composed of a solution of sulphuric acid and water, 1 part acid to from 5 to 10 parts water being used. This acid attacks the metal and cleans it of the oxides and sand by loosening them. For pickling scale from stainless steels a 25% cold solution of hydrochloric or sulphuric acid is used, or hydrofluoric acid with the addition of anhydrous ferric sulphate is used. Hydrofluoric acid solutions are sometimes used for pickling iron castings. This acid attacks and dissolves away the sand itself. For bright-cleaning brass a mixture of sulphuric acid and nitric acid is used. For a matte finish the mixed acid is used with a small amount of zinc sulphate. Copper and copper alloys can be pickled with sulphuric acid to which anhydrous ferric sulphate is added to speed the action, or sodium bichromate is added to the sulphuric acid to remove red cuprous oxide stains. Brass forgings are pickled in nitric acid to bring out the color. Since all of these acids form salts rapidly by the chemical action with the metal, they must be renewed with frequent additions of fresh acid. The French pickling solution known as Framanol, used for aluminum, is a mixture of chromium phosphate and triethanolamine. The latter emulsifies the grease and oil, and the aluminum oxide film is dissolved by the phosphoric acid, leaving the cleaned metal with a thin film of chromic oxide.

The temperature of most pickling solutions is from 140 to 180°F. An increase of 20°F will double the rate of pickling. Acid brittleness after pickling is due to the absorption of hydrogen when the acid acts on iron, and is reduced by shortening the pickling time. In-

hibitors are chemicals added to reduce the time of pickling by permitting higher temperatures and stronger solutions without hydrogen absorption. Hibitite, of the Monsanto Chemical Co., is a brown liquid of the composition  $C_{27}H_{45}NO_{10}S_2$ , used as a metal pickling inhibitor. Pennsalt FA-42, of the Pennsylvania Salt Mfg. Co., is a 42% solution of Fluoboric acid,  $HF_4$ , used for pickling and also to control the acidity of plating baths. It is a colorless liquid with a specific gravity of 1.33. Phosphoric acid is employed in hot solution as a dip bath for steel parts to be finished to a rough or etched surface. A basic iron phosphate coating is produced on the steel, which is resistant to corrosion and gives a rough base for the finish. Coslettised steel is steel rust-proofed by dipping in a hot solution of iron phosphate and phosphoric acid. Parkerized steel is rustproofed steel treated in a bath of iron and manganese phosphates. Bonderized steel is steel treated with phosphoric acid and a catalyst to give a rough, tough, rust-resistant base for paints. Granodized steel is produced with zinc phosphate.

**Pig iron.** The iron produced from the first smelting of the ore. The melt of the blast furnace is run off into rectangular molds, forming, when cold, ingots called pigs. Pig iron contains small percentages of silicon, sulphur, manganese, and phosphorus, besides carbon. It is useful only for resmelting to make cast iron or wrought iron. Pig iron is either sand-cast or machine-cast. The former has sand adhering and fused into the surface, giving more slag in the melting. Machine cast is cast in steel forms, has a fine-grained chilled structure, with lower melting point. Pig irons are classified as Bessemer or nonbessemer, according to whether the phosphorus content is below or above 0.10%. There are six general grades of pig iron: Low phosphorus, with less than 0.03%, used for making steel for steel castings and for crucible steel making; bessemer, with less than 0.10% phosphorus, used for bessemer steel and for acid open-hearth steel; Malleable, with less than 0.20%, used for making malleable iron; Foundry, with from 0.5 to 1%, for cast iron; Basic, with less than 1%, and low silicon, less than 1%, for basic open-hearth steel; and basic bessemer, with from 2 to 3%, used for making steel by the basic bessemer process employed in England.

About two-thirds of all pig iron produced in the United States is

basic. Since silicon is likely to dissolve the basic furnace lining, it is kept as low as possible, 0.70 to 0.90%, with sulphur not usually over 0.095%. Pig irons are also specified on the content of other elements, especially sulphur. The sulphur may be from 0.04 to 0.10%, but high-sulphur pig iron cannot be used for the best castings. The manganese content is usually from 0.60 to 1%. Most of the iron for steelmaking is now not cast but is carried directly to the steel mill in car ladles. It is called Direct metal. Pig-iron production in the United States is normally about 73% of the production of steel ingots, but may increase to 80% when less scrap is used. Coke consumption is normally about 250 lb per ton of pig iron produced, but is reduced to about 200 lb when a high top-pressure blast furnace is employed. Foundry pig iron is graded by the silicon content, No. 1 having from 2.5 to 3%, and No. 3 from 1.5 to 2% silicon. Silvery iron is a name for pig iron of high silicon content because of its silvery fracture. Puddling iron is a grade of pig iron used for making wrought or puddled iron in a puddling furnace. A requirement is that the silicon be low, with manganese 0.5 to 1%.

Chateaugay iron is a low-phosphorus pig iron produced from New York state magnetite ore. The original ore as mined contains about 28% iron. The standard analysis of the pig iron is total carbon 4%, silicon 0.75 to 4.0, sulphur 0.03 max, phosphorus 0.03 max, manganese 0.10 to 0.15. Chateaugay iron is used for casting rolls, gears, and machine parts. Norskalloy is a name for pig iron produced from Norwegian ores containing vanadium and titanium. The standard grade contains from 4 to 4.5% total carbon, 0.5 to 1.5 silicon, 0.20 manganese, 0.20 to 0.25 phosphorus, 0.30 to 0.40 vanadium, and 0.40 to 0.80 titanium. From 15 to 20% Norskalloy pig is added to mixtures where vanadium is required. Mayari iron is pig iron made from Cuban ores which contain vanadium and titanium, or is pig iron made to duplicate the Cuban iron. These irons are considered especially suitable for heavy rolls or high-grade castings. Mayari pig, as marketed by the Bethlehem Steel Co., contains 1.60 to 2.50% chromium, 0.80 to 1.25 nickel, 0.25 to 2.25 silicon, 0.10 to 0.20 titanium, 0.05 to 0.08 vanadium, 3.8 to 4.5 total carbon, 0.60 to 2 manganese, under 0.05 sulphur, and under 0.10 phosphorus. Nikrofer is a name used in Germany for pig iron from Greek ore that is similar in composition.

**Pigment.** A substance, usually earthy or clayey, which when mixed with oil or other solvent forms a paint. Pigments usually give body as well as color to the paint. The hiding power is measured by comparison tests when in the form of a mixed paint. If the hiding power of lithopone is taken as 100, the hiding power of zinc sulphide is 240, and that of titanium dioxide is 400. A pigment is distinct from a filler in that it must retain its opacity when wet. White powdered quartz, used sometimes as a filler, is not a good pigment as it becomes glassy when wet. Fillers that retain their opacity are called Extenders, or Auxiliary pigments, and the final mixed pigment is called a Reduced color. But an extender pigment such as silica, that does not have good hiding power in itself, will increase the hiding power and depth of color of a pigment if the extender is of such fine particle size that it will be dispersed in the voids between the pigment particles. Extremely fine silica will also cement itself chemically to lead pigments and add wearing qualities. The Hi-Sil of the Pittsburgh Plate Glass Co. is a silica with a particle size of 0.025 micron. As a pigment for rubber, it adds strength and wear resistance to the rubber.

Pigments are mostly of mineral origin, the vegetable pigments such as logwood, and the animal pigments such as cochineal, being ordinarily classified as dyestuffs. Bone black, however, is an example of an animal pigment, and vine black is a typical vegetable pigment. Pigments are also produced by dyeing clays with aniline dyestuffs. These are called Lakes. Dutch yellow, for example, is a Yellow lake made by adsorption of a yellow dye such as quercitron by an inert material such as calcium carbonate. Various chemicals such as copper acetate and potassium acetate are used as pigments. Potassium acetate,  $\text{CH}_3\text{COOK}$ , is a white powder also used in making crystal glass. Pigments should be ground fine enough so that all of the powder will pass through a 325-mesh screen.

Natural pigments include ochre, umber, ground shale, hematite, and sienna. The red-ochre pigments are the natural red iron oxides of high oxide content. The yellows, or siennas, are the oxides mixed with considerable clay. The browns, or umbers, have manganese present in the clays. Terre verte, or Verona green, of Cyprus, is a fine blue-green earth valued highly in the Middle Ages as a pigment. It contains 53% silica, 26 ferric oxide, 16 potash, and some magnesia,

manganese, and other metals. Manganese green, or Cassel's green, is Barium manganate,  $\text{BaMnO}_4$ , a green poisonous powder of specific gravity 4.85, insoluble in water. Mineral green, or Scheele's green, is Copper arsenite,  $\text{CuHAsO}_3$ . It is a light-green amorphous powder used in paints and in textile printing. It is also used in medicine. Orange pigments, from yellow to brilliant red, with high tinting strength and great fastness, are made with mixtures of Lead chromate,  $\text{PbCrO}_4$ , Lead molybdate,  $\text{PbMoO}_4$ , and Lead sulphate,  $\text{PbSO}_4$ . Gloss white, used as a reduced-color white pigment, and for surface-coating pulp papers and in printing inks, is a coprecipitation product consisting of 75% blanc fixe and 25 aluminum hydrate.

The most important yellow is Chrome yellow, but it fades easily. Yellow ochre is inferior as a color but is more durable. Cadmium yellow is permanent and brilliant but expensive. It is Cadmium sulphide,  $\text{CdS}$ , used for either oil or water paints. The yellow pigment called Mosaic gold, or Artificial gold, is Stannic sulphide,  $\text{SnS}_2$ , used in gilding and bronzing paints. Stannous sulphide,  $\text{SnS}$ , used for incorporation in bearings, is a black crystalline material melting at  $880^\circ\text{C}$ . Cadmium red and Cadmium orange are produced by calcining selenium with cadmium sulphide. These cadmium sulphoselenide pigments give brilliant colors. Cadmium pigments are used in Camouflage paints to give greater reflection of infrared rays. A building painted with a green containing cadmium has the same reflection as grass or leaves, and is indistinguishable in aerial photographs. An ancient lemon-brown pigment is Bistre. It was obtained from the collected chimney soot of wood fires, and was much used by the old masters. It is very durable in water colors. The most important green is Chrome green, which is chrome yellow mixed with Prussian blue. The latter is ferrocyanide of iron, giving a good color but not permanence. Ultramarine is the most important blue. Cobalt blue is a good color but is expensive. Vermilion is mercury sulphide, which gives a fine color and is permanent, but it is expensive. High-grade blacks are usually lampblack, bone black, and ivory black, but may be extended with graphite. Spanish black is a name used in old texts for the black pigment made by burning cork. It is light and of soft texture. Mineral black, or Slate black, is made by grinding black slate. Metronite is a white mineral composed of mag-



nesium and calcium carbonates and magnesium silicate, used as a paint filler and extender. The pigment known as Plessy's green is Chromium phosphate,  $\text{CrPO}_4$ , a bluish-green powder insoluble in water.

A reactive Fungicidal pigment used in ship paints and antifouling paints is Cupric oxide hydrated, a fine dark-brown powder of the composition  $4\text{CuO} \cdot \text{H}_2\text{O}$ . A yellow pigment used in anticorrosive and blister-resistant metal primers is Zinc tetroxy chromate,  $4\text{Zn}(\text{OH})_2 \cdot \text{ZnCrO}_4$ . Pearl essence, used in lacquers, in synthetic molding materials, and for making Imitation pearls is a motley-silver substance extracted from the scales of many species of fish, notably the herring. It gives high luminosity and iridescence to lacquers. Synthetic pearl essence, for the same uses, is a dispersion of minute particles of nacreous shells in a vehicle. H-scale, of the Celanese Corp. of America, is a synthetic pearl essence. Metallic pigments are most frequently bronze powder or aluminum powder. They are used to increase light reflectivity as well as for appearance. Stainless-steel flake for pigment is marketed by Charles Hardy, Inc., as a fine powder in a paste with stearic acid and a solvent. Added to a clear lacquer or varnish it gives a hard silvery coating resistant to corrosive fumes. Vinylum, of the Argus Chemical Laboratory, is aluminum powder in a vinyl copolymer. It disperses readily in vinyl compounds to give iridescent effects in the molded products.

**Pine.** The wood of coniferous trees of the genus *Pinus*, of which there are 37 species in the United States. The White pine, or Northern white pine, *P. strobus*, grows widely in Canada and in the northeastern United States. The trees are 80 to 100 ft high, with trunks 3 to 9 ft in diameter, reaching full size in 80 years. The wood is soft, straight-grained, and free from rosin. The heartwood is light brown, and the sapwood white. It is the chief wood for pattern-making and is also extensively used for cabinetwork and general carpentry. Cork pine is a name for the clear, soft, white pieces used for patterns. Yellow pine is a name for the wood of the Longleaf, or Longstraw pine tree, *P. palustris*, of the southeastern states, and Shortleaf pine, *P. echinata*, of the southeast and middle western states, also called North Carolina pine and Rosemary pine. The leaves, called needles or straws, of the longleaf pine are up to 18 in.

in length. The Longleaf pine tree furnishes the best grades of yellow pine and also is the chief source of turpentine. It is also called Georgia pine, Southern pine, Hard pine, and Hill pine.

Slash pine, also known as Cuban pine and Swamp pine, from the tree *P. caribaea*, Caribbean pine, growing along the southern coasts of the United States and the Caribbean countries, is also a yellow pine. It is one of the most rapidly growing forest trees in the United States and produces one of the heaviest, hardest, and strongest of all the conifer or softwoods. In Central America it is called Ocoté. Slash pine is next to longleaf pine as a source of turpentine and rosin. As heartwood does not develop until the tree is 20 or more years old, slash pine forms a valuable source of paper pulp. The term Arkansas pine in the lumber trade includes mixtures of shortleaf, longleaf, slash, loblolly, and pond pines. Lodgepole pine, *P. contorta*, is from a small slow-growing tree of western United States, Canada, and Alaska. It is also called Knotty pine, Scrub pine, and Jack pine. The wood is moderately lightweight, light yellow to brown in color, with a narrow white sapwood. It is straight-grained with resin ducts, and has large shrinkage. It is used for poles, ties, mine timbers, and rough construction. Also known as Jack pine is the medium-size tree *P. banksiana* of central Canada, which is used for creosoted telephone poles. Spruce pine, or Cedar pine, is a large tree, *P. glabra*, growing in a narrow area from southern Louisiana to Florida.

Ponderosa pine, also called Western yellow pine, Western white pine, and Oregon white pine, is from the tree *P. ponderosa*. The tree grows to a height of 175 ft and a diameter of 6 ft. It grows throughout the Mountain states from Mexico to Canada, and is also a source of turpentine and rosin. A similar western pine, Jeffrey pine, *P. jeffreyi*, contains Heptane instead of turpentine in the oleoresin, and is a more economic source of this material than petroleum. The lumber is usually mixed with ponderosa pine and sold as such. It is a moderately soft and lightweight wood with the heartwood light reddish brown, and quite similar to yellow pine. Loblolly pine, *P. taeda*, is called North Carolina pine, Oldfield pine, and Sap pine. It grows from Virginia to northern Florida and to Texas; it is adapted to extensive areas and is easily propagated, receiving the name of Field pine. It is a type of shortleaf pine distinguished by three leaves or

straws in each cluster, rough bark, and small prickly burrs. It grows to a diameter of 12 in. in 12 years. Pitch pine is the Pond pine, *P. rigida*, of the southern states, but all yellow pines are called pitch pine in the export trade. Norway pine, of the north central states, is *P. resinosa*. The yellow pines are harder and more difficult to work than white pine. They are resinous and more durable. They also take a better polish and show a more figured grain. They are valued for flooring and for general construction. White pine has a specific gravity, kiln-dried, of 0.38, and compressive strength perpendicular to the grain of 780 psi; Western white pine, *P. monticola*, has a specific gravity of 0.42 and a compressive strength of 750 psi. Deal is a European name for the wood of the tree *P. sylvestris*, also known as Danzig pine, Baltic pine, Scotch fir, Scotch pine, and Northern pine. It is popularly called Scots pine in England, and is one of the most plentiful of the European conifers, especially in Norway, Sweden, and Finland. It gives a straight pole, up to 70 ft long, valued for telegraph poles.

Paraná pine is a soft, yellowish-white wood with rose veins from the tree *Araucaria brasiliensis* of southern Brazil. In Argentina it competes with American softwoods and is called Brazilian pine and Araucanian pine. The specific gravity is 0.865. The tree is very tall, with branches only at the top. Other species of Araucanian pine, or Antarctic pine, grow in southern Chile and Argentina. Araucaria oil is distilled from the wood. It is a viscous reddish oil of roselike odor containing a high percentage of eudeomol and some geraniol. It has a more durable scent than guaiac wood oil for soaps.

The araucanian pines of New Guinea, *A. khinkii* and *A. cunninghamia*, are called Hoop pine. New Caledonia pine is from the tree *A. cooki*, growing to a height of 200 ft with no lower branches. White pine of New Zealand is from the very large tree *Podocarpus dacrydioides*, called also Kahikatea. The sapwood is white, and the small heartwood is yellow. The wood is straight-grained, inodorous, easily worked, but not durable. It weighs 29 lb per cu ft. It is used for boxes, crates, and packing. Another species, from the tree *P. ferrugineus*, called Miro, is brownish in color, fine-grained, easily worked, and has high strength. The trees average 65 ft in height and 20 in. in diameter. The New Zealand species known as Black pine, or Matai, is from the *P. spicatus*. The wood is yellowish-brown,

straight-grained, and weighs 38 lb per cu ft. Red pine, or Rimu, is the chief timber of New Zealand, used for furniture, millwork, and kraft pulp. The tree *Dacrydium cupressinum* averages 100 ft in height and 30 in. in diameter. The wood is reddish brown with streaks, straight-grained, easily worked, and weighs 37 lb per cu ft. Silver pine, Pink pine, and Yellow silver pine of New Zealand are from several other species of *Dacrydium* obtained only in limited amounts. The name silver is applied to the shiny white woods, and the darker and mottled woods are called pink. They are very durable cypresslike woods. Mercus pine is the wood of the tropical pine tree, *Pinus merkusii*, of the East Indies, India, and the Philippines. It is called Tinyu pine in India and Mindoro pine in the Philippines. The wood is used in general construction. The tree yields a superior type of turpentine.

**Pine oil.** An oil obtained from the wood of the *Pinus palustris*, or longleaf pine, in the steam extraction of wood turpentine. It is used as a cold solvent for varnish gums and for nitrocellulose lacquers. In paints and varnishes it aids dispersion of metallic pigments and improves the flow. It is also used in metal polishes and in liquid and powder scrubbing soaps, as the oil is a powerful solvent of dirt and grease. When free from water, pine oil has a yellowish color but is water-white when it contains dissolved water. It has an aromatic characteristic odor, and is distinct from the pine oils distilled from pine leaves and needles and used in medicine. The distillate of the gum of the Jeffrey and Digger pines of California, called Abietine in medicine, contains 96% heptane and is used as a cleaning agent and insecticide, and as a constituent of standard gasolines for measuring detonation of engines. Pine oil is obtained mainly from old trunks and branches, and is a product formed by hydrolysis. Pine-oil disinfectants are made with steam-distilled pine oil. Yarmor is a refined pine oil of the Hercules Powder Co. used to increase the detergency of soaps, for dyes, and as a solvent for oils and greases. Hercosol is a solvent made from pine oil by the same company. Synthetic pine oil made from gum turpentine by this company has a mild pine odor, a specific gravity of 0.9186, and flash point of 154°F. It is technically the same as the natural and has the same uses. Pine-root oil was produced in Japan on a large scale for the manufacture

of fuel oils. The terpenes of the pine oil are converted to aromatic and hydroaromatic compounds by catalytic reaction. The edible Pine kernels of Europe are the seeds from the large cones of the *P. pinea* of southern Europe and Cyprus. Pine-needle oil is distilled from the Siberian fir tree, *Abies sibirica*, of northeastern Russia. It is also known as Siberian pine oil. It contains a high percentage of Bornyl acetate and is used in soaps and perfumes.

**Plane wood.** The wood of the plane tree, *Platanus orientalis*, native to Europe, and *P. occidentalis*, of North America. The latter species is also called Buttonwood and Buttonball. It is a yellowish, compact wood with a fine, open grain. The weight is about 40 lb per cu ft. It resembles maple and gives a beautiful grain when quartered. It is employed in cabinetwork.

**Plastic bronze.** A name applied by makers of bearing bronzes to copper alloys that are sufficiently plastic to assume the shape of the shaft and make a good bearing by running in. These bronzes have a variety of compositions, but the plasticity is always obtained by the addition of lead, which in turn weakens the bearing. In some cases the lead content is so high, and the tin content so low, that the alloy is not a bronze. These copper-lead alloys are referred to as Red metals. The Plastic bronze ingot marketed by one large foundry for journal bearings contains 65 to 75% copper, 5 to 7 tin, and the balance lead. Semiplastic bronze usually contains above 75% copper and not more than 15 lead. ASTM alloy No. 7 has about 10% lead, 10 tin, 1 zinc, 1 antimony, and 78 copper. The compressive strength is 12,500 psi.

**Plastic wood.** Wood cellulose dissolved in ether or other solvent, used for filling or for building up small sections. It hardens on evaporation of the solvent and can be cut, polished, and painted, but has the disadvantage that it shrinks on setting. It may also consist of cellulose nitrate and a plasticizing agent dissolved in acetone or ethyl acetate and mixed with wood flour. One commercial plastic wood is a mixture of a solution of polyvinyl acetate and wood flour. Plastipaste, of the Duorite Plastic Industries, has a binder of phenolic resin and an accelerator which cures the material in a short time. The cured material is light in weight, with specific gravity of 1.05, and

has a compressive strength of 12,000 psi and flexural strength of 3,000 psi. It machines like wood, and gives a smooth finish. The fillers with plastic binders do not shrink greatly.

**Plate glass.** Any glass that has been cast or rolled into a sheet, and then ground and polished. But the good grades of plate glass are, next to optical glass, the most carefully prepared and the most perfect of all the commercial glasses. It generally contains slightly less calcium oxide and slightly more sodium oxide than window glass, and small quantities of iron and aluminum oxides may also be present as impurities. The glass is melted in open pots. The melting and refining take about 20 hr, and the glass is then poured on the casting table at 1000°C. The roller is drawn over the plastic glass. After annealing, the sheets are set in plaster of paris on a circular rotating table and ground with iron blocks and sand. Plate glass is now made on a large scale on continuous machines. Herculite is a glass of the Pittsburgh Plate Glass Co. which will withstand temperatures up to 650°F without cracking. Carrara Structural glass of this company is made like plate glass and ground to true plane surfaces. It is made in many colors in thicknesses from  $1\frac{1}{32}$  to  $1\frac{1}{2}$  in., or laminated to give various color effects. It is used for store fronts, counter tops, tiling and paneling. The weight of the  $1\frac{1}{32}$  in. is 4.5 lb per sq ft. It does not craze, check, or stain like tile.

**Platinum.** A whitish-gray metal, symbol Pt. It is more ductile than silver, gold, or copper, and is heavier than gold. The melting point is 3190°F, and the specific gravity is 21.40. The hardness of the annealed metal is 47 Brinell and tensile strength 42,000 psi; when hard-rolled the Brinell hardness is 90 and tensile strength 54,000 psi. It is very ductile and malleable. It resists the action of alkalies and most acids, dissolving only in hot aqua regia. Platinum occurs native in small flat grains or pebbles, usually alloyed with iridium, rhodium, palladium, osmium, and ruthenium. The largest nugget ever found came from South America and weighed 2 lb. It is also found in the mineral sperrylite. The chief sources are Russia and Colombia, with smaller amounts from Alaska, Canada, and South Africa. It is also obtained from the copper-nickel ores of Canada and South Africa. The Russian platinum is refined 99.80 to 99.90% pure, with 0.05 to 0.10% iridium. The rare mineral sperrylite is found

in Wyoming and in Ontario, Canada. It is a Platinum arsenide,  $\text{PtAs}_2$ , found in small grains of a tin-white, metallic luster.

Platinum is employed for electric contact points for currents less than 4 amp, for resistance wires, thermocouple wires, standard weights, and vessels for laboratory use. It is also used in jewelry. It is too soft for use alone, however, and is almost always alloyed with harder metals of the same group, such as iridium and osmium. An important use of the metal is in the form of gauze as a catalyst in chemical reactions, usually alloyed with 10% rhodium, but for this purpose vanadium and rhodium can be substituted. For fine electrical-resistance wires platinum powder is sintered and then subjected to severe cold drawing to obtain a fibrous structure. Platinum is sold by the troy ounce, 1 cu in. of the metal weighing 11.28 troy oz.

**Platinum-iridium alloys.** The most widely used of the platinum alloys. They are employed for instruments, magneto contacts, and jewelry. The alloys are hard and tough and are noncorrosive. An alloy of 5% iridium and 95 platinum, when hard-worked, has a Brinell hardness 170; an alloy containing 30% iridium has a hardness 400. The 5 and 10% alloys are used for jewelry manufacture; the 25 and 30% alloys are employed for making surgical instruments. An alloy of 80% platinum and 20 iridium is used for magneto contact points, and the 90-10 alloy is widely used for electrical contacts in industrial control devices. The addition of iridium does not alter the color of the platinum. The 5% alloy dissolves readily in aqua regia; the 30% alloy dissolves slowly.

**Plush.** A general name for fabrics woven of cotton, silk, linen, or wool, having a pile deeper than that of velvet. It is used for upholstery. Originally the pile of plush consisted of mohair or worsted yarns, but there is now no distinction except in the length of the pile. Upholstery plush is made in brocade designs by burning the pile with rollers to form a lower background. Plush is also dyed and curled to imitate furs.

**Plywood.** A laminated wood made up of one or more sheets of softwood with thin sheets of more expensive hardwood glued on the outside. The outside sheets are known as Veneer, but this term is applied also to very thin wood sheets for other purposes. Lami-

nated woods were originally developed to increase artistic appeal of furniture by gluing figured woods to ordinary woods with the veneers matched to give artistic effects. Plywood is always built up in odd numbers of layers, and the grains of successive layers are set at right angles. This arrangement gives tensile and compressive strength in all directions and also symmetrical shrinkage stresses. The strength depends largely on the glue. The cheaper types of plywood are bonded with tapioca paste or with casein glue. A blood-albumin glue gives a strength of 370 psi. Plywood bonded with synthetic plastics is strong and waterproof, and some of these have strength-weight factors higher than alloy steels. They are used for aircraft panels, car siding, portable houses, and general construction. Wherever high strength and water resistance are needed the plastic-bonded plywoods have replaced the glue-bonded materials. The plastic-bonded plywoods, in which the plastic is used only to bond the layers, are not classed with the hard boards and sheets in which the laminations of wood are impregnated with resin and the whole cured into a solid sheet. These latter are classed with the laminated plastics.

Compreg, developed by the Forest Products Laboratory, consists of many layers of  $\frac{1}{16}$ -in., rotary cut, yellow-birch plies bonded with about 30% resin under a pressure of 600 to 1,500 psi. The specific gravity is 1.22 to 1.37, and the tensile strength 43,000 to 54,000 psi, depending upon the resin and the molding pressure. Pregwood, of the Formica Insulation Co., is a wood laminate, impregnated with phenolic resin and cured into a hard sheet. But the Impreg weldwood, of the United States Plywood Corp., has the wood plies impregnated only to a short depth before compressing so that it remains a true plywood. It has higher strength and is more resistant than an ordinary resin-bonded plywood. The lightweight plywood Fybr-Tech, of the Technical Plywoods, used for aircraft cabin paneling, consists of  $\frac{1}{16}$ -in. walnut veneer on a  $\frac{1}{4}$ -in. balsa-wood core with a 0.005-in. vulcanized fiber back, bonded with phenolic resin. The weight is 0.2 lb per sq ft.

For construction purposes, where plywood is employed because of its unit strength and nonwarping characteristics, the plies may be of a single type of wood without a hardwood face. The Douglas Fir Plywood Association sets up four classes of construction plywood under general trade names. Plywall is plywood in wallboard grade;



Plypanel is plywood in three standard grades for general uses; Plyscord is unsanded plywood with defects plugged and patched on one side; Plyform is plywood in a grade for use in concrete forms. Etch wood, of the Davidson Plywood & Lumber Co., is plywood paneling with the face wire brushed to remove the softwood and leave the hard grain in raised relief for two-tone finish.

Plywood may have one thick board of cheap wood and two of hardwood, or it may have a large number of thin layers. Basswood, yellow poplar, Spanish cedar, fir, and pine are used for cores. Ash, mahogany, walnut, or any of the expensive woods are used for the outside sheets. The tensile strength of a commercial white ash 3-ply plywood parallel to the grain of the faces is about 6,200 psi, that of a mahogany 6,400 psi, and a walnut plywood 8,200 psi. Mahogany plywood comes in large sheets with thickness of  $\frac{1}{16}$  to  $\frac{1}{4}$  in. Armorply is a plywood marketed by the United States Plywood Corp. Flexwood, of this company, consists of very thin sheets of veneer glued under heat and pressure to cotton sheeting, used as an ornamental covering for walls. Protekwood, of the same company, is a plywood designed for protection against gnawing by rats. It consists of a sheet of hardwood veneer between two sheets impregnated with asphalt and resin, the sheets being bonded with urea-formaldehyde resin. Total thickness is  $\frac{5}{32}$  in. Woven veneer is a paneling made in thin strips of mahogany or other fine wood woven in patterns and pressed between sheets of transparent cellulose acetate. Parkwood, of the Parkwood Corp., is a veneer of this type. Algonite, of the United States Plywood Corp., Inc., is Masonite faced with fancy veneers. Randalite, of the same company, is a birch veneer bonded to a kraft liner. Dec-O-Ply, of the Aetna Plywood & Veneer Co., is a paneling plywood with an embossed surface imitating leather. The K-Veneer used during the war as a lower cost substitute for plywood, was a  $\frac{3}{16}$ -in. fir or hemlock veneer bonded to heavy kraft paper. Welch-board, of the West Coast Plywood Co., is a  $\frac{3}{8}$ -in. plywood on which a smooth surface resembling wood but without grain is produced by curing on one side under heat and pressure a mixture of macerated wood pulp and synthetic resin.

Plywood, or Paneling board, may also be made with metal or fabric plies. Plymax is an English plywood produced by Venesta, Ltd., consisting of thin sheets of aluminum mounted on a plywood backing.

**Plymetl**, of the Haskelite Mfg. Corp., consists of a core of laminated wood with galvanized steel faces cemented to it. **Aluminum-Plymetl** has aluminum facings on Haskelite plywood. The metal-faced plywoods are strong and can be riveted. **Met-L-Wood**, of the Met-L-Wood Corp., is made of two layers of light wood separated by sheet metal, with a fabric cemented to one side. It is used for automobile and truck sides, and has high strength in proportion to weight. **Metalite**, developed by the United Aircraft Corp., has thin sheets of aluminum alloy bonded to both sides of a balsa-wood core, the grain of the wood being perpendicular to the metal faces. Plywood in block form is sometimes used for making rolls, gears, die blocks, and pulleys. **Sprucolite**, of the Sprucolite Corp., is such a material made from sheets of western spruce impregnated with a waterproof binder, laminated at right angles, and subjected to hydraulic pressure to make it dense and hard. The coefficient of friction is nearly 50% higher than that of cast iron; the weight is about 35% that of iron. **Hydulignum** is an English Laminated wood made of thin birch veneers impregnated with vinyl formal resin and compressed into a dense board. It is used for aircraft propellers. The specific gravity is 1.31, tensile strength 45,000 psi, and compressive strength 21,000 psi.

**Poison gases.** Substances employed in chemical warfare for disabling men, and in some cases used industrially as fumigants. They are all popularly called gases, but many are liquids or solids. They are classified according to their main effect on the human system, but one gas may have several effects. They are grouped as follows: **Lethal**, intended to kill, such as phosgene; **lachrymators**, which affect the eyes, such as chloropicrin; **vesicants**, or skin blisterers, such as lewisite and mustard gas; **sternutatory**, which induce sneezing; and **camouflage**, which are harmless, but cause soldiers to suffer the inconvenience of wearing gas masks and thus reduce their morale. Gases are also sometimes designated as **casualty agents** and **harassing agents**, and further subdivided into **persistent** and **nonpersistent**. A **Systemic gas** is one that interferes with one phase of the system, such as carbon monoxide, which paralyzes the respiratory function of the blood. A **Labyrinthic gas** is one that affects an organ of the body, such as Dichlormethyl ether, which affects the ears.

Effects of persistent gases, such as mustard, remain over the ground

for as long as 7 days, but phosgene is quickly decomposed by dampness. Obscuring agents, such as white phosphorus, and the Toxic smokes, such as Diphenylaminochloroarsine, are also classed as war gases. Dusts of materials having catalytic properties, but not poisonous themselves, may be used to penetrate gas masks and create poisons, such as carbon monoxide, within the mask. Carbon and oil smokes may be used to choke the filters of gas masks and cause their removal. Absorbents used in gas masks are usually activated charcoal and soda lime. These will absorb or disassociate most of the toxic gases, but will not stop carbon monoxide. A mixture of powdered oxides of copper, manganese, silver, and cobalt, called Hopcalite, is used as a catalyst to oxidize carbon monoxide.

Lethal gases are divided into four classes: actual poisons, which kill with little pain, such as hydrocyanic acid; Asphyxiating gases, which affect the membranes of the lungs, destroying them and allowing blood to fill the air sacs, such as phosgene, diphosgene, and chloropicrin; poisons which destroy the lining of the air passages and block the passages to the lung tissues, as mustard gas and ethyldichloroarsine; and poisons which affect the nose and throat, causing great pain, headache, vomiting, such as diphenylchloroarsine. Mustard gas,  $(\text{CH}_2\text{ClCH}_2)_2\text{S}$ , known also as Blister gas, Yperite, and Yellow cross, is an oily liquid which boils at  $210^\circ\text{C}$  and vaporizes easily in the air. It destroys the cornea of the eyes, blisters the skin, affects the lungs, and causes discharge from the nose and vomiting. One part in 14 million parts air is toxic and cannot be detected in dilutions by smell. Another powerful vesicant is Bromlost, which is Dibromethyl sulphide,  $(\text{CH}_2\text{BrCH}_2)_2\text{S}$ . It is a solid melting at  $21^\circ\text{C}$ . Sulvanite is Ethylsulphuryl chloride,  $\text{ClSO}_3\text{C}_2\text{H}_5$ . It is a colorless liquid boiling at  $135^\circ\text{C}$ .

Lewisite,  $\text{CHCl}:\text{CH}:\text{AsCl}_2$ , is a liquid boiling at  $190^\circ\text{C}$ . It is a powerful vesicant causing painful blisters on the skin, pain in the eyes, nose irritation, permanent impairment of eyesight, and arsenic poisoning. It forms a heavy mist and was called Dew of death. Chloropicrin, called Aquinite, Klop, and Nitrochloroform, is Nitrotrichloromethane,  $\text{CCl}_3\text{NO}_2$ . It is a persistent lachrymatory and lethal poison. It is a colorless liquid boiling at  $112^\circ\text{C}$ . Tonite is Chloroacetone,  $\text{CH}_3\text{COCH}_2\text{Cl}$ , a clear liquid vaporizing at  $119^\circ\text{C}$ . It is

a powerful lachrymator and skin blisterer. As it is very reactive, it is also used in the synthesis of pharmaceuticals, dyes, and organic chemicals.

**Martonite**, a powerful lachrymator, is a mixture of 20% chloroacetone and 80 bromoacetone. **Bretonite** is Iodoacetone,  $\text{CH}_3\text{-COCH}_2\text{I}$ , a brownish liquid boiling at  $102^\circ\text{C}$ , mixed with stannic chloride as a lachrymator. **Manguinite** is Cyanogen chloride,  $\text{CnCl}$ , which boils at  $13^\circ\text{C}$ , and is a lachrymator. Mixed with arsenic trichloride to make it more toxic it was used under the name of **Vitrite**. **Campillit** is Cyanogen bromide,  $\text{CNBr}$ , a white solid melting at  $52^\circ\text{C}$  and vaporizing at  $61.3^\circ\text{C}$ . The fumes are highly toxic, paralyzing the nerve centers. **Diphenylchloroarsine**, or **Blue cross**  $(\text{C}_6\text{H}_5)_2\text{AsCl}$ , is a Sneezing gas which penetrates gas masks, forcing their removal. It affects chiefly the nose and throat, but is used with other more violent gases. **Adamsite**, is a greenish granular solid of the composition  $(\text{C}_6\text{H}_4)_2\text{NHAsCl}$ , which has a pleasant odor but burns the nose and throat. Many of the lachrymators have important industrial uses. **Phenyl isocyanate**,  $\text{C}_6\text{H}_5\text{NCO}$ , is a water-white liquid of specific gravity 1.101 and boiling point  $162^\circ\text{C}$ , used for the production of alkyl resins, ureas, urethanes, and other chemicals.

**Polonium.** A rare metallic element, symbol  $\text{PO}$ , belonging to the group of radioactive metals, but emitting only alpha rays. The melting point of the metal is about  $1800^\circ\text{C}$ . It is used in meteorological stations for measuring the electrical potential of the air. Polonium-plated metal in strip and rod forms is produced by the Canadian Radium & Uranium Corp. for use as a static dissipator in electrical equipment and textile coating machines. The alpha rays ionize the air near the strip, making it a conductor and drawing off static electrical charges.

**Polystyrene.** A synthetic resin used for molding, in lacquers, and for coatings, formed by the polymerization of monomeric Styrene, which is a colorless liquid of the composition  $\text{C}_6\text{H}_5\text{CH:CH}_2$ , specific gravity 0.906, and boiling point  $145^\circ\text{C}$ . It is made from ethylene, and is ethylene with one of the hydrogen atoms replaced by a phenyl group. The polymerized resin is a transparent solid very light in weight with a specific gravity of 1.054 to 1.070. The tensile strength

is 3,000 to 8,500 psi, compressive strength 12,000 to 17,000 psi, and dielectric strength 450 to 600 volts per mil. Polystyrene is notable for water resistance and high dimensional stability. It is also tougher and stronger at low temperatures than most other plastics. It is valued as an electrical insulating material, and the films are used for cable wrapping. The films are heat-sealing at above 70°C. The molding plastic is used for cosmetic containers, clock crystals, gage dials, and aircraft panels. For coating purposes plasticizers are added to increase pliability, but are not needed for molding. The plastic has good fluidity and is especially suited for injection molding. The polymer used in England for injection molding is called Distrene. Styroflex was a German polystyrene in thin tape form for cable wrapping. Victron, of the Naugatuck Chemical Co., is a clear transparent polystyrene resin. Lustron is the trade name of Monsanto Chemical Co. for a polystyrene plastic. Lustron PI is a grade for molding at low pressure and short molding cycle. Stymer, of this company, is a polystyrene resin used for sizing textiles. It is insoluble in water, but soluble in alkaline solutions. Loalin, of the Catalin Corp., is a polystyrene with a specific gravity 1.05 to 1.07. It is crystal clear, and will take light pastel colors. In the clear form it transmits 90% light. It is water-resistant and has a dielectric strength of 500 to 700 volts per mil. It is not affected by alcohol, acids, or alkalis, but is soluble in aromatic hydrocarbons. It is preferably injection-molded. Styron, of the Dow Chemical Co., is polystyrene molding granules, and Styaloy is molding powder. Cellon and Trotilul are English polystyrene plastics. Isopol, of the Union Bay State Chemical Co., is a high-molecular-weight resin produced from 75% styrene and 25 isoprene. It is a modified polystyrene in which the isoprene acts as an internal plasticizer. The molded and cured resin is a water-white hard solid having the characteristics of polystyrene without the brittleness. It possesses many of the chemical properties of natural rubber, and is soluble in naphtha. When used as picture-frame glass it will fracture without sharp edges. The resin is also used for coatings, and as a stiffener for natural rubber. NBS resin of the Mathieson Alkali Works is a dichlorostyrene-styrene copolymer for use with a catalyst as a casting plastic. It has low water absorption and high dielectric strength. Styrene-butylene resins are copolymers that mold easily and produce thermoplastic products

of low water absorption and good electrical properties. They have strength equal to the vinyls with greater elongation. They are also useful for coatings and for film for packaging.

**Pontianak.** A gum from the trees *Dyera costulata* and *D. laxifolia* of Borneo and Malaya. The commercial pontianak is a grayish-white mass like burned lime, and contains 60% water, with only 10 to 25% rubberlike materials. It is a rubber, but has a high content of resin similar to balata and gutta percha, and is classed with the lower guttas. It is used in the friction compounds employed for coating transmission belting, in insulations and varnishes, for mixing with gutta percha, and also to adulterate or replace chicle for chewing gums. It is also called Jelutong. Pontianak copal is from varieties of *Agathis* trees of Borneo. Its peculiar turpentinelike qualities come from the method of tapping. It is valued for varnishes.

**Poplar.** The wood of several species of the tree *Populus*. The Black poplar, or English poplar, *P. nigra*, of Europe, is a large tree with blackish bark. The wood is yellowish white with a fine, open grain. It is soft and easy to work. The weight is about 25 lb per cu ft. It is used for paneling, inlaying, packing cases, carpentry, and paper pulp. Lombardy poplar is a hybrid variety of this species. It is a tall, columnar tree that is male only and can be propagated only from rootstocks. It is grown in the United States for shelter belts, but in some countries is grown in fruit districts as a wood for packing boxes. White poplar, *P. alba*, is a larger tree native to the United States. The wood is similar to that of the black poplar. Cottonwood is another species of poplar. Gray poplar is from the tree *P. canescens*, of Europe. The color of the wood is light yellow. It has a tough, close texture somewhat resembling that of maple. It is used for carpentry and flooring. The wood of the canary whitewood is called Virginia poplar, or simply poplar, but belongs to a different family of trees. Aspen is also called poplar.

**Potash.** Also called Pearl ash. A white alkaline granular powder, which is a Potassium carbonate,  $K_2CO_3$  or  $K_2CO_3 \cdot H_2O$ , used in soft soaps, for wool washing, and in glass manufacture. It is produced from natural deposits in Russia and Germany and also produced from wood and plant ashes. The American production is largely from

potash salts of New Mexico, from the brines of Searles Lake, Calif., and from solar evaporation in Utah. The specific gravity of potash is 2.33 and melting point  $909^{\circ}\text{C}$ . Hartsalz, mined in the Carpathian Mountains and used for producing potash, is a mixture of sodium chloride, potassium chloride, and magnesium sulphate. It is also a source of magnesium. The extensive potassium mineral deposits at Strassfurt and Mülhausen contain Sylvite,  $\text{KCl}$ ; Carnallite,  $\text{KCl} \cdot \text{MgCl}_2 \cdot 6\text{H}_2\text{O}$ ; Kainite,  $\text{K}_2\text{SO}_4 \cdot \text{MgSO}_4 \cdot \text{MgCl}_2 \cdot 6\text{H}_2\text{O}$ ; and Leonite,  $\text{K}_2\text{SO}_4 \cdot \text{MgSO}_4 \cdot 4\text{H}_2\text{O}$ . There are at least a billion tons of the potash mineral Wyomingite in the deposits near Green River, Wyo. It is a complex mineral containing leucite, phlogopite, diopside, kataphorite, and apatite. It has 11.4%  $\text{K}_2\text{O}$ , with sodium oxide magnesium oxide, phosphorus pentoxide, and other oxides. The potash minerals form the raw material for the production of many chemicals.

**Potassium.** An elementary metal, symbol K, and atomic weight 39.1, also known as Kalium. It is silvery white in color, but oxidizes rapidly in the air and must be kept submerged in ether or kerosene. It has a low melting point,  $65.5^{\circ}\text{C}$ , and a boiling point at  $757^{\circ}\text{C}$ . The specific gravity is 0.859. It is soluble in alcohol and in acids. It decomposes water with great violence. Potassium is obtained by the electrolysis of potassium chloride. It has no commercial applications, but potassium compounds are widely employed. Potassium hydride is used for the photosensitive deposit on the cathode of some photoelectric cells. It is extremely sensitive and will emit electrons under a flash so weak and so rapid as to be imperceptible to the eye. Potassium diphosphate,  $\text{KH}_2\text{PO}_4$ , a colorless, crystalline, or white powder soluble in water, is used as a lubricant for wool fibers to replace olive oil in spinning wool. It has the advantages that it does not become rancid like oil and can be removed without scouring.

**Potassium chlorate.** Also known as Chlorate of potash and Potassium oxymuriate. A white crystalline powder, or lustrous crystalline substance of the composition  $\text{KClO}_3$ , employed in explosives, chiefly as a source of oxygen. It is also used as an oxidizing agent in the chemical industry, in medicine as a cardiac stimulant, and in tooth paste. It melts at  $357^{\circ}\text{C}$  and decomposes at  $400^{\circ}\text{C}$  with the rapid evolution of oxygen. It is odorless but has a slightly bitter saline taste. The specific gravity is 2.337. Potassium chlorate is not hygroscopic

and does not alter on exposure to the air. It is, however, soluble in water but insoluble in alcohol. It imparts a violet color to the flame when used in pyrotechnic compositions. It is made by the electrolysis of potassium chloride.

Potassium chloride is a colorless or white crystalline substance of the composition  $\text{KCl}$ , used for molten salt baths for the heat-treatment of steels. It is also used in fertilizers and in explosives. The specific gravity is 1.987. A bath composed of 3 parts potassium chloride and 2 barium chloride is used for hardening carbon-steel drills and other tools. Steel tools heated in this bath and quenched in a 3% sulphuric acid solution have a very bright surface. A common bath is made up of potassium chloride and common salt and can be used for temperatures up to  $900^{\circ}\text{C}$ .

**Potassium cyanide.** A white amorphous or crystalline mass of the composition  $\text{KCN}$ , employed for carbonizing steel for case-hardening and for electroplating. The specific gravity is 1.52, and it melts at about  $1550^{\circ}\text{F}$ . It is soluble in water and is extremely poisonous, giving off the deadly hydrocyanic acid gas. For cyaniding steel the latter is immersed in a bath of molten cyanide and then quenched in water, or the cyanide is rubbed on the red-hot steel. For this use, however, sodium cyanide is usually preferred, because of its lower cost and the higher content of  $\text{CN}$  in the latter. Commercial potassium cyanide is likely to contain a proportion of sodium cyanide. Potassium ferrocyanide, or Yellow prussiate of potash, can also be used for casehardening steel. It has the composition  $\text{K}_4\text{Fe}(\text{CN})_6$  and comes in yellow crystals or powder. The nitrogen as well as the carbon enters the steel to form the hard case. Potassium ferricyanide, or Red prussiate of potash, is a bright-red granular powder of the composition  $\text{K}_3\text{Fe}(\text{CN})_6$ , used in photographic reducing solutions, in etching solutions, in blueprint paper, and in silvering mirrors. Redsol crystals, of the American Cyanamid Co., is the name of this chemical for use as a reducer and mild oxidizing agent, or toner, for photography. Potassium cyanate,  $\text{KCNO}$ , is a white crystalline solid used for the production of organic chemicals and drugs. It melts at  $310^{\circ}\text{C}$ . The Potassium silver cyanide, used for silver plating, comes in white, water-soluble crystals of the composition  $\text{KAg}(\text{CN})_2$ . Sel-Rex, of the Bart-Messing Corp., is this material.



**Potassium nitrate.** Also called Niter, and Saltpeter, although these usually refer to the native mineral. A substance of the composition  $\text{KNO}_3$ , used in explosives and for bluing steel. A mixture of 2 parts potassium nitrate and 3 sodium nitrate is used for steel-tempering baths. The mixture melts at  $250^\circ\text{C}$ . Potassium nitrate is made by the action of potassium chloride on sodium nitrate, or Chile saltpeter. It occurs in colorless, prismatic crystals, or as a crystalline white powder. It has a sharp saline taste and is soluble in water. The specific gravity is 2.1 and melting point  $337^\circ\text{C}$ . It is found in nature in limited quantities in the alkali region of western United States. Potassium nitrate contains a large percentage of oxygen which is readily given up and is well adapted for pyrotechnic compounds. It gives a beautiful violet flame color in burning. Another use is in smoke-tracer compounds with sulphur and arsenic, and in flares and smoke torches. Its function is to furnish oxygen in concentrated form. Potassium nitrite is a solid of the composition  $\text{KNO}_2$  used as a rust inhibitor, for the regeneration of heat-transfer salts, and for the manufacture of dyes.

**Potato.** The bulbous tubers of the roots of the annual plant *Solanum tuberosum*, native to Peru but now grown in many parts of the world. It is used chiefly as a direct food, but is also employed for making starch and alcohol. The potato was brought to Europe in 1580, and received the name of Irish potato when brought to New England in 1719 by Irish immigrants. The plant is hardy and has a short growing cycle, making it adaptable to many climates. The potato constitutes about 40% by weight of all vegetables consumed as food in the United States, but about 90% of the total world crop is normally produced in Europe, mostly in Germany, Russia, and Poland. The tuber contains about 78% water, 18 starch with some sugar, 2 proteins, 1 potash, and only about 0.1 fats. The average water loss in storage is about 11%. There are more than 500 varieties of potato cultivated. The yield per acre in northern Maine, the chief American growing area, is 358 bu, but under subsidy much higher yields were obtained.

The Sweet potato is the root bulb of the trailing perennial vine *Ipomoea batata*, native to tropical America, but now grown extensively in the south of the United States and in warm climates. In

South America it is known by the Carib name Batata. Like the white potato, the sweet potato has a high water content, but is rich in sugars. There are many varieties and two general types: one with a dry mealy yellow flesh and the other with a soft gelatinous flesh higher in sugars. The latter type is called Yam in the United States, but the true yam is a larger tuber from the climbing plant *Dioscorea alata*, grown widely in the West Indies. The sweet potato is used as a direct food, but large amounts are also employed for making preserves, starch, and flour for confectionery. Almacalt is cooked and roasted sweet potato ground to a powder for use in confectionery. It adds flavor as well as sugar to the confectionery.

The Taro is the root tuber of the large leafy plant *Colocasia esculenta*, which constitutes one of the chief foods of southeast Asia and Polynesia. There are more than 300 varieties grown. The tuber is high in starch, has more proteins than the potato, but has an acrid taste until cooked. The pasty starch food known as Poi in the Pacific Islands is made from taro. In Micronesia the taro is called Jaua, and the Mwang plant, *Cyrtosperma chamissonis* is called taro. This plant is larger, and the rootstock weighs as much as 50 lb, while the taro does not exceed 5 lb. Taro matures in 6 months, while the mwang requires 2 years. The Dasheen is a variety of taro grown in the south of the United States. The Yautia, grown in the West Indies, resembles the taro, but is from the large plant *Xanthosma sagittifolium*. It is high in starch and has more food value than the potato.

**Precious metals.** A general term for the expensive metals that are used for coinage, jewelry, and ornaments. The name is limited to gold, silver, and platinum, expense or rarity alone not being the determining factor, but rather the setting of a value by law, with the coin having an intrinsic metal value as distinct from a copper coin which is merely a token with little metal value. The term noble metal is not synonymous, although a metal may be both precious and noble, as platinum. Noble metals are highly resistant to acids and to corrosion by themselves unalloyed. The noble metals are gold, platinum, iridium, rhodium, osmium, and ruthenium. Radium and certain other metals are more expensive than platinum but are not classed as precious metals. Because of the expense of the platinum noble metals, they may be alloyed with gold for use in chemical crucibles. Platino

is an alloy of 89% gold and 11 platinum. Palau is the name of an alloy of gold and palladium, and Rhotanium is a Rhodium-gold alloy.

**Prefinished metals.** Sheet metals that have a polished surface of another metal plated on one side, or have the finish metal bonded and rolled on the base metal. In the latter case they are called Bonded metal. The metals are used for stamped parts to save plating and polishing of the articles after manufacture, or to give the corrosion resistance of the plated metal with the strength of a steel base. They often replace enameled or lithographed metals for making toys and ornamental articles, and when made in strips or patterns are used for making electrical appliance parts. The most usual prefinished metals have a base of copper, zinc, or brass, with nickel- or chromium-plated surfaces. The bonded metals are on the same principle as clad metals, but are in general thin sheets for decorative articles. The highly finished metals are marketed with a thin paper coating on the polished side which is easily stripped off after forming. Brassoid, of the American Nickeloid Co., is a brass bonded to zinc; Chromoloid is chromium bonded to zinc; and Nickeloid is sheet zinc with a polished nickel surface. Chromium, copper, and nickel, in bright or matte finishes, are also bonded to steel in gages of 0.010 to 0.050 in. Tint-Metal is copper-tin, copper-zinc, or copper-steel base metal finished in plain or striped colors. Metal-Bord is prefinished metal bonded to a backing of paper or fiberboard, used for signs, buckles, ornamental articles, or wall facing.

**Preservatives.** Chemicals used to prevent oxidation, fermentation, or other deterioration of foodstuffs. The antioxidants, inhibitors, and stabilizers used to retard deterioration of industrial chemicals are not usually called preservatives. The most usual function of a preservative is to kill bacteria, and this may be accomplished by an acid, alcohol, aldehyde, or salt. A legal requirement under the Food and Drug Act is that a preservative must be nontoxic in the quantities permitted. Sugar is the most commonly used preservative for fruit products. Sodium chloride is used for protein foods. Sodium nitrate is reduced to sodium nitrite in curing meats, and the nitrite has an inhibitory action on bacterial growth, the effect being greatest in acid flesh. The inhibitory effect of organic acids is due chiefly to the undissociated molecule. Acetic acid is normally more toxic to bacteria than

lactic acid, but when sugar is present the reverse is true, and citric acid then has little toxicity. The inhibitory action of inorganic acids is due mainly to the pH change which they produce. The antimicrobe effect of the vanillic acid esters generally increases with increasing molecular weight. Only small quantities of chemicals are usually needed for preservation. Isobutyl vanillate, an ester of vanillic acid, is effective as a preserving agent in milk and some other foods when only 0.10 to 0.15% is used. Preservatives are also marketed for external application to foodstuffs in storage, though these are more properly classed as fumigants. Barsprout, of the American Cyanamid Co., is a methyl ester of naphthalene acetic acid in powder form for dusting on potatoes and other root vegetables to keep them from sprouting and to preserve them in storage.

**Primer.** A surfacing material employed in painting or finishing to provide an anchorage or adhesion of the finishing material. A primer may be colorless, or it may be with color. In the latter case it is sometimes called an Undercoat. A primer is distinct from the filler coat used on woods to fill the pores and thus economize on the more expensive finish. Primer coats of red lead paint were formerly much used on construction steel to give corrosion resistance, but chromate or phosphate primers are now more common. Pigment E, of the National Lead Co., is a Barium potassium chromate that gives a pale-yellow coating with good anticorrosion properties for steel, aluminum, and magnesium. Zinc yellow paints may also be used as primer coats on metal. Zinc chromate is used as a primer on steel. It has a tendency to dissolve when moisture penetrates the paint, and this dissolved chromate retards corrosion of the steel. Granodine, of the American Chemical Paint Co., is a zinc phosphate for spray or dip application to iron and steel to give corrosion resistance and to improve paint adhesion. Thermoil-Granodine is a manganese phosphate that forms a dense crystalline coating on steel which acts as a corrosion-resistant base for paint. In addition to the pigment, various corrosion inhibitors may be used in primer paints. Ammonium ferrous phosphate,  $\text{NH}_4\text{FePO}_4 \cdot \text{H}_2\text{O}$ , has a platelike structure which gives impermeability to the film as well as adding corrosion resistance. It is greenish in color. A primer is especially required in the finishing of sheet-metal objects that are likely to receive dents or

severe service, but they are not usually necessary for castings or roughened surfaces. For sheet-metal work, baked enamels were formerly much used for the primers for the lacquer finishes, but synthetic resin primers give good adhesion and are less expensive.

**Proteins.** Complex nitrogen organic compounds of very high molecular weights, from about 15,000 to many millions, occurring in animal and vegetable matter, and now also made synthetically. They are built up from amino acids and vary greatly. At least 10 different proteins are known to be essential to human body growth and maintenance. Plants are able to synthesize the proteins, but animals cannot do this. Animals hydrolize proteins to give simpler products including other proteins, but do not build up. While proteins are known best for their use in foods and feeds, and are an essential of all living cells, they are of increasing importance for plastics and chemicals.

More than 30 Amino acids have been isolated from proteins, and every protein contains many different amino acids. The simple proteins are made up entirely of the acids, but the complex or conjugated proteins contain also carbohydrates and special groups, while the Cystine of hair and wool also contains sulphur. The constituent amino acids of the protein molecule are linked together with a peptide bond, and the linkage forms the backbone of the molecule, but the arrangement is not similar to the high polymers usually associated with plastics with one type of polymer, or group, repeating itself. The linkage is formed by the loss of carbon dioxide rather than by the loss of water as in plastics.

Biologically, the edible proteins are classified as first-class and second-class, the first being from animal and the second from vegetable origin. Meat and fish proteins are both complete, or first-class proteins, but the digestibility of fish protein is slightly higher than that of beef protein, while oyster protein is high in growth-promoting value. The synthesis of globulin and antibody formation for resistance to disease depends upon the utilization of various amino acids most readily obtained from first-class proteins. Vegetable protein is in general not a complete food for the human system, and has only low effect in plasma protein regeneration.

Hydrolyzed proteins are used in flavoring foodstuffs. Soy sauce is

a soybean protein hydrolysate with a meatlike flavor used in Japan and in China. The Japanese condiment Adjimimoto is made from wheat gluten, and is largely Sodium glutamate, a salt of Glutamic acid,  $C_5H_9O_4N$ , which occurs in seeds and beets. Monosodium glutamate, known under various trade names, as MSG of the A. E. Staley Mfg. Co., and Ac'cent of the International Minerals & Chemical Corp., and exported to Japan as Shirayuki, is a white crystalline material with a sweet saline taste and some astringency. It is a vegetable protein derivative from soybean, sugar-beet waste, and other products. The purified chemical has no flavor, but intensifies the taste and flavor of foods, especially when salt is present. It also may intensify food odors without having any odor in itself. Animal protein factor, APF, used in animal feeds, and marketed commercially in fish solubles, is an amino-acid combination containing several vitamins. It is used in feeds for single-stomach animals, such as the hog, which cannot synthesize within themselves all of the amino acids necessary for health. It is also used in poultry feeds, as it contains the hatchability factor not adequately supplied by grains. DL-methionine, of the Dow Chemical Co., is a synthetic amino acid of the composition  $CH_3SCH_2CH_2CH(NH_2)CO_2H$ , used in feeds for fattening poultry. Soybean protein is marketed as a highly refined, odorless, and tasteless powder for use in confectionery and other foods to retain freshness and add food value.

**Protein plastics.** Organic plastic molding materials produced by the isolation or precipitation of proteins from animal or vegetable products and hardening or condensing into stable compounds that can be molded into sheets or fiber. The oldest of the protein plastics is casein plastic which is made into molding plastics or into woollike fibers for textiles. The proteins from soybean meal or other vegetable products are condensed with aldehydes or with various mineral salts or acids to form plastics. These plastics are distinct from those made from the fatty acids of soybean or other oils. Peanut fiber, under the name of Ardil, is made in England by precipitating the protein from peanut meal with an acid, dissolving in caustic soda, and forcing through spinnerets into a hardening bath. The fiber is soft and resilient, moisture-absorbent like wool, moth-resistant, and will dye easily. It is mixed with wool in weaving fabrics. Vicara, of the

Virginia-Carolina Chemical Corp., is a protein fiber produced from the zein of corn. The fiber is light yellow in color, soft, tough, and strong. In fabrics it has the warmth of wool, is resistant to mildew, and will withstand temperatures to 310°F. It can be blended with cotton, wool, or rayons. Proteins obtained by alkaline extraction from cottonseed are also used to produce woollike fibers. Azlon is a general name for protein fibers.

**Pulpstones.** Large blocks of sandstone cut into wheels and used for grinding, chiefly for the grinding of wood pulp in paper manufacture. The American pulpstones are produced in Ohio and West Virginia. The sandstones for pulpstones must be uniform in texture, have sharp grains, medium hardness, and be composed of even quartz grains of which 85% will be retained on a 150-mesh screen, and 90% on a 200-mesh screen. The cementing material may be siliceous, calcareous, or argillaceous, but must be firm enough to hold the stone together when working under pressure, and soft enough to wear faster than the quartz grains and prevent glazing. The standard diameter of pulpstones is 54 in. and width of face 27 in. The stones are aged or seasoned from 1 to 2 years before use. Aging is quickened by heating the stones to about 180°F in a closed room and cooling slowly.

**Pumice.** A porous, frothlike volcanic glass which did not crystallize due to rapid cooling, and frothed with the sudden release of dissolved gases. Powdered or ground pumice is used as an abrasive for fine polishing, in metal polishes, in scouring compounds and soaps, and in plaster and lightweight concrete and pozzuolanic cement. In very fine powder it is called Pounce when used for preparing parchment and tracing cloth. Pouncing paper is paper coated with pumice used for pouncing, or polishing, felt hats. Pumice is grayish white in color, and the fine powder will float on the surface of water. The natural lump pumice contains 65 to 75% silica, 12 to 15 alumina, and 4 to 5 each of soda and potash. It is produced chiefly in California and New Mexico. Pumicite is a Volcanic ash similar in composition to pumice, found in large beds in Nebraska, Kansas, and Colorado. Its chief distinction is that it is fine-grained and has sharp edges suitable for abrasive purposes. The natural material is dried, pulverized, and screened so that 98.8% will pass a 325-mesh screen.

**Seismotite** is a trade name of the Cudahy Co. for pumice used as an abrasive in scouring compounds. Slag pumice, or Artificial pumice, is made in Germany by treating molten slag with less water than is required for granulation. It is used as an aggregate in lightweight concrete and as a heat insulator. Obsidian, or Volcanic glass, will change into pumice when melted. Obsidian was used by the ancients for instruments and by the American Indians for arrowheads and knives. Semitransparent smoky-colored obsidian nodules of Arizona are called Marekanite, and are cut for Indian silver jewelry.

Hawaiian obsidian, or Tachylite, also known as Basalt glass, is a volcanic glass from Oahu, Hawaii. It is jet black, takes a fine polish, and is used for making ornamental articles. The type of obsidian found in Oregon and California, known as Perlite, is flash roasted to form a bubblelike expanded material about 15 times original size which is crushed to a white fluffy powder. Perlite contains about 75% silica. In California it has been called Calite. The powder weighs only 4 to 12 lb per cu ft, and is used in lightweight wall-board, acoustical tile, insulation, and as a lightweight aggregate in concrete. Perlalex, of the Alexander Film Co., is the finely ground powder used for removing smears from drawing paper. The Rhyolite perlite of California is expanded to ovaloid particles of 590- to 840-micron size containing complete vacuums and weighing only 0.78 lb per cu ft. This material has about 70% silica, 15 alumina, 2  $\text{Fe}_2\text{O}_3$ , 1.5 CaO, 2.75  $\text{Na}_2\text{O}$ , 1 MgO, 4  $\text{K}_2\text{O}$ , and 4 water.

**Purpleheart.** The wood of several species of trees, notably *Peltogyne paniculata* of the Guianas. The color of the wood is brown, the heartwood turning purple on exposure. The grain is open and fine. The wood weighs about 53 lb per cu ft, is very hard, strong, and durable. It is used for machine and implement parts, inlays, furniture, and turnery.

**Putty.** A mixture of calcium carbonate with about 18% linseed oil, with sometimes white lead added. It is used for cementing window glass in place and also as a filler for patterns. Litharge is often added to putty for steel sash. Another putty for steel contains red lead, calcium carbonate, and linseed oil. The dry pigment for putty, Whiting putty, according to ASTM specifications contains 95% calcium carbonate and 5 tinting pigment. White lead putty contains



10% or more white lead mixed with the calcium carbonate. Federal specifications call for a minimum of 11% boiled or processed linseed oil with a maximum of 89% pigment in a white lead-whiting putty. Putty powder is a mixture of lead and tin oxides, or a mixture of tin oxide and oxalic acid, or it may be merely an impure form of tin oxide. It is used in enameling and for polishing stone and glass, and as a mild abrasive for dental polishes. Calking putty, used for setting window and door frames, is made of asbestos fibers, pigments, and drying oils, or with rubber or resins.

**Pyrrargyrite.** An ore of silver, known also as dark ruby silver. It is a sulphantimonite of silver,  $\text{Ag}_3\text{SbS}_3$ , containing 22.3% antimony and 59.8 silver. It is found in various parts of Europe, in Mexico, Colorado, Nevada, and New Mexico. It occurs in crystals or massive, and also in grains. Its hardness is 2.5 and specific gravity 5.85. The color is dark-red to black, showing ruby-red in thin splinters. Proustite is another ore of silver occurring in silver veins associated with other metals. It is found in the mines of Peru, Mexico, Chile, and in Nevada and Colorado. It is also called light Ruby silver and is a sulpharsenite of silver of the composition  $\text{Ag}_3\text{AsS}_3$ , containing theoretically 65.4% silver. It commonly occurs massive, compact, in disseminated grains. The hardness is 2 to 2.5, specific gravity 5.55, and the color is ruby-red with an adamantine luster.

**Pyrethrum.** The dried flowers of several species of chrysanthemum, of which the *Chrysanthemum cinerariaefolium* of Yugoslavia and Japan is the best known. It is a slender perennial, about 15 in. high, with daisylike flowers. The powder is used as an insecticide chiefly in sprays. It comes from Yugoslavia, Japan, and British East Africa. The crude pyrethrum from Kenya contains 1.3% Pyrethrin as compared with only 0.9% in the Japanese. Persian powder is pyrethrum from the species *C. coccineum* of southwestern Asia. Lethane, of the Rohm & Haas Co., is a synthetic aliphatic diacyanate used as a substitute for pyrethrum. It is 30 to 40% more powerful than pyrethrum in insect sprays. Pyrethrin contains Pyrethronic acid and Cyclopentane,  $(\text{CH}_2)_5$ . The active principles of natural pyrethrum flowers have been designated as pyrethrin and Cinerin, and the synthetic material marketed by the U.S. Industrial Chemicals, Inc., is a homologue of cinerin. In high concentrations, it is more effective than

natural pyrethrum. A substitute for pyrethrum for the control of corn worms is Styrene bromide, or Bromo styrene, an oily liquid of the composition  $C_6H_5CBr:CH_2$ .

**Pyrophoric alloys.** Metals which produce sparks when struck by steel, used chiefly for gas and cigarette lighters. The original pyrophoric alloy, or Sparking metal, was known as Auer metal. It was patented by Auer von Welsbach in 1903, and contained 35% iron and 65 misch metal. The French Kunheim metal contained 10% magnesium and 1 aluminum instead of iron. A very durable alloy for cigarette lighters is a Zirconium-lead alloy containing 50% of each metal. Titanium can replace part of the zirconium, and tin can replace part of the lead, but alloys with less than 25% zirconium are not pyrophoric. The 50-50 alloy has a crystalline structure.

**Pyrophyllite.** An aluminum silicate mineral found in North Carolina, used as a substitute for talc. It is similar to talc in structure and appearance, but its composition,  $Al_2Si_4O_{10}(OH)_2$ , is more nearly like kaolin. It is white, gray, or brown, with a pearly or greasy luster, specific gravity 2.8, and hardness 1 to 2. Compact varieties of the mineral are made into slate pencils and crayons. A fine-grained compact rock mined in South Africa, composed of about 90% pyrophyllite, with rutile and other minerals, is called Wonderstone, and is used for table tops and switchboard panels. It is resistant to weathering, acids, and heat, and it can be planed, sawed, or turned in the lathe. It then becomes harder on exposure. Wonderstone is an ancient indurated clay resembling fireclay in which the colloidal matter has been destroyed by heat, pressure, and age. Unfired refractory bricks are made of dry-pressed pyrophyllite. They have high spalling resistance and do not shrink. Pyrax, of the R. T. Vanderbilt Co., is pyrophyllite in fine white powder of 100 mesh, with specific gravity 2.6, used as a filler in rubber. Silical, of Herron Bros. & Meyer, is pyrophyllite from Newfoundland in fine powder form as a dusting talc for rubber. The Japanese employ great quantities of pyrophyllite in the making of firebrick, fireclay, and crucibles. The mineral used averages 86.7% pyrophyllite, 12.8 kaolin, and 0.5 diaspore.

**Quartz.** The most common variety of silica,  $SiO_2$ . It occurs mostly in grains or in masses of a white or gray color, but often colored by

impurities. Pure crystalline quartz is colorless and is called Rock crystal. Quartz usually crystallizes in hexagonal prisms or pyramids. The hard rigid Beta quartz crystals have a latticelike molecular structure in which each silicon atom is linked to four separate oxygen atoms, each oxygen atom being linked to two different silicon atoms. The formula of quartz crystal, therefore, is  $(\text{SiO}_2)_x$ . The grains in sand are often less than 0.04 in., but crystals up to 20 in. have been found. The specific gravity is 2.65. Quartz will transmit the short waves of ultraviolet light, and fused quartz or Quartz glass is used for bulbs for photoelectric cells and for optical glass. Quartz crystals have the property of generating an electrical force when placed under pressure and, conversely, of changing dimensions when an electric field is applied. This property is termed piezoelectric. A Piezo-electric crystal is made up of molecules that lack both centers and planes of symmetry. Many materials other than quartz have this property, such as rochelle salt and ammonium dihydrogen phosphate, but most of them are water-soluble or lack hardness. The best quartz crystals are hexagonal prisms with three large and three small cap faces. For electric use the crystals must have no bubbles, cracks, or flaws, and they should be free from twinning, or change in the atomic plane. Brazilian quartz crystals are cut into plates of different sizes to initiate and receive various frequencies on multiple-message telephone wires, and to obtain selectivity in radio apparatus. Owing to its peculiar refractive powers, quartz crystal is also employed for the plates in polarization instruments and in lenses. Quartz crystals for radio-frequency control are marketed in three forms: Rough-sawed blanks, cut to specified angles; semifinished blanks, machine-lapped to approximate size; and electrically finished blanks, finished by hand and electrically tested. Synthetic quartz crystals of large size and high purity and uniformity are grown from seed crystals suspended in an alkaline silica solution at high temperature and pressure. Barium titanate crystals, grown synthetically, are used as substitutes for quartz crystals for some applications. After growing, they are subjected to a high polarizing voltage, and they give quick response to changes in pressure or electric current. Ethylene diamine tartrate crystals, another substitute for quartz, are grown to large size and are used for telephone work.

Quartz is harder than most minerals, being 7 Moh, and is crushed

for abrasive use. Finely ground quartz is also used as a filler, and powdered quartz is employed as a flux in melting metals. When quartz is fused, it loses its crystalline structure and becomes a silica glass with a specific gravity of 2.2, compressive strength 7,000 psi, and hardness 5. Pure fused quartz is employed for crucibles and for tubes and rods for furnaces, as it will withstand rapid changes of temperature without breaking. Vitreosil, of the Thermal Syndicate, Ltd., is Fused quartz, containing 99.8% silica. It comes opaque, translucent, and transparent. It transmits ultraviolet and short wave lengths, has high electric resistance, and a coefficient of expansion about one-seventeenth that of ordinary glass.

Since quartz crystallizes more slowly than many other minerals, the natural crystals may include other minerals which were crystallized previously. Sagenite is a form of crystalline quartz containing hairlike crystals crossing in a netlike manner. A variety of fibered quartz with a pale amethyst color which shows deep red by transmitted light, found in Russia and Colorado, is called Onegite. Aventurine is a form of quartz crystal containing the inclusions in the form of flakes or spangles. It comes from the Ural Mountains and from India and is prized for gems. For cheap jewelry it is made synthetically in great quantities under the name of Goldstone by melting the inclusions into quartz glass. Amethyst, Topaz, and many other gem stones are quartz. The golden-yellow topaz of Mexico and Brazil is a type of quartz called Citrine. Inferior-colored amethysts may also be made into yellow or orange-colored citrine by heating. The Rose quartz of South Dakota is prized in the beautiful rose color, but in the large deposits the shades may run from milky white through pale pink to deep rose red. The best stones are used for gems, as are also the translucent pink crystals from Maine. Other grades are cut into vases, ornaments, and architectural facings. Chalcedony is a cryptocrystalline quartz with a waxy luster deposited in rock veins from colloidal solution, or in concentric rings on rocks. Its fibers are biaxial instead of the uniaxial of quartz. The chalcedony of South Dakota known as Beckite fluoresces under ultraviolet light. Chalcedony was an ancient gem stone, and was used for intaglios and seals and for figurines and vases. Some chalcedony from New Mexico and Arizona is stained and cut for costume jewelry. Chrysoprase is a translucent, apple-green variety of cryptocrystalline quartz colored with

hydrated nickel silicate found in Silesia. It is highly valued for mural decorations and as a gem stone.

The so-called massive topaz used as a refractory material instead of kyanite is not true topaz or quartz. The massive topaz mined in North Carolina contains about 50%  $\text{Al}_2\text{O}_3$  and 40  $\text{SiO}_2$ , with iron and iron oxide. When calcined for refractory use, it has the same composition as kyanite. The topaz from the wolframite mines of São Paulo, Brazil, used for refractories, has a high alumina content and a high fluorine content. The purer crystals have a melting point of  $1880^\circ\text{C}$ . The quartz known as Cristobalite, used as a refractory, differs from ordinary quartz only in the crystal structure. It has a melting point of  $3110^\circ\text{F}$ . Jasper is a variety of quartz colored red with iron oxide. It is cut and polished as an ornamental building stone. Egyptian jasper is brown in color with dark zones. In ancient times many of the gem stones were silica stones, and the Athiaenon stone from Cyprus was jasper of bright colors.

**Quartzite.** A rock composed of quartz grains cemented together by silica. It is firm and compact and breaks with uneven, splintery fractures. Most of the quartzites used are made up of angular grains of quartz and are light in color. Quartzite was derived from sandstones by intense metamorphism. Quartzite is employed for making Silica brick used for roofs of open-hearth steel furnaces. It is also used for abrasives, siliceous linings for tube mills, as a structural stone, and as a broken stone for roads. It is found as a widely distributed common rock. Medina quartzite, from Pennsylvania, contains 97.8% silica. The melting point is about  $1700^\circ\text{C}$ .

**Quassia.** Also known as Bitterwood. The wood of the Jamaica quassia tree, *Picroena excelsa*, and of the Surinam quassia, *Quassia amara*, of the West Indies and northern South America. The Jamaica quassia is a large tree, sometimes called Bitter ash because the leaves resemble those of the common ash. The wood is yellow, light, dense, and tough. It is odorless, but has an intensely bitter taste. The wood is imported mostly as chips for the production of the extract which is used in medicine as a bitter tonic, and also used in insecticides and in flypapers. It is also used as an ingredient in stock-feed tonics for cattle. In tropical countries the wood is valued for furniture, as it is

resistant to insects. The wood of the Surinam quassia is darker in color, heavier, and harder, but has similar properties.

**Quebracho.** The common name for the wood of the Quebracho colorado, or red quebracho tree, *Aspidospera quebracho*, found only along the west bank of the Paraná and Paraguay rivers in Argentina and Paraguay. It contains about 24% tannin, and is valued chiefly as a source of Quebracho extract. The wood is exceedingly hard and has a brownish-red color often spotted and stained almost black. Quebracho is valued as a firewood in Argentina, and is also used for crossties and posts, but is too brittle for structural work. It takes a fine polish and is very durable, carvings of this wood being in perfect condition after 300 years. The weight is 78 lb per cu ft. Quebracho extract is the hard, resinous substance extracted from the wood by boiling. It is brownish black in color and extremely bitter, and the solid extract contains 62% soluble tannins. One metric ton of wood yields about 250 kilos of solid extract. The liquid extract contains 25 and 35% tannin. It is employed in tanning leather and is rapid acting, but is seldom used alone as it makes a dark leather. It is mixed with alum and salt, or with chestnut extract. Some extract is used in boiler compounds, but one of the largest uses has been for the treatment of oil-well drilling muds. The Aerosol Q, of the American Cyanamid Co., is powdered quebracho and an organic colloid for oil-well muds. White quebracho, *Schinopsis lorentzii*, is a smaller tree than the red quebracho, growing over a wider area of Argentina, Brazil, and Paraguay. It produces a similar tannin. Some Urunday extract is produced in Argentina for export instead of quebracho. The urunday wood is red in color and very hard, but not as brittle as quebracho, and is valued locally for cabinetwork. The tannin from the wood is similar to quebracho extract.

**Radioactive metals.** Metallic elements which emit radiations that are capable of penetrating matter opaque to ordinary light. They give out light and appear luminous, also having an effect on the photographic plate. The metal radium is the most radioactive of all the elements, and practically its only commercial substitute is mesothorium. It is employed for luminous paints for dials and pointers of instruments and for the hands of watches. Other radioactive elements

are uranium, thorium, ionium, actinium, and polonium. These metals all have high atomic weight. The radiating power is atomic and is unaffected in combinations. Radium and other radioactive metals are changing substances. Radium gives out three types of rays; some of the other elements give out only one or two. The  $\gamma$ , or Gamma, rays are wave motion with waves shorter than the X rays below ultra-violet light. The  $\beta$ , or Beta, rays are believed to be streams of small negatively charged electrons. The  $\alpha$ , or Alpha, rays are believed to be the hearts of helium atoms carrying two positive electric charges. The emanations are all emitted at high velocities approaching that of light. The  $\alpha$  and  $\beta$  rays are deflected by magnetic fields. An aluminum screen completely absorbs the  $\alpha$  rays, while lead stops the  $\beta$  rays. After breaking up, the rays apparently go into the group of inert gases like argon and helium. By comparison of changing atomic weights, it has been deduced that the metal lead is the ultimate product, and uranium the parent metal under present existing stability conditions. But heavier metals, now no longer stable under present conditions, have been produced synthetically, notably plutonium. Radium has apparently a period of transfer of several thousand years, while mesothorium disintegrates in a little over 6.7 years, and polonium decays in a short time, losing half its weight in 140 days.

**Radium.** A peculiar radioactive element, symbol Ra, scattered in minute quantities throughout almost all classes of rocks. It was discovered in 1898 by Curie, and the first radium chloride was separated from pitchblende in 1902. Radium is only commercially obtainable from the uranium ores, monazite sand, carnotite, and uraninite, and is believed to be formed from the disintegration of uranium or ionium. In the Sudetenland section of Europe it is obtained from the residue of pitchblende after the extraction of thorium oxide, but most of the present supply comes from carnotite of the Belgian Congo and from the pitchblende of the Great Bear Lake region of Canada. One gram of radium and 7,800 lb of uranium are obtained from 370 tons of pitchblende. The ratio of radium to uranium in any uranium ore is always about 1:3,000,000. Radium is marketed in the form of bromides or sulphate in tubes and is extremely radioactive in these forms. In a given interval of time a definite proportion of the atoms breaks up with the expulsion of  $\alpha$ ,  $\beta$ , and  $\gamma$  rays. The most powerful ray is

the  $\gamma$ , which it is estimated has a million times the wave frequency of light. Radium is most widely known for its use in therapeutic medicine, but considerable of the production is employed in luminous paints for hands and pointers of watches and instruments, and for luminous signs. It is also used for making inspections of metal castings in place of X rays. Radium-beryllium powder is marketed by the U.S. Radium Corp. for use as a neutron source.

**Ramie.** A fiber used for cordage and for various kinds of coarse fabrics, obtained from the plant *Urtica nivea* of temperate climates, and *U. tenacissima*, of tropical climates. The former plant has leaves white on the underside, and the latter has leaves all green. The name Rhea is used in India to designate the latter species. It is also grown in China, Formosa, Egypt, Brazil, and Florida. The plants grow in tall slender stalks like hemp and belong to the nettle family. The bast fibers underneath the bark are used, but are more difficult to separate than hemp fiber owing to the insolubility of the adhesive gums. The fibers are eight times stronger than cotton, four times stronger than flax, and nearly three times stronger than hemp. They are fine and white, and are as silky as jute. They are not very flexible and are not in general suitable for ease of weaving, but their high wet-strength, absorbent qualities, and resistance to mildew make the fibers suitable for warp yarns in wool and rayon fabrics. The yarn is used also for strong, wear-resistant canvas for such products as fire hose. The fiber is also valued for marine gland packings and for twine. The composition is almost pure cellulose, and the tow and waste are used for making cigarette paper. China grass is the hand-cleaned but not degummed fiber. It is stiff and greenish yellow in color. Grass cloth is a woven fabric made in China from ramie. Swatow grass cloth, imported into the United States, is made of ramie fibers in parallel strands not twisted into yarns.

**Rape oil.** An oil obtained from the seeds of a species of the turnip, *Brassica campestris*, of which varieties are referred to as *B. rapa*, *B. napus*, *B. oleifera*, and *B. glauca*, grown in Europe, India, Canada, and Argentina. It is widely used as an edible oil, for making factice, and for mixing with lubricating and cutting oils and for quenching oils. The seeds are very small, an ounce including as many as 40,000 seeds. The seeds contain 40% oil. The edible oil is cold-pressed



and refined with caustic soda. The burning and lubricating oils are refined with sulphuric acid. The iodine value is about 100, the specific gravity is about 0.915, and the flash point 455°F. The oil contains palmitic, oleic, linoleic, and stearic acids, and 43 to 50% of a characteristic acid,  $C_{22}H_{42}O_2$ , called Brassidic acid or Erucic acid. Colza oil is a rape oil extracted from French seed, used to mix with mineral oils to make cutting oils. The name Colza now refers to any refined rape oil. Chinese colza oil, from the *B. campestris chinoleifera*, contains the mustard volatile oil. The specific gravity is 0.91, saponification value 174, and iodine number 100.3. From 15 to 20% of blown rapeseed oil is mixed with mineral oil for lubricating marine engines. Cameline oil, called also Dodder oil and German sesame oil, has the same uses as rape oil. It is from the plant *Camelina sativa* grown in central Europe. The seeds contain 35% oil which contains oleic and palmitic acids and also erucic acid, the characteristic acid of rape oil. The seed itself is high in mineral and protein content and is used in birdseed mixtures.

**Rare metals.** A term given by the U.S. Bureau of Mines to certain metallic elements that are rare in the sense that they are extremely difficult to extract from their ores and are rare commercially. These include the four elements Illinium, Masurium, Alabamine, and Virginium. The last is called Madavium in France. The silver-colored metal Technetium, symbol Tc, has been produced by bombardment of molybdenum with neutrons. Berkelium is element 97, produced by the cyclotron irradiation of americium with helium ions. All the ultraheavy metallic elements, such as plutonium, that are produced synthetically by bombarding heavy atoms with neutrons, are classed as rare metals. These metals are called Transuranic metals because they have a place in the periodic table beyond uranium, or are heavier than uranium. They are all radioactive. Illinium, also known as Florentium, was given the name Promethium when it was produced by uranium fission at Oak Ridge. Radium is also classed as a rare metal.

**Ratany.** Also known by the original Inca name of Payta, and in medicine as Krameria. The root of the shrub *Krameria triandria*, which grows in Peru and is used for tanning leather and in medicine as an astringent. The root comes in diameters up to 1 in., and in

pieces up to 3 ft in length. It contains about 40% tannin which is extracted by hot water. It gives the leather a deep-brown color, and is usually mixed with other tannins.

**Rattan.** The long slender stem of the palm *Calamus rotang* and other species, of Ceylon, Malaya, and Indo China. There are more than 40 varieties. The Malay word is rottan, meaning cane. It is tough, flexible, strong, and durable, and is used for canes, umbrella handles, and furniture. When split it is used for car seats, baskets, baby-carriage bodies, furniture, whips, and heavy cordage. Commercial rattans are in pieces 5 to 20 ft long. A substitute for rattan is Jacitará, from the plant *Desmoncus macroacanthus*, of Brazil. It is used for seating. Vinylidene chloride plastic is now widely used as a substitute for rattan for seating.

**Rayon.** A general name for artificial-silk textile fibers or yarns made from cellulose nitrate, cellulose acetate, or cellulose derivatives. The general name was adopted after the Federal Trade Commission had ruled against the use of such terms as Art silk, Fiber silk, Chardonnet silk, and Artificial silk. Some of the products are referred to preferably by the manufacturer's trade name such as Celanese, for cellulose-acetate yarns and fabrics. In general, the name rayon is limited to the viscose, cuprammonium, and acetate fibers, or to fibers having a cellulose base. Other Synthetic fibers take their own group names or special trade names, the protein fibers being known as azlon and the polymeric amide fibers as nylon. The strong, silklike English textile fiber known as Terylene is not a rayon, but is a polyester derived by combining the Terephthalic acid, obtained as a by-product in the production of phthalic anhydride from petroleum, with ethylene glycol. The fiber has properties similar to nylon. Fiber V, of E. I. du Pont de Nemours & Co., Inc., is this type of material.

Viscose rayon is made by treating the cellulose with caustic soda and then with carbon disulphide to form cellulose xanthate, which is dissolved in a weak caustic solution to form the viscose. With the cuprammonium process the cellulose is digested in an ammonia solution of copper sulphate, and the solution forced through the spinnerets into dilute acid for hardening. Rayons manufactured by the different processes vary both chemically and physically. They are resistant to caustic solutions which would destroy natural silk. They

are also mildewproof, durable, and easily cleaned. But they do not have the permeability and soft feel of silk. The acetate rayons are more resistant than the viscose or cuprammonium. The lack of permeability of the fibers is partly overcome by having superfine fibers so that the yarns are permeable. The one-denier viscose staple produced by the American Viscose Co. by stretching the fiber after it leaves the spinnerets is finer than Egyptian cotton and can thus be made into yarns that are permeable between the fibers. Fabrics made from the superfine yarns have the appearance of sheer silk. The objectionable high gloss of synthetic fibers is reduced by pigmentation. *Glos* was an early name for rayon because of this gloss, but the name has now been abandoned. Practically all types of dress fabrics and knitted hosiery and underwear are made from rayons. The material is also used for automotive tire fabrics because of its strength. Staple fiber is fiber cut to length for the spinning system to be used. The Lanese fiber of the Celanese Corp. of America is 3-, 5.5-, 8-, and 12-denier acetate rayon cut to lengths of  $1\frac{1}{8}$  to 2 in. Seraceta, of the American Viscose Corp., is a continuous-filament acetate rayon. Matesa is the name of continuous-filament cuprammonium rayon of the American Bemberg Corp.

**Red brass.** The standard wrought metal known as Red brass, or Rich low brass, of the brass mills contains 85% copper and 15 zinc. It is one of the most ductile and malleable of the brasses, and the working stresses can be relieved without softening the metal by heating for a half hour at 275°C. It is also valued for its fine reddish color, ability to take a high polish, and corrosion resistance. It is essentially a drawing and stamping metal and, unless it contains a little lead, will not machine well. The annealed metal has a tensile strength of 35,000 psi, with elongation 40%, while the hard-rolled metal has a strength of 65,000 psi, with elongation 5%, and Rockwell B hardness 75. The melting point is 1875°F, weight 0.316 lb per cu in., coefficient of expansion 0.0000104 per deg F, and electrical conductivity 34.7% that of copper. It is produced regularly in the form of sheets and tubes, and is used for jewelry, name plates, dials, drawn and stamped hardware and mechanical parts, and corrosion-resistant hot-water pipes. Plumrite 85, of the Bridgeport Brass Co., is this alloy in tubes for piping. Revere alloy No. 130, of the Revere

Copper & Brass, Inc., is this metal in sheets and tubes. Redalloy, of the Chase Brass & Copper Co., contains 85% copper, 14 zinc, and 1 tin. The tensile strength is 42,000 psi and elongation 48%.

The high-copper alloy known in the mills as Commercial bronze contains 90% copper and 10 zinc. It is widely used for making costume jewelry, weather stripping, stamped hardware, forgings, and screws. It has a bronze color, a weight of 0.318 lb per cu in., and electrical conductivity 43.6% that of copper. The tensile strength, soft, is 38,000 psi, with elongation 40%. The tensile strength of the hard-rolled metal is 60,000 psi and elongation 5%. Revere alloy No. 120 is this metal. Federal specifications for gilding metal call for this alloy, and it is also known as Government gilding metal. But standard Gilding metal employed for making cheap jewelry and small-arms ammunition contains 95 to 97% copper. It has a golden-red color, is stronger and harder than copper, but has only about half the electrical conductivity of copper. The English Cap copper, used for cartridge caps, has 97% copper and 3 zinc. BES gilding metal is in three grades, 80, 85, and 90% copper, but the 80-20 alloy has a definite golden-yellow color and is not in the class of red brasses. The 80-20 brass is one of the standard alloys of the brass mills under the name of Low brass. It was early used for jewelry under the name of Dutch metal. It is very ductile and is easily drawn, takes a high polish, and has high strength. It is still much used for cheap jewelry. Chain bronze, used for flat-link jack chains, and also for costume jewelry, contains 87 to 89% copper, 0.60 to 1.25 tin, and the balance zinc. The tin increases the hardness, and it has good strength and corrosion resistance.

Many old names used in England and the United States for designating the golden or reddish high-copper brasses, especially for cheap jewelry making, are still in occasional use. Pinchbeck metal, originally made by C. Pinchbeck, an English jeweler, contained 88% copper and 12 zinc. This is the same as the Guinea gold used for traders' jewelry. Manila gold, or Traders' gold, was about the same with some lead to heighten the color. Ormolu gold, a name still used by brass platers, was any composition that would give a golden color. Rich gold metal was the 90-10 alloy, and this alloy is still being used for decorative purposes such as for store fronts, under the name of Copper-rich brass. Mannheim gold, containing 83% copper, 10

zinc, and 7 tin, was a German alloy for cheap jewelry. It is a considerably harder alloy than ordinary red brasses. Tournay metal was a French alloy widely used for buttons when brass buttons were in vogue. It was essentially the same as the original Tombac metal used by the Chinese for buttons, and was the 85-15 alloy containing considerable arsenic to give a brilliant grayish tone to the metal. The alloy is quite brittle. The name tombac is the Malay word *tombaga* used to designate gold-colored jewelry alloys. Chrysochalk is another old name for gilding metal containing enough lead to give a dull gold tone. Japanese low-priced jewelry alloys often contained silver or gold to balance the color and make them resistant to tarnishing. Shadke was a high-copper alloy with some gold, and Shaku-do contained about 4% gold and 1 silver. The gold color of the red brasses is enhanced by pickling in nitric acid.

**Red lead.** A common lead pigment, also erroneously called minium. It is a lead tetroxide,  $Pb_3O_4$ , forming a bright-red or orange-red powder of specific gravity 0.096, insoluble in water. As a pigment it has great covering power and brilliancy, but red lead which has not been completely oxidized and contains litharge must be applied immediately after mixing to avoid combination with the oil. It is used as a heavy protective paint for iron and steel. Red lead is also used in storage-battery plates and in lead glass. With linseed oil it is used as a lute in pipe fitting. Orange mineral is a pure form of red lead made from white lead and has an orange color. Chemically it is the same as red lead, but it has a different structure, giving it a more brilliant color. Red lead is made from lead metal by drossing and then heating in a furnace. Fume red lead is a fine grade made from Fume litharge, which is made by oxidizing molten lead and passed off as a yellow smoke or fume. Fume red lead is notable for the extreme fineness of its particles, and has an apparent bulk much greater than ordinary red lead. Fume red lead is marketed for pigment as Superfine red lead.

**Redwood.** Also called Sequoia, California redwood, and Humbolt redwood. The wood of the tree *Sequoia sempervirens*, native to the west coast of the United States. The wood is light, soft, and spongy but has comparatively high strength and is resistant to decay and insect attack. The trees grow in a narrow coastal strip in Cali-

fornia, and are of an immense size, reaching a diameter of 20 ft and a height of 350 ft in 2,000 years. The so-called Big tree, however, is the *S. gigantea* or *S. washingtoniana*. It grows in the mountains at elevations of 5,000 to 8,500 ft, but is not cut for lumber. Planks of redwood can be readily obtained 6 ft in width. The specific gravity is 0.374 to 0.387. It has a tensile strength of from 7,000 to 11,000 psi. The heartwood varies from light-cherry to dark-mahogany color, and the narrow sapwood is almost white. The wood is used in all kinds of common construction. Redwood bark fiber is the shredded fiber of the bark of the redwood. It has excellent felting properties, is water-resistant and fire-resistant, and is an excellent insulator for house walls and refrigerators. It is also used in wool mixtures for blankets and overcoatings. The fiber is short, but has a natural twist that facilitates spinning. The fiber contains a high content of lignin, and makes a good filler for heat-curing plastics. Palco wool, of the Pacific Lumber Co., is redwood bark fiber. Redwood tannin, produced by soaking redwood chips in hot water and dissolving out the tannin with ethyl acetate, is used as an oxidation inhibitor in paraffin hydrocarbons.

**Refractories.** Substances employed where resistance to very high temperature is required, such as for furnace linings and metal-melting pots. They are composed largely of alumina and silica and are employed in the form of powder to be mixed like cement, or are in the form of bricks. They owe their properties largely to silica, magnesia, and alumina. Materials with a melting point above Seger cone 26, or 1580°C, are called refractory, and those with melting points above cone 36, or 1790°C, are called highly refractory.

Clay is the oldest and most common of the refractories. The natural refractories are kaolin, chromite, bauxite, zirconia, magnesite, often marketed under trade names. Refractories may be acid, such as silica, or basic, such as magnesite or bauxite, for use in acid- or basic-process steel furnaces. Graphite and chromite are neutral refractories. Magnesia fuses at 3929°F, chromite at 3722°F, and alumina at 3670°F. The fusing point of the refractory, however, is usually dependent on the binder, as all binders or impurities lower the melting point. The Arco refractory brick of the General Refractories Co., with 60 to 80% alumina, will withstand temperatures from 3290°

to 3335°F. The melting point of a 99.5% pure alumina is given as 3725°F, and the decomposing point of a 98% pure silicon carbide as 4175°F. Chrome-magnesite bricks are made usually with 75% chrome ore and 25 dead-burned magnesite.

The chief artificial refractories are silicon carbide and aluminum oxide. A refractory cement, marketed by the Carborundum Co. under the name of Carbofrax, is silicon carbide with a small amount of binder. Grade No. 4 vitrifies at 2460°F and will not fuse under 3300°F. The tensile strength at 2550°F is 1,750 psi. Refrax, of the same company, is composed of silicon carbide held together by crystallization. It will withstand temperatures up to 2240°C, at which point it decomposes. The crushing strength of the brick is 12,500 psi. This type of material can be made only in simple shapes. Aluminite is the name of an alumina refractory of the Philip Carey Co. furnished in blocks to withstand temperatures up to 2000°F. Good refractories should be of such a chemical composition that they do not fail below the melting point by great expansion or contraction, or by spalling, that is, by cracking from unequal expansion. A high-grade refractory for melting furnaces should withstand temperatures up to 3300°F and have high resistance to slag and chemical influences. Fire sand is a sand composed of 98% silica and is very refractory. The natural silica refractories used to replace fireclay for high temperatures should contain at least 97% silica and not yield too fine a powder on crushing. In order of merit the materials used are chalcedony, old quartzites, and vein quartz. The refractory known in Europe as Klebsand, used for steel furnace linings, has 87%  $\text{SiO}_2$ , 8.6  $\text{Al}_2\text{O}_3$ , 0.3  $\text{TiO}_2$ , and some ferric oxide. Ganister is a natural refractory mineral used for furnace linings. In compact form it was used for furnace hearths. It contains about 95% silica, about 1.5  $\text{Al}_2\text{O}_3$ , and a small amount of lime as a binder. The chief deposits are in the quartzites of Wisconsin, Alabama, and Colorado. An artificial ganister is made with silica and clay. Ganisand, of the Quigley Furnace Specialties Co., Inc., is a ganister having a fusing point at 3250°F. Dinas silica is an English ganister with about 97% silica, having a melting point of 1680°C.

Pinite, from Nevada, is a secondary mineral derived from the alteration of feldspar and other rocks, and is used for kiln linings in cement plants. It is a hydrous silicate of alumina and potash, and

the massive material resembles steatite. It will bond alone like clay and has low shrinkage. At 1125°C, the mineral inverts to mullite. Agalmatolite is a massive pinitite and can be used in the same way. Bull-dog is an old name for a refractory which is a mixture of ferric oxide and silica made by roasting tap cinder with free access of air. Tap cinder is a basic silicate of iron,  $2\text{FeO} \cdot \text{SiO}_2$ , which on roasting takes up oxygen.

**Refractory cement.** A large proportion of the commercial refractory cements used for furnace and oven linings and for fillers are fireclay-silica-ganister mixtures with a refractory range of 2600 to 2800°F. Cheaper varieties may be mixtures of fireclay and crushed brick, fireclay and sodium silicate, or fireclay and silica sand. An important class of refractory cements is made of silicon-carbide grains or silicon-carbide fire sand with clay bonds or synthetic mineral bonds. The temperature range of these cements is 2700 to 3400°F. Silicon-carbide cements are acid-resistant and have high thermal and electrical conductivity. For crucible furnaces the silicon-carbide cements are widely used except for molten iron. Alumina and alumina-silica cements are very refractory and have high thermal conductivity. Calcined kaolin, diaspore clay, mullite, sillimanite, and combinations of these, make cements that are neutral to most slags and to metal attacks. They are electrical insulators. Chrome-ore cements are difficult to bond unless mixed with magnesite. Plastic 695, of the Basic Refractories, Inc., is a Chrome-magnesite cement made of treated magnesite and high-grade chrome ore. It sets quickly and forms a hard and dense structure. The melting point is above 3600°F. It is used particularly for hot repairs in open-hearth furnaces. Magnefer is the name of a dead-burned dolomite refractory of the same company, while Basifrit is a magnesia refractory for resurfacing. Zircon-magnesite cement is made with 25% refined zircon sand, 10 milled zircon, 15 fused magnesia, and 50 low-iron dead-burned magnesite bonded with sodium silicate. A wide range of refractory cements of varying compositions and characteristics is sold under trade names, and these are usually selected by their rated temperature resistance. For example, Hadesite, of the Eagle-Picher Lead Co., is composed of refractory clay and aggregates, mineral wool, and a binder, and is recommended for temperatures up to 1900°F. Vitrobond, of the



Johnson Fuller Co., is a powder composed of zirconium silicate and high-melting oxides, which is sprayed or brushed on furnace walls in water solutions. It vitrifies at 2090°F, and will then withstand temperatures up to 3850°F.

**Refrigerants.** Gases, or very low-boiling-point liquids used for the heat-absorbent cycle in refrigerating machines. The ideal refrigerant, besides having a low boiling point, should be noncorrosive, noninflammable, and nontoxic. Ammonia is the most common refrigerant. Ethyl chloride, methyl ether, carbon dioxide, sulphur dioxide, and other chemicals are used as refrigerants. Freon, a colorless, odorless gas of the composition  $\text{CF}_2\text{Cl}_2$ , which liquefies at  $-21.7^\circ\text{F}$ , is a refrigerant. The gas is noninflammable. Other chlorofluoro derivatives of ethane and methane are also used as freons:  $\text{CCl}_3\text{F}$ ,  $\text{CHCl}_2\text{F}$ , and others. The freons are also used as carriers for insecticides. Genetron 101, of the General Chemical Co., has the composition  $\text{CH}_3\cdot\text{CClF}_2$ , with boiling point at  $-9.2^\circ\text{C}$  and freezing point at  $-130.8^\circ\text{C}$ .

**Resins.** An important group of substances obtained as gums from trees, or manufactured synthetically, as the phenol resins. The common resin of the pine tree is called rosin. The natural resins are soluble in most organic solvents, and are used in varnishes, adhesives, and various compounds. Oleoresins are natural resins containing essential oils of the plant. The synthetic resins are used chiefly for lacquers, varnishes, coatings, adhesives, and for molding mechanical and electrical parts. Some of the commercial resins are rosin, dammar, mastic, sandarac, frankincense, lac, and amine. Gum resins are natural mixtures of true gums and resins and are not as soluble in alcohol. They include gamboge, myrrh, rubber, gutta percha, and olibanum. Fossil resins are considered especially valuable, and owe their quality to the long formation period. These are amber, kauri, and copal.

Galbanum, used in medicine, is a gum resin from the perennial herb *Ferula galbaniflua* of western Asia. It comes in yellowish to brownish tears. Myrrh is a yellow to reddish aromatic gum resin from the *Commiphora malmol* and other species of small trees of India, Arabia, and northeast Africa. There are more than 80 species. The Hebrew word Mur means bitter, and the gum has a bitter

taste. It consists of a mixture of complex acids and alcohols but mainly the mucilaginous Arabin, with from 3 to 8% of a volatile oil of the formula  $C_{10}H_{14}O$ . It is used in incense and perfumes, and in medicine as a tonic. The gum is called Mulmul and Ogo in East Africa and Herabol in India. Sweet myrrh, or Bisabol myrrh, is a very ancient perfume and incense. It comes from the tree *C. erythraea* of Arabia. Herabol myrrh is from the small tree *C. myrrha* of India and is a brown to black solid. It is used in medicine as a stimulant and antiseptic and in perfumes and incense. Asafetida is a gum resin with a foul odor and acrid taste obtained from the roots of the perennial herb *F. assafoetida* and other species. It is used in Asia for flavoring foods, but in the United States is employed in medicines and perfumes. Creosote bush resin is an amber-colored, soft, sticky resin from the leaves and small twigs of the Greasewood bush, *Larrea tridentata*, or Creosote bush, *L. divaricata*, of the desert regions of the Southwest and Mexico. It is used in adhesives, insecticides, core binders, insulating compounds, and pharmaceuticals. When distilled, the resin yields Nordihydroguaiaretic acid,  $(C_6H_3 \cdot Cl \cdot COOH)_2CH_2$ , called NDGA, used as an antioxidant preservative in butter, lard, vegetable oils, and pharmaceuticals. It is a white crystalline solid with a melting point of  $184^\circ C$ , soluble in fats but only slightly soluble in hot water.

**Resistance wire.** The standard alloy for electrical resistance wire for heaters and electrical appliances is nickel-chromium, but nickel-manganese is also used; for high-temperature furnaces molybdenum wire is used. The alloy with 80% nickel and 20 chromium resists scaling and oxidation up to  $2100^\circ F$ . The alloy containing 60% nickel, 15 chromium, and 25 iron is resistant up to  $1830^\circ F$ , and the alloy with 30% nickel, 20 chromium, and 50 iron, is resistant to  $1560^\circ F$ . Molybdenum wire is used for temperatures up to  $2900^\circ F$ . For low temperatures, copper-nickel or nickel-iron alloys are used. A resistance alloy developed by the National Bureau of Standards, called Therlo, contains 85% copper, 9.5 manganese, and 5.5 aluminum. Fecraloy, of the Wilber B. Driver Co., contains 15% chromium, 5 aluminum, and the balance iron. It has high electrical resistance, and will withstand temperatures up to  $1400^\circ F$ . A silicon-manganese-nickel alloy is marketed by this company under the name

of Sparkaloy and is used for spark-plug wire. Hoskins alloy 667, known as Spark plug wire, of the Hoskins Mfg. Co., contains 4% manganese, 1 silicon, and the balance nickel. The resistance is 152 ohms per cir mil ft, specific gravity 8.4, and coefficient of expansion 0.0000151 in. per deg C to 500°C. Manganin, of the Wilber B. Driver Co., contains 70 to 85% copper, 2 to 5 nickel, and 12 to 15 manganese. It has a tensile strength of 70,000 psi and a resistance of 290 ohms per cir mil ft. It is used for coils and shunt wires in electrical instruments, and also in sheet form for instrument springs. Tophet A, of this company, is a standard 80–20 nickel-chromium alloy. The tensile strength is 120,000 psi and resistance 650 ohms per cir mil ft. Tophet C, containing 60% nickel, 16 chromium, and 24 iron, has a resistivity of 675 ohms and is used for temperatures up to 1920°F.

Calorite, of the General Electric Co., has 65% nickel, 8 manganese, 12 chromium, and 15 iron. Excellor metal, of H. Boker & Co., Inc., contains 85% nickel, 14 chromium, and 0.5 each manganese and iron. It is used in electric heaters for temperatures up to 2000°F. Alumel, of the Hoskins Mfg. Co., intended for temperatures up to 1250°C, has 94% nickel, 2.5 manganese, 0.5 iron, and small amounts of other elements. Calido, of the Driver-Harris Co., contains 59% nickel, 16 chromium, and 25 iron. Nichrome V, of this company, is the 80–20 alloy. Nichrome S contains 25% nickel, 17 chromium, and 2.5 silicon. It is marketed in sheet form for temperatures up to 1800°F. Comet metal, of the same company, used for rheostats, contains 30% nickel, 5 chromium, and the balance iron. It has high strength, up to 160,000 psi, and a resistivity of 570 ohms. The Driver-Harris resistance alloy known as Karma contains 20% chromium, 3 iron, 3 aluminum, 0.30 silicon, 0.15 manganese, 0.06 carbon, and the balance nickel. Its melting point is 2552°F, resistivity 800 ohms, and the annealed wire has a tensile strength of 130,000 psi with elongation 25%. Hytemco, of this company, is an iron-nickel alloy used for low-temperature wire. The resistance is 120 ohms per cir mil ft. Magno is a 95% nickel, 5 manganese alloy of this company; Climax metal has 74% iron, 25 nickel, and 1 manganese. A Swedish alloy without nickel, used as a substitute for nickel-chromium-iron alloy, is Kanthal, containing 23% chromium, 5 aluminum, 1.8 cobalt, and the remainder iron. The Kanthal alloys mar-

keted as wire and ribbon by the C. O. Jeliff Mfg. Co. have 20 to 25% chromium with some cobalt and aluminum, and the balance iron. Copper-manganese alloys have high resistivity, one with 96 to 98% manganese having a resistance of more than 1,000 microhms per cu cm. But when the manganese content is high, they are brittle and difficult to make into wire. Addition of nickel makes them ductile, but lowers the resistivity. A typical alloy contains 35% manganese, 35 nickel, and 30 copper. The casting alloys are hardenable by heat-treatment. A casting alloy of the Imperial Chemical Industries, Ltd., contains about 10% nickel, 10 manganese, and 1 iron.

**Resorcinol.** A colorless crystalline material with the composition  $C_6H_4(OH)_2$ , melting point  $110^{\circ}C$ , very soluble in water and in alcohol. It is used in the production of plastics, in the manufacture of fluorescein, in the production of xanthane and azo dyes, particularly the fast Alsace green, in medicine as an antiseptic, and in making the explosive lead styphnate. Resorcinol polymerizes with formaldehyde to form the Resorcinol-formaldehyde plastics that will cure at room temperature and with only slight pressure. They are used in strong adhesives for plywood and wood products, and do not deteriorate from acid action like some other plastics. Resorcinol adhesives remain water-soluble during the working period for 2 to 4 hr and are then insoluble and chemical-resistant. Pencolite G-1215, of the Pennsylvania Coal Products Co., is a resorcinol-formaldehyde adhesive that cures at  $75^{\circ}F$  and gives a bonding strength of 3,000 psi. The resorcinol adhesives may be modified with phenol to reduce cost and still retain the low-temperature setting. Phenac 703, of the American Cyanamid Co., is a phenol-modified resorcinol resin used as an adhesive for plywoods.

**Rhenium.** An elementary metal, symbol Re, present in small quantities in many minerals. Rhenium has a specific gravity of 21.4, and a melting point of  $3440^{\circ}C$ , or higher than that of tungsten. It has a silvery-white color, is hard but ductile and malleable, and takes a high polish. The metal is obtained from molybdenite, which usually has from 2 to 20 parts per million, but some concentrates contain as high as 90 parts per million. It is precipitated from molybdenite flue dust in the form of Potassium perrhenate,  $KReO_4$ , which is reduced by hydrogen to the metal, 1 lb of rhenate yielding 0.6 lb of metal.

Rhenium is also found in the Ural platinum ores. The metal is resistant to many acids, but is soluble in nitric acid. As a plating metal it gives a hard white deposit, but darker than that of rhodium. Some rhenium is used in radio tubes and as a catalyst.

**Rhodium.** A rare metal, symbol Rh, found in platinum ores. It is very hard and is one of the most infusible of the metals. The melting point is 3542°F. It is insoluble in most acids, including aqua regia, but is attacked by chlorine and hot fuming sulphuric acid. The specific gravity is 12.44. Rhodium is used to make the nibs of writing pens, resistance windings in high-temperature furnaces, for the points of thermocouples, as a catalyst in the oxidation of ammonia to nitric acid, for laboratory dishes, and for electroplating jewelry and electric appliances, surgical instruments, electronic contacts, and infrared reflectors. The plated metal has a pinkish-white luster of high brilliance and corrosion resistance, and a hardness of 775 to 820 Vickers. The metal is malleable at temperatures above 800°C. It forms a solid-solution alloy with platinum that is easily workable and does not tarnish or oxidize at high temperatures. These alloys are used for thermocouples, and sometimes for chemical apparatus. Rhodium is sold by the troy ounce, 1 cu in. weighing 6.56 troy oz.

**Rice.** The white seed of the large annual grass *Oryza sativa*, growing to a height of 2 to 4 ft. It is a tropical plant native to Asia, but grows in hot, moist regions well into the temperate zones and is cultivated in many parts of the world. Rice fields are flooded after planting to control weeds. The rice seed grows in an inflorescence composed of a number of fine branches each terminating in a single grain enclosed in a brown husk. There are more than 2,000 listed varieties. Rice forms the staple food of more than half the population of the world. Wild rice was used by the Indians of North America before the first Asiatic rice was brought to South Carolina in 1694. Rice is high in starch and low in proteins. It is used as a direct food, also as flour, cereal, in puddings, and for the manufacture of starch and for alcoholic beverages. Rice hulls are used as stock feed, and Rice straw is used for packing, hats, and other articles. Rice in the husk before hulling is known by the Hindu name of Paddy. Brown rice is rice that has been cleaned but not polished. A hundred pounds of paddy yields 62 lb of cleaned rice, while 100 lb of brown rice yields

91.3 lb of polished rice. Broken grains are sold in the India trade as Coodie or Khoo, and about 20% of the rice produced from paddy is broken. Patna rice does not refer to the Patna district of India, but to a variety of rice with bold and hard grains especially suited for soups as it holds its shape in boiling. Malekized rice, developed by the General American Transportation Co., is produced by steaming unpolished rice to force the soluble part of the bran and the vitamins into the core of the grain, and then sealing the rice kernel by gelatinization, after which it is polished. The treated rice holds its shape and does not become gummy when cooked, and the nutritional value is improved. The beverage known in Japan as Saké is Rice wine made by fermenting the rice with a mold, Tané koji. The wine contains 13 to 14% alcohol. Rice oil is produced by solvent extraction from rice bran, 100 lb of bran, or hulls, yielding 15 lb of oil. It is similar to peanut oil, and is used as a salad oil.

**Roscoelite.** One of the most important ores of vanadium produced in the United States. It is a muscovite mica in which part of the aluminum has been replaced by vanadium. It occurs in micalike scales varying in color from green to brown. It has a specific gravity of 2.9. The ore mined in Colorado contains about 1.5% Vanadium oxide,  $V_2O_5$ , and this oxide is extracted and marketed for making ferrovanadium and vanadium compounds.

**Rosewood.** The wood of several species of *Dalbergia* of northern South America, but chiefly from the Jacaranda tree, *D. nigra*. It is used for fine cabinetwork, pianos, novelties, and expensive furniture. It should not be confused with the wood of the tree *Physocalymma floridum*, which also comes from Brazil and is there called Pao rosa or rose wood. The color of rosewood is dark brown to purple, and it takes a beautiful polish. It has a characteristic fragrance. It is very hard and has a coarse, even grain. The weight is 54 lb per cu ft. The tree grows to a height of 125 ft. Another Brazilian wood, Caroba, from the large tree *Jacaranda copaia*, is also called Jacaranda and is sometimes confused with rosewood. The tree has purple flowers while the true rosewood has white flowers. Caroba wood is chocolate-colored, and is used for fine furniture and knife handles. Indian rosewood is from the tree *D. sissoo* of India. It is also called Sissoo, and is a beautiful, brown hardwood employed for carvings. In Europe

it is also used for parquet floors. Borneo rosewood, also known as Ringas, is the wood of several species of trees of the genus *Melanorrhoea* of Borneo. The wood has a deep-red color with light and dark streaks. It has a close texture suitable for carving. Satinee is a type of rosewood from the tree *Ferolia guianensis* of the order *Rosaceae*, native to tropical America, particularly the Guianas. The wood is reddish brown, weighs 54 lb per cu ft, is fairly hard, has a fine grain, and takes a lustrous polish. It is used for cabinetwork. Bois de rose oil, or Rosewood oil, is not from rosewood, but is extracted from the heartwood of the tree *Aniba panurensis* of Brazil and the Guinas, though the wood of this tree is also used as a cabinetwood. The oil is also called Cayenne linaloe, or Cayenne oil. It has a delicate rose odor with a suggestion of orange and mignonnette valued in perfumes. It contains a high percentage of Linalol, a colorless alcohol with a soft, sweet odor, also found in the rose, lilac, lily, lavender, petitgrain, and other plants. It also contains geraniol. Linaloe oil, or Mexican linaloe, is distilled from the heartwood of the trees *Bursera delpechianum* and *B. aloexylon*. It contains less linalol and also terpineol and geraniol. Linalol is closely related to geraniol and nerol. Bois de rose is also made synthetically from geraniol. Oriental linaloe is distilled from selected highly perfumed parts of the wood of the large tree *Aquilaria agallocha* of eastern India, Burma, and Java. The odor of the oil is like rose, ambergris, and sandalwood. Like the linaloes of the American continent the oil is a pathological product and comes only from old trees. It is also called Aloe wood oil and Agar attar, and is a very ancient perfume. The beautifully figured and fragrant reddish wood of this tree, called Aloes wood, Eagle wood, and Paradise wood, is used for ornamental articles. True original rosewood oil known as Rhodium oil was distilled from the wood of the plant *Convolvulus scoparius* of the Canary Islands.

**Rosin.** The common resin of several varieties of the pine tree, found widely distributed in North America and Europe. It is obtained by cutting a longitudinal slice in the tree and allowing the exudation to drip into containers. The liquid resin is then distilled to remove the turpentine, and the residue forms what is known as Gum rosin. Wood rosin is obtained by distillation of the wood, and is inferior for most purposes. Rosin contains seven acids with very

similar characteristics, but consists chiefly of Abietic acid,  $C_{19}H_{29}COOH$ . The specific gravity of rosin is about 1.08, and the melting point is 100 to 140°C. Rosin is soluble in alcohol, turpentine, and in alkalis. It is used in varnishes, paint driers, soluble oils, paper sizing, belt dressings, and as a filler for other resins. The rubber industry uses large amounts annually, and gum rosin is also used with rubber in nonvulcanizing cements.

Rosin is generally graded commercially by letters according to color. The darkest grade is B, and the lightest is W. Extra grades are A, nearly black, and WW, water white. Thirteen color grades are designated under the Naval Stores Act. The dark grades of wood rosin are considered inferior. They have high melting point and low acid number and are used for making rosin oil, for battery wax, thermoplastics, dark varnish, and for linoleum manufacture. The ruby-red wood rosin, obtained by extraction from fat pine wood, has high acid number, 155, and low melting point, 175°F. It is used for printing inks, paper size, and adhesives. Rosin is usually marketed in wooden barrels. A barrel of rosin under Georgia law is 280 lb. Naval stores is a name given to rosin and turpentine. Colophony is a chemical name for rosin before the distillation of rosin oil. It was referred to by early writers as Greek pitch, but the so-called Greek fire, used by the ancients as an incendiary material, was described as tow and pine sawdust impregnated with powdered rosin, pitch, and sulphur. Burgundy pitch is a name now used for rosin and mineral oil, used for friction tape and for compounding with rubber. It is amber-colored, has a specific gravity of 1.04, and a melting point of 212°F. But the name Burgundy pitch was originally applied to the resin of the Norway spruce, *Picea abies*, used in medicine.

Hardened rosin is a weak resinate made by adding 6 to 8% high-calcium lime to melted rosin. It is used in some varnishes. Fosfo rosin, of Newport Industries, Inc., is a Lime-hardened rosin. It is an FF rosin treated with 4.75% calcium hydrate, which raises the melting point, decreases the free rosin acids, and decreases the tendency to crystallize. It is used in paints, varnishes, and molded products. Soda-treated rosins, with about 1%  $Na_2O$ , but no free alkali, are used for soap, paper size, and disinfectants. Rosin size is alkali-treated rosin in dry powder or emulsion forms for sizing paper. Dresinite is such a sodium or potassium salt of rosin. Rosin ester, or



Ester gum, is prepared by heating rosin with glycerin. It is lighter in color than rosin, has a higher softening point, and a much lower acid number, usually 7 to 9. It is used with tung oil in enamels and varnishes and in adhesives. Resin V, of the Advance Solvents & Chemical Corp., is a rosin glycerin ester gum. Rosin esterified with glycerin has lower molecular weight, and is not as stable as rosin esterified with pentaerythritol or other tetrahydric alcohol. Hydroabietyl alcohol, used as a plasticizer and tackifier for rubber and for sizing textiles, is a colorless, tacky liquid made by reduction of rosin. The 85% alcohol has a specific gravity of 1.008, and a flash point of 187°C.

Hydrogenated rosin has greater resistance to oxidation than common rosin, has less odor and taste, and has a pale color that is more stable to light. It is used in protective coatings, paper size, adhesives, in soaps, and as a tackifier and plasticizer in rubber. Because of its saturated nature it cannot be used for rosin-modified plastics. The average acid number is 162, saponification value 167, and softening point 157°F. Stabelite resin, of the Hercules Powder Co., may be glycerol ester or ethylene glycol ester of hydrogenated rosin. Vinsol resin is a hard, high-melting, dark resin produced from the distillation of wood, or is the black residue left after rosin is extracted with petroleum solvents. It is soluble in alcohols, has a melting point of 115°C, and is used for insulating varnishes where light color is not essential, and for compounding in thermoplastics. Abalyn, of the Hercules Powder Co., is a name for the methyl ester of abietic acid, Methyl abietate, made by treating rosin with methyl alcohol. It is a liquid resin used as a plasticizer. Herculyn is Abalyn hydrogenated to saturate the double bonds with hydrogen. Flexalyn, of this company, is a pale-colored, very tacky, semisolid resin produced by the esterification of rosin acids with diethylene glycol, and has a complex chemical structure. It is used in adhesives to give added tack and strength. The Pentalyn resins of the Hercules Powder Co. are pentaerythritol esters, the Pentalyn M is a phenol-formaldehyde modified pentaerythritol ester. It has a melting point of 165°C, and when used in linseed oil varnishes gives a tough coating. The Lewisol resins of this company are maleic alkyd modified esters.

Rosin is hardened by polymerization to form a dipolymer of abietic acid. The product is then pale in color, and has a lower acid number

and a higher melting point than rosin. Poly-pale resin, of the Hercules Powder Co., is a polymerized rosin with melting point of 208 to 217°F, acid number 152 to 156, and saponification value 157 to 160. It can be substituted for natural copals in paints, and in gloss oil it gives water resistance and high viscosity. In the making of metallic resins it gives higher melting points, higher viscosity, and better solubility than natural rosin. Nuroz is a polymerized rosin of Newport Industries, Inc., with a melting point of 76°C and acid value 161. It has high resistance to oxidation, and is used in varnishes and soaps.

**Rosin oil.** An oil produced by the dry distillation of rosin at a temperature of 200 to 360°C. There are two qualities of the oil: a light spirit, Pinolin, which forms from 1 to 5% of the rosin, and a bluish, heavy oil, which forms 80 to 84%. It contains abietic acid and has an acid value of about 28. The commercial oil has a specific gravity of 1.020 with a flash point 160 to 170°C. The refined oil is a yellow liquid with a pleasant odor and is used for blending with turpentine. It is also employed as a plasticizer in rubber, as a tack producer in rubber cements, and in synthetic molding resins. When treated with lime, it may be used to mix with lubricating oils. The light distillate is used sometimes in pharmacy under the name of Oil of amber. Blended rosin oil is a mixture with mineral oils.

**Rottenstone.** A soft, friable, earthy stone of light-gray to olive color, used as an abrasive for metal and wood finishing. It resembles Missouri tripoli, and is derived from the weathering of siliceous-argillaceous limestone, with generally from 80 to 85% alumina, 4 to 15 silica, and 5 to 10 iron oxides. Rottenstone was largely imported from England, but a variety is found in Pennsylvania. It is finely ground and is marketed either as a powder or molded into bricks. The latter form is used with oil on rag-wheel polishing. A 250-mesh powder is used as a filler in molding compounds.

**Rouge.** A hydrated iron oxide used for polishing metals. It has a hardness of 5.5 to 6.5, and is made by calcining ferrous sulphate and driving off the sulphur. The color is varying shades of red; the darker the color, the harder the rouge. The grains are rounded, unlike the grains of crocus. The pale-red rouge is used for finishing operations;

the other grades are used for various polishing of metal surfaces. Stick rouge is made of finely crushed powder. Although the word rouge means red, materials of other colors are used for buffing and are called rouge. Black rouge, also called Glassite, is magnetic oxide of iron made by precipitating ferrous sulphate with caustic soda. It is used for buffing but is not popular because it stains the skin. Green chrome rouge is Chromium oxide,  $\text{CrO}$ , made by the strong heating of chromic hydroxide. It is used for buffing stainless steels. When used as a paint pigment, it is called Guignet's green. Satin rouge is a name applied to lampblack when used as a polishing medium in the form of brick for polishing silverware. Crocus is a name applied to mineral powders of a deep-yellow, brown, or red color made into cakes with grease for polishing. Polishing crocus is usually red ferric oxide. Crocus cloth is a fabric coated with red iron oxide marketed in sheets and used for polishing metals.

**Rubber.** A gum resin exudation of a wide variety of trees and plants, but especially of the tree *Hevea brasiliensis* and several other species of *Hevea* growing in all tropical countries and cultivated on plantations in southern Asia, Indonesia, Ceylon, Belgian Congo, and Liberia. The International Rubber Regulation Committee figured costs and allocations on a basis of a rubber yield of 400 lb per acre per year, but the American plantations in Malaysia yield an average of 900 lb per acre, and yields up to 1,200 lb are not uncommon. To produce the best yielding trees three species may be grafted together. One species that is a strong producer of roots is used for the seedling; a second high-yielding species for the latex trunk; and a third species resistant to leaf disease for the foliage. The *H. rigidifolia*, native to Brazil, is a tree resistant to leaf-spot disease, but yields little rubber.

The gum resin was formerly referred to as India rubber, and the name given it by Charles Goodyear was Gum elastic. The first highly compounded rubber for insulation, developed in 1867, was called Kerite. Brazilian rubber is sometimes called Para rubber. Caoutchouc is an early name for crude rubber. The milklike juice, or latex, is dried over a fire into a dark, solid mass for shipment, but latex is also shipped. Castilla rubber, sometimes erroneously called Castilloa, is from the very large tree *Castilla elastica*. It was the original rubber of the Mayan and Carib Indians, but was cultivated only in Mexico,

although it has been produced in Panama and called Panama rubber. The latex and rubber are identical with Hevea rubber after purification. Euphorbia rubber is from vines of the genus *Euphorbia* of which there are 120 species in South Africa.

Considerable Mangabeira rubber was produced in the Amazon Valley during the Second World War. It is the latex of the Mangabeira tree, which comprises various species of the genus *Hancoria* and yields the edible fruit Mangaba. The latex is coagulated with alum or sodium chloride, but the native Indians coagulated it with the latex of the Caxiguba tree, *Ficus anthelmintica*, giving a better rubber. The rubber is softer than hevea rubber, but ages better. The low-grade Assam rubber is from a species of Ficus tree, *F. elastica*, of India and Malaya. Ceara rubber comes from the small, rapid-growing tree, *Manihot glaziovii*, native to the semidesert regions of Brazil but now grown in India and Ceylon. The rubber is of good grade.

Crude rubber is usually marketed as crepe or ribbed smoked sheet in various grades. Rubber has the property of being vulcanized with sulphur, making it harder, and more elastic in the low-sulphur compounds. The ordinary Soft rubber contains only from 3 to 6% sulphur, and may also contain factice or other softening medium, giving varying degrees of elasticity, flexibility, and resiliency. When 30% sulphur is added and heated, hard rubber is formed. Vapor-cured rubber is rubber vulcanized by sulphur chloride fumes and neutralized with magnesium carbonate. It is used for thin goods only. Acid-cured rubber is rubber cured in a bath of sulphur chloride in a solvent. About 75% of the rubber consumed in the United States normally goes for automotive tires, but there are innumerable other uses of rubber for molded goods, adhesives, elastic products, and water-proofings. The great value of rubber is its flexibility and elasticity, but it also is valued for its adhesive properties and its water resistance. The tensile strength of rubber of low vulcanization is 800 to 1,200 psi of the original cross section.

All commercial rubber is vulcanized, but when the term Vulcanized rubber is used it generally refers to Hard rubber that has been vulcanized to a rigid but resilient solid. It is used for electrical parts and tool handles. The amount of sulphur used may be as great as 33%, and the hardness depends on the sulphur content. If too highly vulcanized, the material is fragile. Usual tensile strengths are from 3,500

to 6,500 psi, with specific gravities from 1.11 to 1.4. and Scleroscope hardnesses from 45 to 70. Ordinary commercial grades, marketed in sheets, rods, and tubes, can be machined readily. It resists the action of organic oils, but is softened by mineral oils. The dielectric strength is usually better than most plastics, and cost is generally lower than plastics. Ace hard rubber, of the American Hard Rubber Co., in sheet form, has a specific gravity of 1.27, tensile strength 8,700 psi, dielectric strength 485 volts per mil, distortion temperature 172°F, and water absorption as low as 0.04. Vulcanite and Ebonite are old names for hard rubber. Synthetic hard rubber was made during the war from GR-S rubber and called GR-S ebonite. It does not produce a smooth, nonshrinking sheet like natural hard rubber, is not as tough, and is subject to chipping when machined, but the strength and hardness are greater. A natural hard rubber can be bent 90°, but synthetic hard rubber will break at a 20° bend, and plasticizing to correct the brittleness gives cold flow. In the vulcanization of natural rubber a part of the sulphur is taken up by the molecule forming cross linkage and not acting as a filler or mechanical hardener.

For the rubber used in making automobile tires large percentages of carbon black and zinc oxide are used to reinforce it and give added wearing qualities. Rosin and other resins and gums impart softness to rubber compounds. Carbon black gives wear resistance. Zinc oxide is an accelerator as well as a filler and strengthener. Litharge, lime, and magnesia stiffen rubber and speed up vulcanization. Calcium carbonate increases strength and tear resistance. Red rubber is now simply rubber colored red, but was originally rubber vulcanized with antimony pentasulphide which broke down with the heat of vulcanization yielding sulphur to the rubber and coloring it red with the residual antimony trisulphide. Many trade-named accelerators, fillers, and stiffeners are marketed for rubber compounding. Cycline oil, of the Monsanto Chemical Co., is a mixture of vegetable and mineral oils for softening molding rubbers. Tackol is a mixture of oils and resins used as a rubber plasticizer. Trimene, of the Naugatuck Chemical Div., U.S. Rubber Co., is an aldehyde amine with stearic acid, used to aid the cure and to stiffen rubber. Whiting, clay, and barites are used as fillers, but many of the fillers also give added properties to the rubber.

Rubber contains Isoprene,  $C_5H_8$ , which is the building unit of

balata, gutta percha, and many other rubberlike materials. Isoprene can be made from turpentine or from petroleum, and at least small amounts are needed in all synthetic rubbers to increase elasticity, impart tack, and aid the curing. The exact composition of rubber is not fully determined, but natural rubber contains as many as 4,500 isoprene groups and may have a molecular weight as high as 300,000. It is, therefore, a Polyisoprene, and the vulcanization with sulphur introduces relatively few chemical bonds between the polyisoprene molecules. Rubber is a strong network of molecular chains that are not easily packed together or frozen into crystals by attraction on each other. The elastic property is like that of a gas, the pull on a piece of rubber stretching the molecular chains.

The so-called Synthetic rubbers are not rubbers, but are rubberlike products. They do not have the elasticity of rubber, but are more resistant to aging, heat, oils, and chemicals, and are stronger. Some of them, also, have stronger adhesive qualities. They have advantages over rubber for many products where the lesser elasticity is not important, and in mixtures with natural rubber they often form products with the characteristics of both. The original Butadiene rubber was produced in Germany from butane gas by conversion to butadiene and then reacted with styrene to form the Buna S rubber or with a nitrile to form the Buna N rubber. There are at least six general types of Synthetic rubbers: Chloroprene polymers, such as Neoprene; Butadiene polymers, such as Buna; Organic polysulphides, such as Thiokol; Isobutene polymers, such as Vistanex; Vinyl chloride polymers, such as Koroseal; and Dimethyl butadiene polymers, such as Methyl rubber. In general, these rubbers are made in two steps, by manufacture of the monomer, and then by polymerization or condensation.

The original Buna type of rubber made in the United States during the war, and called GR-S, or Government rubber-S, contained 76.5 parts butadiene and 23.5 styrene. It was an irregular molecular combination with inconsistent chemical and physical properties. It was difficult to work, the elasticity was low, and the heat build-up high. Control of the molecular chain and cross-linking, new polymer combinations, and improved plasticizers and reinforcing agents, resulted in a greatly changed rubber. Though retaining the same name, the present GR-S rubber is a different product from the

original. Cold rubber is GR-S rubber polymerized at 41°F or lower, instead of at the usual 122°F, and with chemicals to accelerate the cold reaction. The rubber is easy to process, has higher elongation, and has increased crack and abrasion resistance. In tires it does not have heat build-up like ordinary GR-S rubber. Philprene of the Phillips Petroleum Co., is a cold rubber with 24% styrene. High-styrene rubbers are light in color and tough. They are used for coatings or for compounding with other rubbers. Pliolite S-3, of the Goodyear Tire & Rubber Co., for coatings, is a butadiene-styrene copolymer with 85% styrene. It is thermoplastic, and is compatible with natural and synthetic rubbers. Pliolite latex 190 is a water dispersion of the high-styrene rubber for coatings and for reinforcing rubber stocks. Darex X-34, of the Dewey & Almy Chemical Co., is a buna rubber with a very high styrene content, used for compounding. Goodrite resin 50, of the B. F. Goodrich Co., is also a high-styrene rubber in powder form for compounding with natural or synthetic rubbers to increase hardness and impact strength, improve the workability, and improve electrical properties. Nitrex, of the U.S. Rubber Co., is a butadiene-acrylonitrile latex for coating paper and textiles. It is thermoplastic and heat-sealing.

Neoprene, formerly called Duprene, of E. I. du Pont de Nemours & Co., Inc., is a chloroprene rubber and has various grades, or polymers. It is a rubberlike material but is more resistant to oils and chemicals than rubber. It is also stable to light and aging and is more heat-resistant than rubber, but the elasticity is less. It is not vulcanized with sulphur but is self-curing by polymerization. It is valued for hose, gaskets, belting, molded goods, coated fabrics, and adhesives. The specific gravity is 1.25, but with fillers it ranges from 1.4 to 1.8. The tensile strength is 200 to 4,000 psi, depending upon the polymer and the fillers. This material produced in Russia is called Sovprene. Neoprene type RT is an interpolymer of chlorobutadiene and styrene. It is resistant to crystallization at temperatures down to -20°F, but is otherwise similar to normal Neoprene in physical and chemical characteristics.

Thiokol, of the Thiokol Corp., is an olefin polysulphide reaction product, which can be vulcanized like rubber and is used for molded products, wire covering, and coatings. Thiokol A is made by the reaction of sodium tetrasulphide and ethylene dichloride. Resenit is

a Russian polysulphide, and Vulcaplas is a similar English rubber. Koroseal, of the B. F. Goodrich Co., is a polymer of vinyl chloride, and is used for gaskets, fabric impregnation, and cable sheathing. The strength is from 1,000 to 7,000 psi, depending upon the amount of plasticizer. The dielectric strength is 250 to 850 volts per mil. In solution this material, known as Korolac, is used for lining acid tanks and covering plating racks. It is resistant to acids. Korogel is highly plasticized Koroseal.

Chloroprene, a colorless liquid,  $\text{CH}_2\text{:CHCl:CH}_2$ , produced from acetylene, can be polymerized to form a wide variety of products from soft rubberlike plastics to hard, horny, inelastic, and insoluble polymers. The polymerization can be controlled to yield rubber-like materials with some characteristics superior to natural rubber.

Vistanex, known first in Germany under the name of Oppanol, and further developed by the Standard Oil Co., is a polymer of isobutylene, a petroleum hydrocarbon. It is not elastic like rubber, but has good electrical properties, is resistant to oils and chemicals, and has heat and wear resistance. It is especially valuable when compounded with natural rubber. It is used for insulation, packings, gaskets, and hose. Butyl rubber is a copolymer of butadiene and isobutylene derived from petroleum. This rubber was called Ameripol by the B. F. Goodrich Chemical Co. Inner tubes are now made of Butyl rubber as it lasts longer and retains air pressure better than natural rubber. The Hycar of this company is a Nitrile rubber, or acrylonitrile-butadiene copolymer. Hycar OR-15 is this rubber in fine powder form for blending with phenolic resins to give greater toughness and resilience to the molded parts. Royalite, of the U.S. Rubber Co., formerly known as Versalite, is a copolymer of butadiene and acrylonitrile, and styrene and acrylonitrile. It is thermoplastic, with tensile strength of 4,800 psi, elongation 30%, and is resistant to chemicals. It is marketed in smooth, grained, or patterned sheets for molding into such articles as luggage and radio cabinets. The Enrup of this company is a high styrene-butadiene copolymer with a phenolic resin. It has a combination of strength, toughness, light weight, and chemical resistance, making it suitable for gears, pump parts, plating barrels, and electrical insulation. The specific gravity of the molded part is 1.3, tensile strength 4,200 psi, and dielectric strength 500 volts per mil.



Methyl rubber, or methyl chloroprene, was made by Bayer & Co. Perduren is a Buna rubber of I. G. Farbenindustrie. Mustone is a Japanese Chloroprene rubber. Perbunan is a butadiene rubber of the Standard Oil Development Co. Chemigum is a rubber derived from petroleum with patents held by the Goodyear Tire & Rubber Co. It is easier to process and cheaper than Buna rubber. Tervan is Vistanex mixed with paraffin wax, used for blending with microcrystalline wax to improve the adhesion and water resistance of paper coatings. Agripol, of the Reichhold Chemicals, Inc., is a rubber substitute made from soybean oil-fatty acids polymerized with ethylene glycol. It vulcanizes somewhat like rubber and it is compounded with sulphur, carbon black, zinc oxide, and plasticizers. It is flexible, and is used for mechanical applications. Norepol rubber, developed by the U.S. Department of Agriculture, is made by the polymerization of the linoleic acid from soybean, linseed, or peanut oils. Lactoprene rubbers are polymers of ethyl acrylate. Hycar PA, of the B. F. Goodrich Chemical Co., is a polyacrylic ester that resembles pale crepe rubber in appearance and is resistant to heat, oils, and chemicals. It is used for hose, belting, wire insulation, and as an impregnant for paper and textiles. Vulcollan is a German synthetic rubber produced by reacting polyoxy compounds with di-isocyanate. It is noted for high elasticity.

**Rubber powder.** Also called Granulated rubber. A powder prepared usually by spraying latex containing protective colloids into a current of hot air and drying the particles. The latex is protected or stabilized with an ammonia solution of zinc ammonium sulphate; the final rubber powder contains 8% zinc ammonium phosphate and 2 magnesium carbonate. It can also be made by precipitation. Rubber powder is fine, passing through a 200-mesh screen. It is used chiefly in molding and calking compounds. Vulcanizing and compounding materials are sometimes added to the powder for marketing as molding powders. Hard-rubber dust is made from hard-rubber scrap and is used as a filler in rubber. Vultex is a prevulcanized natural rubber powder in liquid or paste form used in coatings and adhesives. Mealorub is a rubber powder produced by a process developed by the Indonesian Research Institute. About 5% of the powder is used in asphalt bitumen mixtures for road surfacing.

**Rubidium.** A rare metallic element, symbol Rb, atomic weight 85.45, belonging to the group of alkali metals. The chief occurrence of rubidium is in the mineral lepidolite, although it is found in other minerals, and in tea, coffee, tobacco, and certain other plants. It is a silvery-white metal, with a specific gravity of 1.52, melting point of 39°C, and boiling at 696°C. It takes fire easily in the air, and like potassium it decomposes water. It can be obtained by electrolysis but has few industrial applications as yet, owing to its rarity and instability. Its chief use is for coating photoelectric cells for telephotographic and television instruments. For the photoelectric cell an extremely thin layer of rubidium is applied to the inside of the glass, and it is preferred to cesium.

**Ruby.** A transparent variety of the mineral corundum, having a beautiful red hue which is due to chromium oxide. It ranks with the best grades of precious stones as a gem stone, but is also used for pivot bearings in watches and fine instruments. The specific gravity is 4.03 and the hardness is 9, being nearly equal in hardness to the diamond. The color is due to chromic oxide. Most of the best rubies come from Upper Burma. Darker stones come from Siam. The center of ruby cutting is at Cambay, near Bombay. The carmine-red, or pigeon's blood, stones are the most highly prized, and in large sizes are of more value than diamonds. Medium-colored red squares and rounds are highly valuable. Stars are stones of large size. Most rubies range from 0.01 to 0.67 carat. For bearing uses synthetic rubies are largely substituted for the natural stones. Synthetic ruby, and other Synthetic gems, notably the Aquamarine and Tourmaline, are made for jewelry and for bearings for watches and instruments. They are made from argillaceous earth at high temperatures, or they may be grown from seed crystals by special methods. They have the same composition and crystal structure as the natural stones. Synthetic spinel,  $\text{MgO} \cdot \text{Al}_2\text{O}_3$ , was made in large quantities in Germany for airplane instrument bearings to replace ruby and sapphire. They were produced in many colors. Spinel has the advantage that it is easy to cut while soft, and can then be hardened by heat-treatment. When hardened it is a little more than half the hardness of corundum but has 30% greater shear strength. Tourmaline is a complex silicate stone, usually green in color, but sometimes blue or red. The rare

colorless variety found in Madagascar is called Achroite. Tourmaline can be used for frequency control in radio, but is more expensive than quartz crystal. It has high piezoelectric properties.

**Ruthenium.** A rare metallic element, symbol Ru. It is a hard, white metal, having a specific gravity of 12.1 and a melting point of about 4440°F. The Brinell hardness of the annealed metal is 220. It can be obtained in the metallic state by heating Ruthenium oxide,  $\text{RuO}_2$ , obtained from the residue of platinum ores, in hydrogen. It is insoluble in most acids and is not dissolved by aqua regia. Ruthenium is used as a hardener in platinum alloys and has a powerful hardening effect on this metal. It is sold by the troy ounce; 1 cu in. weighs 6.38 troy oz.

**Rye.** The seed of the plant *Secale cereale* used as a food grain, but in the United States and Great Britain it is valued chiefly for the production of whisky and alcohol and for feeding animals. Only 4% of the world production is in the United States. The grain looks like wheat, and the stalks of the plant are slender and tough, growing to a height of up to 6 ft. But flour made from the grain produces bread that is dark in color, bitter, and soggy. When used for flour in the United States, it is mixed with wheat and other flours. The plant has the advantage that it will grow on poor soil, in arid regions, at high altitudes, and in regions of severe winter. It is thus a grain of poor agricultural countries, and has been called the Grain of poverty. Rye straw is the dried and sunbleached stalks of the plant. It is very tough and resilient, and is the most valued of all the commercial Straw derived from grains. It is used for packing, bedding, and for the manufacture of strawboard.

**SAE steels.** The common designation for the standard grades of steel approved by the Society of Automotive Engineers. These steels are made regularly by the various mills and are known by their designating numbers. The first number indicates the class of steel, as follows: carbon steel, 1; nickel-carbon, 2; nickel-chromium, 3; molybdenum, 4; chromium, 5; chromium-vanadium, 6; tungsten, 7; and silicon-manganese steel, 9. The second figure indicates the approximate percentage of the predominating alloying element. The last two or three figures indicate the approximate carbon content in hundredths of 1%. Thus SAE 2350 steel is a nickel steel containing

3% nickel (2.75 to 3.25) and 0.50 carbon (0.45 to 0.55). The manganese steels, with manganese from 1.60 to 1.90%, are designated by the letter T before the initial 1. Thus SAE T1350 contains 0.45 to 0.55% carbon and 1.60 to 1.90 manganese. The SAE steels are made to close specifications of manganese, sulphur, and phosphorus content and, since they are very uniform in quality and usually carried in stock, they have been widely adopted for use in all kinds of products. The silicon range for the basic open-hearth alloy steels is 0.15 to 0.30; for electric and acid open-hearth steels it is 0.15 minimum.

**Sago flour.** A starch extracted from the pith of the sago palm, *Metroxylon sagu*, of the East Indies and Malaya, and also from the Aren palm. Sago is valued industrially for sizing and filling textiles because, like tapioca, it holds mineral fillers better than other starches. It gives a tougher and more flexible feel than tapioca, but its tan color limits its use. From 600 to 800 lb of crude Sago is obtained from a tree, which is destroyed in the process. Pearl sago, used for food, is the same material made into dough and forced through a sieve. The aren palm, or Sugar palm, is the species which yields arenga fiber. It contains only 20% as much sago as the sago palm, but a juice, called Toewak, is produced from the cut flower stems and is used to make Palm wine, or Arak. The juice is also boiled down to produce a brown Palm sugar used locally for sweetening.

**Salmon oil.** A pale-yellow oil obtained as a by-product in the salmon-canning industry, and employed as a drying oil for finishes and also used in soaps. There are different classes of the oil, depending upon the type of salmon. The oil contains palmitic and other acids. The specific gravity is 0.926. It has a high iodine value, 168, but it does not form an elastic skin on drying and is therefore inferior for use in most varnishes. The salmon is a valuable food fish and is extensively canned. There are five commercial species of North Pacific salmon of the genus *Oncorhynchus*, and the Steelhead trout or Salmon trout, *Salmo gairdneri* of the Atlantic. The Red salmon, or Sockeye salmon, is *O. nerka*; the Pink salmon is *O. gorbuscha*; and the Chinook or King Salmon is *O. tshawytscha*. The catch is in the rivers on both sides of the Alaska Peninsula and in the Columbia River.

**Salt.** The common name for Sodium chloride, known in mineralogy as Halite, but chemically a salt is any compound derived from an acid by replacing the hydrogen atoms of the acid with the atoms of a metal. Common salt, or sodium chloride, is widely used as a preservative, for flavoring foods, in freezing mixtures, for salt-brine quenching baths, and for the manufacture of soda ash and many chemicals. Common salt has such a variety of uses that its curve of consumption practically parallels the curve of industrial expansion. It is a stable compound of the composition  $\text{NaCl}$ , containing theoretically 60.6% chlorine, but it usually contains impurities such as calcium sulphate and calcium and magnesium chlorides. The hardness of salt is 2.5, specific gravity 2.1 to 2.6, and melting point  $1472^{\circ}\text{F}$ . It is colorless to white, but when impure may have shades of yellow, red, or blue. It occurs in crystalline granular masses with cubical cleavage, known as Rock salt, or Mineral salt. Vast deposits of salt are found underground in Louisiana, and a large area of Kansas is underlain with a salt deposit reaching 800 ft in thickness. The rock salt occurring in immense quantities on the island of Hormoz in the Persian Gulf contains 97.4%  $\text{NaCl}$ , 1.83  $\text{CaCO}_3$ , and only very small amounts of magnesium chloride, iron oxide, and silica. Salt is produced commercially in 15 states of the United States, with an annual production up to 16 million tons, and is also produced in almost every country of the world. It is easily soluble in water, and is found in all waters. It is obtained by evaporation from sea water, which also contains magnesium chloride and other salts. Bay salt is an old name for salt extracted from sea water, now known as Solar salt. Refined California solar salt is 99% pure sodium chloride. From the salt wells of Michigan the bromine, magnesium, and other elements are extracted and the brines form an important source of these products.

Commercial salt is marketed in many grades, depending chiefly on the size of the grain. The term Industrial salt refers rather to the method of packing and shipping than to a grade distinct from Domestic salt, but most of the industrial salt is rock salt; the bulk of the domestic salt is evaporated salt. Domestic consumption of salt for direct human consumption is large in all countries. It is required in the blood stream up to about 3.5%, and is rapidly exhausted in hot weather. Salt tablets, used in hot weather, or by workers in steel

mills, are made up to 70% salt and 30 dextrose. Salt obtained by simple evaporation of sea water contains salt-resistant bacteria which are capable of developing in salted hides or fish and injuring the material. Mineral salt is thus preferred for these purposes. In making brines, 100 parts of water at ordinary temperature will dissolve about 36 parts of salt. Brines used for quenching steel contain from 10 to 15% of salt and have a high cooling rate, but corrode the steel.

Sodium hypochlorite, or Sodium oxychlorite,  $\text{NaOCl}$ , is a stable, noncorrosive salt used in tanneries. Merclor D is a trade name of the Monsanto Chemical Co. for this material in water solution. Javel water is a name given in the laundry industry to a water solution of sodium hypochlorite used as a bleach. Sodium hypochlorite when used as a bleach in the textile industry is called Chemic. Sodium chlorite,  $\text{NaClO}_2$ , is a white to yellow crystalline water-soluble powder used as a bleaching agent for textiles and paper pulp. It is stable up to  $150^\circ\text{C}$ . It yields  $\text{ClO}_2$  in the solution, is an oxidizing agent, and attacks the coloring matter without injuring the fibers. It is also used for water-works purification. Textone is a trade name of the Mathieson Alkali Works, Inc., for sodium chlorite as a bleach for textiles.

**Sand.** An accumulation of grains of mineral matter derived from the disintegration of rocks. It is distinguished from gravel only by the size of the grains or particles, but is distinct from clays which contain organic materials. Sands that have been sorted out and separated from the organic material by the action of currents of water or by winds across arid lands are generally quite uniform in the size of grains. Usually commercial sand is obtained from river beds, or from sand dunes originally formed by the action of winds. Much of the earth's surface is sandy, and these sands are usually quartz and other siliceous material. The most useful commercial sands are composed chiefly of silica, often above 98%. Other materials in sand are feldspar, garnet, zircon, and tourmaline. Silica sands for making glass must be free from iron. The sand mined at Hot Springs, Ark., called Amosil, is 99.5% pure silica, and comes in transparent rounded grains of 3 microns average size.

Sand is used for making mortar and concrete and for polishing and sandblasting. Sands containing a little clay are used for making

molds in foundries. Clear sands are employed for filtering water. Sand is sold by the cubic yard or ton but is always shipped by weight. The weight varies from 2,600 to 3,100 lb per cu yd, depending on the composition and size of grain. Standard sand is a silica sand used in making concrete and cement tests. The grains are free of organic matter and will pass through a 20-mesh sieve, but will be retained on a 30-mesh. Engine sand, or Traction sand, is a high-silica sand of 20 to 80 mesh washed free of soft bond and fine particles, used to prevent the driving wheels of locomotives or cars from slipping on wet rails.

**Sandalwood.** The heartwood of the evergreen tree *Santalum album* and other species of southern Asia. The heartwood is usually equivalent to about one-third of the log. It is sweet-scented and is used for chests, boxes, and small carved work. The chips and sawdust are used for incense and for oil production. Sandalwood oil is a yellowish essential oil of specific gravity 0.953 to 0.985, distilled from the wood, which yields 5 to 7% of the oil. It is used in medicine, perfumery, and soaps. The center of the oil production is in Mysore, India.

**Sandarac.** Known also as White gum, or Australian pine gum. A white, brittle resin obtained as an exudation from various species of the coniferous tree *Callitris*, known as Cyprus pine. The North African sandarac is from the tree *C. quadrivalis* of the Atlas Mountains, and resembles the resin from the Australian tree *C. arenosa*. The trees in Morocco are tapped from May to June, and two months later the small tears of gum are gathered. Sandarac is used in varnishes and is soluble in turpentine and alcohol. It melts at 135 to 140°C. It gives a hard, white spirit varnish used for coating labels and for paper and leather finishes. Ground sandarac, under the name of Pounce, was formerly used as a pouncing powder and for smoothing parchment and tracing cloth, but is now replaced by pumice for this use.

**Sandblast sand.** Any sand employed in a blast of air for cleaning castings, removal of paint, cleaning of metal articles, or for giving a dull rough finish to glass or metal goods, or for renovating the walls of stone or brick buildings. Sandblast sand is not closely graded, and

the grades vary with different producers. The U.S. Bureau of Mines gives the following usual range: No. 1 sand should pass through a 20-mesh and be retained on a 48-mesh screen; No. 2 should pass through a 10-mesh and be retained on a 28-mesh screen; No. 3 through a 6-mesh and be retained on a 14-mesh; No. 4 through a 4-mesh and be retained on an 8-mesh screen. No. 1 sand is used for light work where a smooth finish is desired; No. 4 sand is employed for rough cast-iron and cast-steel work. Sharp grains cut faster, but rounded grains produce smoother surfaces. The sand is usually employed over and over, screening out the dust. The dust and fine used sand may be blasted wet. This is known as mud blasting and produces a dull finish.

**Sandpaper.** Originally a heavy paper coated with sand grains on one side, used as an abrasive, especially for finishing wood. Sharp grains obtained by crushing quartz replaced ordinary sand, but have now been largely replaced by crushed garnet and aluminum oxide grains, although the papers are still commonly referred to as sandpaper. Quartz grains, however, are still employed. For this purpose the quartz grains are prepared in grades from the 20 mesh, known as No. 3 $\frac{1}{2}$ , through No. 3, 2 $\frac{1}{2}$ , 2, 1 $\frac{1}{2}$ , 0, 00, and 000. All of the No. 000 grains pass through a 150-mesh sieve, with 25% retained on a 200-mesh sieve and 80% on a 325-mesh sieve. Good sandpaper quartz will contain at least 98.9% silica. The paper used is heavy, tough, and flexible, usually 70- or 80-lb paper, and the grains are bonded with a strong glue. A process is also employed to deposit the grains on end by electrostatic attraction so that the sharp edges of the grains are presented to the work.

**Sandstone.** A consolidated sand rock, consisting of sand grains united with a natural cementing material. The size of the particles and the strength of the cement vary greatly in different natural sandstones. The most common sand in sandstone is quartz, with considerable feldspar, lime, mica, and clayey matter. The cementing material is often fine chalcedony. Silica sandstones are hard and durable but difficult to work. Calcareous sandstone, in which the grains are cemented by calcium carbonate, is called Freestone and is easily worked, but it disintegrates by weathering. Freestone is homogeneous and splits almost equally well in both directions. Chert, formerly



used as an abrasive and, when employed in building and paving, known under local names, as Hearthstone, Firestone, and Malmstone, is a siliceous stone of sedimentary origin. It has a radiating structure and splintery fracture and is closely allied to flint. In color it is light gray to black or banded. The colors of sandstones are due to impurities, pure siliceous and calcareous stones being white or cream-colored. The yellow to red colors usually come from iron oxides, black from manganese dioxide, and green from glauconite. Flexible sandstone, which can be bent, is known as Itacolumite, and is found in North Carolina. It contains talc or mica in the bonding material.

Sandstones are employed for grindstones and for building stones. The average compressive strength of sandstone used for building purposes is 12,000 psi, and the average weight is 135 lb per cu ft. Sandstones for building purposes are produced under innumerable names, usually referring to the locality. The Blue stone of New York state is noted for its even grain and high crushing strength, up to 19,000 psi. It contains about 70% silica sand with clay as the binder. Holystone is a block of close-grained sandstone, formerly used for rubbing down the decks of ships and still used for rubbing down furniture and concrete work. Briar Hill stone and Macstone are trade names for building blocks consisting of lightweight concrete faced with a slab of sandstone. Kemrock, of the Kewaunee Mfg. Co., is a sandstone impregnated with a black furfural resin and baked to a hard finish. It is used for table tops and chemical equipment to resist acids and alkalies.

**Sapele.** The figured woods of various species of trees of tropical Africa which are mixed with khaya and exported from West Africa as African mahogany. Sapele woods are harder and heavier than red khaya, but shrink and swell more than khaya with changes in moisture. They are also darker in color with a purplish tinge. Sapele mahogany, also called Scented mahogany, and West African cedar, is from the *Entandrophragma cylindricum*, a very large tree growing in the Ivory Coast, Gold Coast, and Nigeria. On the Ivory Coast it is called Aboudikro. Another species, *E. angolense*, is called Tiama mahogany on the Ivory Coast, and in Nigeria is known as Brown mahogany and Gedunohor. A less heavy wood is from the tree *E. utile*, known on the Ivory Coast as Sipo mahogany, and in the

Cameroons as Assie mahogany. It is one of the chief woods exported as mahogany from the Cameroons. The wood known on the Ivory Coast as Heavy mahogany and Omu in Nigeria is from the tree *E. candollei*, and is much heavier than other sapeles. Nigerian pearwood, from species of *Guarea*, notably *G. cedrata* and *G. thompsonii*, is also exported as African mahogany. The woods are more properly called *Guarea*. The color is pale pink to reddish. The weight is about the same as sapele. The wood is of a finer texture than khaya, but is not figured like sapele or khaya. Another wood marketed as African mahogany is Lingue, from the tree *Afzelia africana* of the west coast of Africa from Senegal to Nigeria. The wood is light brown, turning dark when seasoned, and is beautifully figured.

**Saponin.** Glucosides of the empirical formula  $C_{32}H_{54}O_{18}$  which have the property of frothing with water. They are found in soap bark, soap nut, licorice, and other plants; when separated out, saponin is a white, amorphous powder of a disagreeable odor. It is used in some soap, in soapless shampoos, tooth powders, fire extinguishers, and as a detergent and emulsifying agent. Soap nut is the fruit of the trees *Sapindus mukorossi* and *S. laurifolia* of northern India known locally as Ritha. The soap nut has been used as a detergent in washing fabrics since ancient times. The nut has 56% of pericarp and 44 of seed, and the saponin is found in the pericarp. It is extracted with solvents from the dried powdered fruit. Saponin is soluble in water but insoluble in petroleum spirits. Soapbark, also called Morillo bark, is the dried inner bark of the tree *Quillaja saponaria* of the west coast of South America. It was used by the Incas and the botanical name comes from the Inca word quillean meaning to wash. The bark produces suds in water, but the powdered bark is highly sternutatory owing to fine crystals of calcium oxalate. It is marketed in brownish white pieces, and is used as a source of saponin. It has been used in beverages to produce froth, but is highly toxic, affecting the heart and respiration. In medicine it is called Quillaja and is used as an irritant and expectorant. Soapwort consists of the leaves of the plant *Saponaria officinalis*, growing in North America. The leaves contain saponin which dissolves out in water to produce a lather useful for cleansing silk and fine woolens. Soapberry is the fruit of the tropical tree *Sapindus saponaria*, used in hair and toilet

preparations. The Soapberry of the American Southwest consists of the fleshy berries of the small tree *S. drummondii*. Soaproot is the bulb root of the plant *Chlorogalum pomeridianum* of California. Mexican soaproot is the thick rootstock of the *Yucca baccata* and of the Wild date, *Y. glauca*, growing in the dry regions of Mexico and southwestern United States. Both plants are called Yucca, and in Mexico they are called Amole. The Indians used the roots for washing, which were called Vegetable soap by the settlers. In the processing of yucca leaves to obtain fiber about 20% of a powder is obtained which contains 3% saponin. Yucca powder is used in scouring compounds or for the extraction of saponin. The long stout stems of the Soap plant, *Chenopodium californicum*, also yield saponin.

**Sapphire.** A transparent variety of the mineral corundum. When it has the beautiful blue hue for which it is noted, it ranks with the diamond, ruby, and emerald among precious gem stones. The off-color stones are cut for pointers and wearing points of phonographs and instruments. The specific gravity of sapphire is 4.03, and the hardness is 9. The blue color is from titanite oxide and is rarely uniform throughout the stone. Yellow sapphire is colored with NiO. The best gem sapphires come from Ceylon and India, but industrial stones are produced in Montana. Most natural sapphires are small, but the Star of Artaban, in the National Museum in Washington, weighs 300 carats. Synthetic white sapphire is produced by fusing alumina in an oxyhydrogen flame. The fused material forms a boule as a single crystal. The average boule is 200 carats, but sometimes they are as large as 400 carats, or about  $\frac{3}{4}$  in. in diameter and 2 in. long. This water-white type is used for instrument bearings, but watchmakers prefer the ruby color. The synthetic stone has a melting point of 2030°C. Synthetic sapphires are also marketed in the form of standard ring and plug gages in sizes from 0.004 to 0.350 in. They have a wear life 50 times longer than hard steel gages, and have a better feel because of the lower coefficient of friction. The hardness of sapphire on the Knoop scale is 1,900 compared with 850 for hardened tool steel. Sapphire is also used for thread guides on textile machinery, and in the form of balls for bearings and valves.

**Satin.** A full-silk, heavy fabric with a close twill, or satin, weave. In the satin weave the fine silk warp threads appear on the surface

and the weft threads are covered up by the peculiar twill. Common satin is of 8-leaf twill, the weft intersecting and binding down the warp at every eighth pick, but 16 and 20 twills are also made. In the best satins a fine quality of silk is used. The gloss is partly due to hot rolling. Cheaper varieties of imitation satin are made with a cotton weft. Satins are dyed to many colors, and may be sold under trade names. In industry they are used chiefly for linings and trimmings. Sateen is made from mercerized cotton. The wind-resistant sateen used for military garments is a 9-oz cotton fabric in satin weave with 2-ply yarn in warp and filling. The thread count is 112 ends per in., 68 picks per in. The fabric is singed, mercerized, and given a water-repellent finish.

**Scandium.** A metallic element, symbol Sc, found in the mineral Thortveitite,  $(\text{ScYt})_2\text{Si}_2\text{O}_7$ , and in wolframite. It occurs also in small quantities in many minerals but has as yet no commercial application because of the difficulty of extraction.

**Scheelite.** An ore of the metal tungsten, occurring usually with quartz in crystalline rocks associated with wolframite, fluorite, cassiterite, and some other minerals. It is found in various parts of the United States, Brazil, Asia, and Europe. Scheelite is Calcium tungstate,  $\text{CaWO}_4$ , containing theoretically 80.6% tungsten trioxide and 19.4 lime. It is called Powellite when it contains some molybdenum to replace a part of the tungsten. It occurs massive granular or in crystals, with a specific gravity of 6.0 and a hardness 4.5 to 5. Its color is white, yellow, brown, or green, with a vitreous luster. Chinese scheelite from Kiangsi averages 65%  $\text{WO}_3$ . High-grade scheelite is used directly for adding tungsten to steel. Tungstic acid is a yellow powder of the composition  $\text{H}_2\text{WO}_4$  made from calcium tungstate ore by treating with hydrochloric acid. It is not soluble in water, but is soluble in alkalis and in hydrofluoric acid, and is used as a mordant in dyeing, in plastics, and for making tungsten wire by reducing. Tungstic acid is also obtained as a by-product in the manufacture of alkalis from the brine of Owens Lake, and is a source of tungsten, 1,000 lb of tungstic acid yielding about 800 lb of metallic tungsten. Calcium tungstate crystals, for piezoelectric uses, are grown synthetically by the Linde Air Products Co. in rods  $\frac{1}{4}$  in. square and 2 in. long.

**Scouring abrasive.** Natural sand grains or pulverized quartz employed in scouring compounds and soaps, buffing compounds, and metal polishes. The Federal specifications require that the abrasive grains used in grit cake coap and scouring compounds shall all pass a No. 100 screen, that the grains for scouring compounds for marble floors must all pass a No. 100, and 95% pass a No. 200 screen. For ceramic floors 90% must pass a No. 80, and 95% must pass a No. 60 screen. Very fine air-floated quartz is employed in metal polishes, and all grains pass a 325-mesh screen.

**Screw stock.** A common term for soft steel with free-cutting qualities used for screws and small turned parts made in the screw machine. It usually contains a larger percentage of sulphur than ordinary soft steel. Sulphur makes steel hot-short, or brittle, at red heat, and reduces the tensile strength, but it aids machinability and is called for in steel for simple parts where strength is not important. SAE specifications for screw stock call for 0.08 to 0.155% sulphur, 0.09 to 0.13 phosphorus, 0.060 to 0.90 manganese, and up to 0.25 carbon. High-manganese screw stock is an open-hearth, high-sulphur steel in the medium-manganese class having good cutting and case-hardening properties and higher strength. A grade of manganese screw stock under the name of Ryco is marketed by Joseph T. Ryerson & Son, Inc., having a tensile strength of 90,000 psi and elongation of 20%. Silcut steel is a free-cutting steel produced by W. T. Flather, Ltd. Super-cut steel and Freecut steel of the Union Drawn Steel Div., Republic Steel Corp., are high-sulphur, bessemer cold-drawn steels with tensile strengths up to 100,000 psi, elongation 18% and hardness 196 Brinell. USS steel MX, of the U.S. Steel Corp., is an SAE 1113 bessemer steel made to close control limits to give uniform machining. Free-cutting steels are produced by almost all steel mills, containing sulphur, selenium, zirconium, lead, or other elements. These steels include free-cutting stainless steels. The name screw stock also refers to free-cutting brass rod containing a small percentage of lead.

**Seal oil.** An oil obtained from the blubber of the oil seal, *Phoca vitulina*. The industry centers around South Georgia with the whale-oil industry. Seal oil is used in lubricating and cutting oils. It has a

saponification value as high as 195 and an iodine value up to 150. It contains palmitic and other acids.

**Selenium.** An elementary metal, symbol Se, found native in cavities in Vesuvian lavas and, in combination with sulphur, in copper and iron pyrites. It is produced as a by-product in copper refining. Like sulphur it exists in various forms, having six allotropic forms. Amorphous selenium is a finely divided brick-red powder with a specific gravity of 4.26. Semicolloidal red amorphous selenium is a blood-red solution. Vitreous selenium forms a brownish-black, brittle, glassy mass with a specific gravity of 4.28. The red crystalline selenium has a ringlike structure of 8 atoms in the molecule. Metallic selenium is made by fusing the vitreous variety and cooling slowly. This form has a chain linkage of atoms. The specific gravity of the metal is 4.82, and melting point about 215°C. Selenium is odorless and tasteless, but the vapor has a putrid odor. Selenium is poisonous, and is used in insecticides and in ship-hull paints. It is toxic to some plants, and foods grown on soils containing selenium have toxic effects on animals. The metal boils at 690°C, and burns with a purple flame. Commercial selenium is a blackish powder, 99% pure.

The peculiar photoelectric properties of selenium were discovered in 1873. It changes electrical resistance when exposed to light. Ordinary fused or vitreous selenium is a poor conductor of electricity but, when annealed by heating, it takes a crystalline form and its electrical resistance is reduced, and it also becomes susceptible to changes in light. The change of electric conductivity is instantaneous, even the light of small lamps having a marked effect. It is used for light-measuring instruments and for electric eyes. The change in resistance varies directly as the square of the illumination.

Selenium is also used in steels to make them free-machining. Selenium steels are not as susceptible to corrosion as those with sulphur and are stronger. Small amounts of selenium may be used in glass to neutralize the green tint of iron compounds. Larger amounts produce pink and ruby glass. Selenium ruby glass is used in signal lenses. Selenium gives the only pure red color for ceramics and glass. The pigment may be a combination with cadmium sulphide. Pigment for glass may also be in the form of the black powder, Barium selenite,  $\text{BaSeO}_3$ , or as Sodium selenite,  $\text{Na}_2\text{SeO}_3$ . Selenium is also used as an

accelerator in rubber and to increase abrasion resistance. Vandex, of R. T. Vanderbilt Co., is a selenium powder used as a rubber vulcanizer. Novac, of Herron Bros. & Meyer, used for curing synthetic rubbers, is selenium dibutyl dithiocarbonate in the form of a liquid easily dispersed in the rubber. In copper alloys selenium improves machinability without hot-shortness. Selenium copper is a free-cutting copper containing about 0.50% selenium. It machines easily, and the electrical conductivity is nearly equal to that of pure copper. The tensile strength of annealed selenium copper is about 30,000 psi. Small amounts of selenium salts are added to lubricating oils to prevent oxidation and gumming.

**Senna.** The dried small leaves and the pods of the bushy plant *Cassia acutifolia*, the Alexandrian senna, and *C. angustifolia*, the Tinnevely senna, of India, Arabia, and North Africa. The plants are cultivated in India, but the Sudan material comes mostly from wild plants. The sun-dried leaves and pods are shipped in bales. They are used direct as a laxative by steeping in water, or the extract is used in pharmaceuticals. It contains the yellowish noncrystalline Cathartine, a powerful purgative. Another species of the plant, *C. auriculata*, yields Avaram bark which is an important tanning material in India. It is similar to algarobilla in action.

**Serpentine.** A mineral of the theoretical formula  $3\text{MgO} \cdot 2\text{SiO}_2 \cdot 2\text{H}_2\text{O}$ , containing 43% magnesium oxide. It is used for building trim and for making ornaments and novelties. The chips are employed in terrazzo and for roofing granules. Actually, the stone only rarely approaches the theoretical formula, and usually contains 2 to 8% iron oxide with much silica and aluminum. It has an asbestoslike structure. The attractively colored and veined serpentine of Vermont is marketed under the name of Verde antique marble. The massive verde antique of Pennsylvania is used with dolomite in refractories. Antigorite is a form of serpentine found in California which has a platy rather than a fibrous structure. The serpentine of Columbus County, Georgia, contains 36 to 38% MgO and 2 to 5 chrome ore. It is used as a source of magnesia and its salts, and the chromium is recoverable.

**Sesame oil.** A pale-yellow, odorless, bland oil obtained from the seeds of the tropical plant *Sesamum orientale* and other species,

grown in India, China, Africa, and Latin America, and used for soaps, foodstuffs, and for blending industrial oils. It is distinct from German sesame oil. The seeds from different species and localities vary greatly in size and color, from yellowish white to reddish brown to black. The oil from Nigeria is called Benne oil, and the seed Bennisseed. In India it is known as Til oil, and the seed as Til seed. In Madras it is called Gingelly. In Mexico it is called Ajonjoli. The seeds contain 50% of oil of a specific gravity of 0.920 to 0.925, with saponification value 188 to 193.

**Shale.** A rock formed by mud or clay consolidated under pressure. It is fine-grained and has a laminated structure, and is largely composed of silica and alumina with various impurities, often colored by oxides of iron. Unlike sandstones, shales are not usually porous, most shales being hard, slatelike rocks. Slate is a form of shale. Some shales are calcareous or dolomitic and are used with limestone in making portland cement. These are called Marlstone. Oil shale is a hard shale with veins of a greasy solid known as Kerogen which is oil mixed with organic matter. Crude shale oil is a black, viscous liquid containing up to 2% nitrogen and a high sulphur content. But on heating oil shale above 750°F, the kerogen is cracked into gases condensable to oils, gases, and coke. Some shales also yield resins and waxes, and the Kvarmtorp shale of Sweden contains 220 grams of uranium oxide per ton with also vanadium and molybdenum. The regular commercial by-products of Swedish shale oil recovery are sulphur, fuel gas, ammonium sulphate, tar, and lime. Oil shales are widely distributed in many parts of the world and are regularly distilled in most of the countries of Europe, the yield varying from 15 to 100 gal per ton. Scotch shales give an average yield of 24.5 gal crude oil and 35.7 lb ammonium sulphate per short ton. Colorado shale has yielded 17 to 40 gal oil per ton by a continuous method under which the oil is extracted by a stream of hot gases passing through the crushed shale. Shale occurs in strata and is mined like coal. Bituminous shale was originally called Boghead coal in England, and Torbane mineral in Scotland. It is estimated that there are 2,000 sq mi of oil shale lands in Colorado alone, with a total of 400 billion tons of oil-bearing shale available in Colorado, Utah, and Wyoming, with an estimated probable average yield of



15 gal per ton. Other extensive deposits occur in Indiana, Ohio, and Kentucky.

**Shark leather.** A durable nonscuffing leather used for book bindings, handbags, and fancy shoes, made from the skin of sharks. The shark has a skin unlike fishskin. When tanned, the surface is hard, the epidermis thicker than cowhide, and the long fibers lie in a cross weave. The shark is split on the back instead of the belly as in cowhides, and the skins measure from 3 to 20 sq ft, averaging 10 sq ft. The hard denticle, called the shagreen, is usually removed, after which the leather is pliable but firm, the exposed grain not pulling out. Shagreen leather is a hard, strong leather with the grain side covered with globular granules made to imitate the sharkskin. Eastern shark leather has a deep grain with beautiful markings. The eastern shark includes about a dozen species of shark caught off the Florida and Cuban coasts except the Nurse shark and the Sawfish which are graded separately. The nurse shark measures 6 to 10 ft. Olcotrop leather, from a species of shark, has a smooth, fine grain with regular markings. Galuchat leather, or Pearl sharkskin, is from the Japanese ray. It is used for trim on pocketbooks. Boroso sharkskin, Roussette leather, or Morocco leather, is from a small shark of the Mediterranean, but the name is also applied to a vegetable-tanned Spanish goatskin on which a pebbly grain is worked up by hand boarding. It is now made from ordinary goatskin by embossing. Most of the sharkskin is now a by-product of the catch for oil, which is used for medicinal purposes. The shark liver is about one-fourth the total weight of the animal, and Shark-liver oil is 30 times higher in vitamin A than cod-liver oil. The oil is also used for soap, lubricant, and heat-treating oil, though normally it is too expensive for these purposes. The Mexican shark-oil industry centers at Mazatlan, and about 25 species are caught off the West Coast. Vitamin oil from South Africa is from the liver of the Stockfish, *Merluccius capensis*, which is also an important food fish. The liver contains 30% oil.

**Sheepskin.** The skin of numerous varieties of sheep, employed for fine leather for many uses. The best sheepskins come from the sheep yielding the poorest wool. When the hair is short, coarse, and sparse, the nourishment goes into the skin. The merino types having fine wool have the poorest pelts. Wild sheep and the low-wool cross-

breeds of India, Brazil, and South Africa have close-fibered firm pelts comparable in strength with some kidskin and retain the softness of sheepskin. This type of sheepskin from the hair sheep is termed Cabretta, and is used almost entirely for making gloves and for shoe uppers. None is produced in the United States. The lambs grown in the mountains of Wales, Scotland, and western United States also furnish good skins. The commercial difference between sheepskin and Lambskin is one of weight only. Sheepskins usually run 3 to 3½ lb per skin without wool, and lambskins are those below 3 lb. Sheepskins are tanned with alum, chrome, or sumac. The large and heavy skins from Argentina and Australia are often split, and the grain side tanned in sumac for bookbinding and other goods; the flesh side is tanned in oil or formaldehyde and marketed as chamois. The fine-grained sheepskins from Egypt, when skived and specially treated, are known as Mocha leather. Uda skins and White Fulani skins, from Nigerian sheep, are used for good quality grain and suède glove leather. Sheepskin shearlings are skins taken from heavy-wooled sheep a few weeks after shearing. The wool is about an inch in length. They are tanned with the wool on, and the leather is used for aviation flying suits and for coats.

**Shellac.** A product of the *Tachardia lacca*, an insect that lives on various trees of southern Asia. The larvae of the lac insect settle on the branches, pierce the bark, and feed on the sap. The lac secretion produced by the insects forms a coating over their bodies and makes a thick incrustation over the twig. Eggs developed in the females are deposited in a space formed in the cell, and the hatched larvae emerge. This swarming continues for 3 weeks and is repeated twice a year. The incrustation formed on the twigs is scraped off, dried in the shade, and is the commercial Stick lac. It contains woody matter, lac resin, lac dye, and bodies of insects. Seed lac is obtained by screening, grinding, and washing stick lac. The washing removes the Lac dye. Lac dye was once an important dyestuff, giving about the same colors as cochineal but not as strong. It gives a fast bright-red tint to silk and to wool, but is now replaced by synthetics. Ari lac is stick lac collected before the young insects have swarmed, and contains living insects. Lac harvested after the swarming is called Phunki lac and contains dead bodies of the insects. Average yield of

stick lac from Kusum trees is 12 lb, from the Ber tree 3 lb, and from the Palas tree 2 lb. About 80% of lac production is in Bihar Province, India, but it is also obtained from Bengal, the Central Provinces, and Assam. The stick lac from Burma and Siam is brought to India for making shellac. Shellac is prepared from seed lac by melting or by extraction with solvents. The molten material is spread over a hot cylinder, stretched, and the cooled sheet broken into flakes of shellac. Button lac is made by dropping molten lac on a flat surface which spreads it into button-shaped cakes 3 to 4 in. in diameter. Kiri is the refuse from the filtering bags. It is marketed in pressed cakes and contains 50 to 60% lac with resin and dirt. The yield of shellac from stick lac is about 57%. When pure, shellac varies from pale orange to lemon yellow in color, but the color of commercial shellac may be from a high content of common rosin. White shellac is made by bleaching with alkalis. Garnet lac is the material with lac dye left in. Color may also be balanced with pigments. Orange shellac contains up to 1% powdered orpiment, and the yellow may have smaller quantities. Shellac contains polyhydroxy acids in condensed form as long-chain esters, but it also contains resin and wax. Hard lac is prepared by removing soft constituents by alkali extraction. For electrical use the wax content should be below 3½%. By solvent extraction of the seed lac the wax may be reduced to 1%. Shellac is graded by color and by its freedom from dirt. The first grade contains no rosin, but other grades may contain up to 12%. Most Indian exports of seed lac to the United States are of the special grade which has a high bleach index. Cut shellac is shellac with usually 25 lb rosin to 100 lb dry shellac, dissolved in alcohol. Shellac is used in adhesives, varnishes, insulating compounds, and in some molding compounds. Shellac plastics, usually for electrical purposes, are sold under trade names such as Electrose, of the Insulation Mfg. Co., and Harvite, of the Siemon Co. Shellac substitutes are made by blending natural resins with nitrile rubber.

**Shock-resistant steels.** A general name for steels used for tools and parts that are required to withstand much pounding. There are two general types. One type contains chromium, vanadium, and a small amount of molybdenum, with usually fairly high manganese; the other type contains up to 2% silicon, with usually some molybdenum.

The silicon steels are used for pneumatic tools and for such purposes as coining dies. A Chromium-silicon steel marketed by the Timken Steel & Tube Co. under the name of Sicromo steel is a combination of both types, and has high strength and resistance. It contains 2.25 to 2.75% chromium, 0.5 to 1 silicon, 0.4 to 0.6 molybdenum, and 0.15 carbon. The tensile strength, annealed, is 60,000 psi, elongation 30%, and hardness 170 Brinell. The low-alloy chromium-silicon steels with about 1% chromium, 1 silicon, 0.60 to 0.70 manganese, and 0.40 to 0.45 carbon have tensile strengths above 200,000 psi when heat-treated. They have good fatigue resistance and are also used for springs. A steel of the Allegheny Ludlum Steel Co. called Shoe die steel, for cutting block dies, or Clicker dies, for cutting leather and paper, contains 0.70% chromium, 0.35 molybdenum, 0.60 manganese, 0.20 silicon, and 0.53 carbon. Shoe die steel is marketed in beveled shapes. MSM steel, of A. Milne & Co., for punches, chisels, and shear blades, has 0.50% carbon, 2.0 silicon, 0.70 manganese, and 0.25 molybdenum. Omega steel, of the Bethlehem Steel Co., for chisels, shear blades, and swaging tools, contains 0.60% carbon, 1.85 silicon, 0.70 manganese, 0.20 vanadium, and 0.45 molybdenum. When hardened in oil, it has a high resistance to impact. Hy-Tuf steel, of the Crucible Steel Co. of America, for shock-resistant tools, gears, and parts, is an oil-hardening steel containing 1.30% manganese, 1.50 silicon, 1.80 nickel, 0.40 molybdenum, and 0.25 carbon. When hardened to 475 Brinell it has a tensile strength of 235,000 psi and elongation 14%. Ludlum No. 602 steel, for pneumatic tools, has 0.48% carbon, 0.70 manganese, 1.70 silicon, 0.40 molybdenum, and 0.12 vanadium, while Seminole hard steel of the same company has 1.3% chromium, 2 tungsten, 0.25 vanadium, and 0.48 carbon. Atsil steel, of the Atlantic Steel Co., for shear blades, punches, and pneumatic tools, contains 0.50% carbon, 0.60 manganese, 0.50 tungsten, 0.30 molybdenum, and 1.30 silicon.

**Silica.** A mineral of the composition  $\text{SiO}_2$ , Silicon dioxide, which is the most common of all materials, and in the combined and uncombined states is estimated to form 60% of the earth's crust. Many sands, clays, and rocks are largely composed of small silica crystals. When pure, silica is colorless to white. It is either crystallized or

amorphous, and in the crystalline forms it has the composition  $(\text{SiO}_2)_n$ , with a latticelike structure of the molecule. The varieties of natural silica are Crystalline silica, such as quartz and Tridymite; Cryptocrystalline silica (minute crystals), such as flint, chert, chalcedony, and agate; and Amorphous silica such as opal. Silica is insoluble in water when anhydrous and is also insoluble in all acids except hydrofluoric. Crystallized silica in the form of quartz has a hardness of 7 Moh and a specific gravity 2.65. Amorphous Silica glass has a density of 2.21. Pure fused silica has a melting point of  $1750^\circ\text{C}$ , but softens slightly at  $1400^\circ\text{C}$ . In chemical and heat ware it is used up to  $1100^\circ\text{C}$ . The coefficient of expansion is very low, 0.00000054 per deg C. Vitreous silica is a name sometimes used for silica glass of high transparency employed for camera lenses.

Fused silica is used for chemical parts, especially where resistance to sulphuric acid is required or where there is severe thermal shock. The fused silica of the Amersil Co., Inc., known as Amersil, used for tubes, pipe, and parts of chemical equipment, is transparent and will withstand continuous temperatures up to  $2700^\circ\text{F}$ . It is resistant to all acids except hydrofluoric and hot phosphoric. Silica is also used as a filler in paints, in ceramics, and for abrasives and building stones.

Silica flour, made by grinding sand, is used in paints and as a facing sand for molds. One large machine-tool foundry uses 50 parts silica flour to 220 parts sand and 10 parts linseed oil. It is also employed for making flooring blocks. An acid-resistant industrial flooring of Johns-Manville contains 50% silica flour, 32 silica sand, and 18 asphalt. Silver bond silica, of the Tamms Silica Co., is a water-floated silica flour of 98.5%  $\text{SiO}_2$ , ground to 325 mesh. In zinc and lead paints it gives a hard surface. Pulverized silica, made from crushed quartz, is used to replace tripoli as an abrasive. Ultra-fine silica flour, with crystals as small as 1 to 1.5 microns, is produced by forcing carbon dioxide through a solution of sodium silicate and methanol, thus precipitating out the fine silica. Silica powder of the Linde Air Products Co. is a white amorphous powder with maximum particle size of 50 millimicrons, and bulking density of 2.3 lb per cu ft. It gives increased pigment dispersion in paints and plastics, and is also used as a reinforcing agent in rubber. The extreme fineness gives stable suspensions in water and in solvents. The Colloidal silica marketed as Ludox by E. I. du Pont de Nemours & Co., Inc.,

is an opalescent 30% water solution of high-purity silica with a particle size less than 0.000001 in. It is produced by reacting sodium silicate with an acid form of a cation exchange resin. It is used as a reinforcing agent in synthetic rubbers, to add wearing qualities to coatings, and to give water resistance to adhesives. Syton, of the Monsanto Chemical Co., is a colloidal dispersion of fine silica in water used for treating textiles to increase strength. Translucent silica particles are deposited on the fibers, increasing the coefficient of friction, giving more even and higher strength yarns.

Silica aerogel is a fine, white, semitransparent silica powder, the grains of which have a honeycomb structure, giving extreme lightness. It weighs 2.5 lb per cu ft and is used as an insulating material in the walls of refrigerators, as a filler in molding plastics, as a flattening agent in paints, as a bodying agent in printing inks, and as a reinforcement for rubber. It is produced by treating sandstone or sand with caustic soda to form sodium silicate, and then treating with sulphuric acid to form a jellylike material called Silica gel. This material is then washed with water and alcohol, and then ground. The fine silica particles, 3 to 5 microns in diameter, are porous and have high oil absorption. The Synthetic silica of the Davidson Chemical Co. is silica gel ground to an average particle size of 0.5 micron. It is 97.7% min silica. Santocel, of the Monsanto Chemical Co., is silica gel. Mertone WB-2, of this company, is silica gel used as a coating material for blueprint papers to deepen the blue and increase legibility. When silica gel is used as a pigment, the vehicle surrounds the irregular particle formation, producing greater rigidity and hardness of paint surface than when a smooth pigment is used. For insulation use, the thermal conductivity of silica gel powder is given as 0.1 Btu per hr per sq ft per inch per deg F at  $-115^{\circ}\text{F}$ , and 0.30 Btu at  $500^{\circ}\text{F}$ .

Silicon monoxide,  $\text{SiO}$ , does not occur naturally but is made by reducing silica with carbon in the electric furnace and condensing the vapor out of contact with the air. It is lighter than silica, having a specific gravity of 2.24, and is less soluble in acid. It is brown powder valued as a pigment for oil painting as it takes up a higher percentage of oil than ochres or red lead. Monox is a trade name for silicon monoxide. Fumed silica is a fine translucent powder of the simple amorphous silica formula made by calcining ethyl silicate. It is used

instead of carbon black in rubber compounding to make light-colored products, and is often called White carbon black.

**Silicon.** One of the nonmetallic elements, symbol Si. It is used in iron, steel, and in nonferrous metals for deoxidation of the molten metals and to give hardness and other characteristics. Its melting point when pure is about 2615°F, but it readily dissolves in molten metals. It is never found free in nature, but combined with oxygen it forms silica,  $\text{SiO}_2$ , one of the most common substances in the earth. Silicon can be obtained in three modifications. Amorphous silicon is a brown-colored powder with a specific gravity of 2.35. It is fusible and dissolves in molten metals. When heated in the air, it burns to form silica. Graphitoidal silicon consists of black glistening spangles, and is not easily oxidized and not attacked by the common acids, but is soluble in alkalis. Crystalline silicon is obtained in dark, steel-gray globules or six-sided pyramids. It is less reactive than the amorphous form, but is attacked by boiling water. All these forms are obtainable by chemical reduction. Silicon is an important constituent of commercial metals. Molding sands are largely silica, and silicon carbides are used as abrasives. Commercial silicon is sold in the graphitoidal flake form, or as ferrosilicon, and silicon-copper. The latter forms are employed for adding silicon to iron and steel alloys. Commercial refined silicon contains 97% pure silicon and less than 1% iron. It is used for adding silicon to aluminum alloys and for fluxing copper alloys.

**Silicon bronze.** A name applied to two classes of copper alloys. One of these is a copper, or nearly pure copper, fluxed with silicon, in which little or no silicon remains in the final metal. This material is used for strong electric wires and has high strength and resistance to corrosion. A standard alloy of this class contains 98.55% copper, 1.40 tin, and 0.05 silicon. The tensile strength, hard-drawn, is 92,000 psi. The second class of alloy contains a considerable amount of silicon and may have nickel, tin, and other elements. This type of alloy usually depends for hardness on the formation of silicides of nickel or iron. These alloys can be heat-treated and age-hardened.

Phono bronze, or Phono electric alloys, is the trade name of a group of copper alloys of the Bridgeport Brass Co. containing about 1.25% tin and small amounts of silicon and cadmium. The tensile strength

of the wire is up to 100,000 psi and of the hard-rolled sheet 75,000 psi. It is wear-resistant and corrosion-resistant. The electrical conductivity of the various grades varies from 14 to 80% that of copper. Duronze III, of the same company, contains 91% copper, 7 aluminum, and 2 silicon. It forges easily and machines readily. The average tensile strength is 90,000 psi. The high strength is inherent in the alloy and is not from cold working. The drawn rod has a tensile strength of 100,000 psi.

An early bearing alloy known as Tetmejer contained 2.75% silicon, 5 to 10 aluminum, some iron, and the balance copper. Another bearing bronze, called Vulcan bronze, contained 1% silicon, with iron and nickel. Silicon forms solid alpha solutions in low brass up to about 2.8% silicon, above which point a beta phase is formed. Thus, a mixed alpha-beta structure is present in the high-silicon bronzes. Tombasil, an alloy developed in Germany and marketed by the Ajax Metals Co., is essentially tombac metal with the addition of silicon. It can be die-cast or sand-cast, and is used for bearings. The tensile strength is 65,000 psi, elongation 15%, and Brinell hardness 135. Navy Tombasil contains approximately 90% copper, with maximums of 5 zinc and 5 silicon. It has good casting qualities, and gives a homogeneous structure. The tensile strength, sand-cast, is up to 58,000 psi with elongation 36%. P.M.G. metal, of Vickers-Armstrong, Ltd., has 2% iron, 3 to 4 silicon, 2 zinc, and the balance copper. The forged metal has a tensile strength of 94,000 psi, elongation 17%, and Brinell hardness 153. Cast P.M.G. metal, of the Cramp Brass & Iron Foundries, has a tensile strength of about 50,000 psi with elongation 15 to 23%, Brinell hardness 90 to 125, and specific gravity 8.44. Castings will withstand high liquid pressures and are corrosion-resistant.

Silicon-copper alloys containing zinc are used also for die castings, bearing metals, and general strong castings. They may be called also Silicon brass, although this name properly refers to the alloys with considerable zinc and small amounts of silicon. The alloys known in Federal specifications as Copper-silicon alloy contain 5% zinc and 1 to 5 silicon, with some iron, tin, and manganese. They are used for castings or wrought parts. A grade of Olympic bronze, of the Chase Brass & Copper Co., contains 3% silicon and 1 zinc. The tensile strength is from 56,000 to 110,000 psi and elongation 5 to 65%.



Olympic bronze G contains 22% zinc and 1 silicon, with the balance copper. It is a strong Silicon brass, and the annealed sheet has a strength of 65,000 psi with elongation 50%. Doler brass, of the Doehler Die Casting Co., is a silicon brass for die castings. A group of copper-silicon-manganese alloys is produced by the American Brass Co. under the name of Everdur metal, originally patented by Charles Jacobs and called Jacobs' alloy. Everdur 1000 for castings contains about 94.9% copper, 4 silicon, and 1.1 manganese. The tensile strength, cast, is 45,000 psi and elongation 15%. The alloys combine high strength and toughness with acid and corrosion resistance. The wrought alloys have some physical characteristics similar to those of mild steel, but they have the disadvantage as compared with tin bronze that they have no proportionality limit and suffer permanent deformation at a low load and low impact. The hard-drawn rods have a minimum tensile strength of 70,000 psi. The electrical conductivity of the cast metal is 7% that of copper, and of hard-wrought metal 12% that of copper. A European alloy, under the name of Kuprodur, containing 0.5% silicon, 0.75 nickel, and the balance copper, has good strength at elevated temperatures and is used for locomotive firebox plates.

**Silicon carbide.** A bluish-black crystalline artificial mineral of the composition  $\text{SiC}$ , having a hardness of 9.5 on the Moh scale, and used as an abrasive in the form of powder, paper, wheels, and hones. It is also used as a refractory material, being bonded with clays or held together with its own crystals by a method of recrystallization. It is also used as a deoxidizer and graphitizer in melting iron and steel. Silicon carbide is made by fusing sand and coke with sawdust, using salt as a flux. The temperature used is just above  $4000^{\circ}\text{F}$ . It was discovered in 1891 by E. G. Acheson. The specific gravity is 3.12 to 3.20. As a refractory it will withstand temperatures up to about  $4200^{\circ}\text{F}$ , at which point it decomposes. Pure silicon carbide should contain 70% silicon and 30 carbon, but the commercial grades contain less silicon and have small amounts of iron oxide. Unlike aluminum oxide, the crystals are large, and it is crushed to make the small grains required for abrasive purposes. It is harder than aluminum oxide, and is used for the hardest types of grinding wheels. The standard grain sizes are the same as those for aluminum oxide. For

polishing granite, sizes 70 to 90 are employed. Silicon carbide as an abrasive and refractory is sold under a great variety of trade names. Carborundum is the name of the Carborundum Co. for a silicon carbide. Other silicon carbide abrasives are Carboron, Carborite, Carbolite, Carbolox, Mimico, Carbo-brant, Carbicon, Corex, Silexon, Crystolite, Sterbon, Storalon, Natalon, Natrondum, Lotens, Calcinite, Idilon, Electrolon. Carbox is a silicon carbide firebrick made by the General Refractories Co. Crystolon, of the Norton Co., is the name of an abrasive and a refractory. Ferrocarbo is a silicon carbide of the Carborundum Co. in briquettes for adding to the iron cupola charge. It breaks down in the cupola above 2000°F to form nascent carbon and silicon for adding to the iron and also for deoxidizing. It produces more uniform iron castings.

**Silicon-copper.** An alloy of silicon and copper used for adding silicon to copper, brass, or bronze, and also employed as a deoxidizer of copper and for making hard copper. Silicon alloys in almost any proportion with copper, and is the best commercial hardener of copper. A 50-50 alloy of silicon and copper is hard and extremely brittle and black in color. A 10% silicon, 90 copper alloy is as brittle as glass; in this proportion silicon-copper is used for making the addition to molten copper to produce hard, sound copper castings of high strength. The resulting copper alloy is easy to run in the foundry and does not dross. Silicon-copper grades in 5, 10, 15, and 20% silicon are also marketed, being usually sold in slabs notched for breaking into smaller sections for adding to the melt. A 10% silicon-copper melts at 1500°F; a 20% alloy melts at 1152°F.

**Silicon iron.** An Acid-resistant cast iron containing a high percentage of silicon. When the amount of silicon in cast iron is above 10%, there is a notable increase in corrosion and acid resistance. The acid resistance is obtained from the compound  $\text{Fe}_3\text{Si}$ , which contains 14.5% silicon. The usual amount of silicon in acid-resistant castings is from 12 to 15%. The alloy casts well but is hard and cannot be machined. These castings usually contain 0.75 to 0.85% carbon; amounts in excess of this decrease the acid resistance. Too much carbon also separates out as graphite in silicon irons, causing faulty castings. Increasing the content of silicon in iron reduces the melting point progressively from 1530°C for pure iron to 1250°C for iron

containing 23% silicon. A 14 to 14.5% silicon iron has a silvery-white structure, a compressive strength of about 70,000 psi, Brinell hardness 290 to 350, and is resistant to hot sulphuric acid, nitric acid, and organic acids. Silicon irons are also very wear-resistant, and are valued for pump parts and for parts for chemical machinery. They are marketed under many trade names. Tantiron, of the Bethlehem Foundry & Machine Co., contains 14 to 15% silicon, 2 to 2.5 manganese, and 1 carbon. The high manganese aids the machining properties of the metal. Duriron, of the Duriron Co., contains 14.5% silicon and 1 carbon and manganese. The tensile strength is 16,000 psi and weight 0.253 lb per cu in. Durichlor, of the same company, is a special grade of high-silicon iron resistant to hydrochloric acid. Antaciron is a 14.5% silicon iron of Antaciron, Inc., and Corrosiron is a similar iron of the Pacific Foundry Co. Thermisilid is the original name given by the Krupp Works to high-silicon cast iron. A heat-resistant silicon iron developed by the British Cast Iron Research Assoc. under the name of Silal contains only 5% silicon. It is used for stoker and furnace parts.

**Silicon-manganese.** An alloy employed for adding manganese to steel, and also as a deoxidizer and scavenger of steel. It usually contains 65 to 70% manganese and 12 to 25 silicon. It is graded according to the amount of carbon, generally 1, 2, and 2.5%. For making steels low in carbon and high in manganese, silicomanganese is more suitable than ferromanganese. A reverse alloy, called Manganese-silicon, contains 73 to 78% silicon and 20 to 25 manganese, with 1.5 max iron and 0.25 max carbon. It is used for adding manganese and silicon to metals without the addition of iron. Still another alloy is called Ferromanganese-silicon, containing 20 to 25% manganese, about 50 silicon, and 25 to 30 iron, with only about 0.50 or less carbon. This alloy has a low melting point, giving ready solubility in the metal.

Silicon-spiegel is an alloy of silicon and manganese with iron employed for making additions of silicon and manganese to open-hearth steels, and also for adding manganese to cast iron in the cupola. A typical analysis gives 25 to 30% manganese, 7 to 8 silicon, and 2 to 3 carbon. Both the silicon and manganese act as strong deoxidizers, forming a thin fusible slag, making clean steel.

**Silicon steel.** All grades of steel contain some silicon and most of them contain from 0.10 to 0.35% as a residual of the silicon used as a deoxidizer. But from 3 to 5% silicon is sometimes added to increase the magnetic permeability, and larger amounts are added to obtain wear-resisting or acid-resisting properties. Silicon deoxidizes steel, and up to 1.75% the elastic limit and impact resistance are increased without loss of ductility. Silicon steels within this range are used for structural purposes and for springs, giving a tensile strength of about 75,000 psi and elongation 25%. A common low-silicon structural steel contains up to 0.35% silicon and 0.20 to 0.40 carbon, but the Structural silicon steels are ordinarily Silicon-manganese steel, with the manganese above 0.50%. European silicon structural steels contain 0.80% or more silicon, with manganese above 0.50%, and very low carbon. The silicon alone is a graphitizer and to be most effective needs the assistance of manganese or other carbide-forming elements. It is useful in high-strength low-alloy steels, and has a wide range of utility when used with expert technique in alloy steels. Considerable addition of silicon above 1.75% increases the hardness and the corrosion resistance, but reduces the ductility and makes the steel brittle. The lower grades can be rolled, however, and silicon-steel sheet is used for electric transformer laminations. Silicon forms a chemical combination with the metal, forming an iron silicide. The value of silicon steel as a Transformer steel was discovered by Hadfield in 1883. Silicon increases the electrical resistivity and also decreases the hysteresis loss, making silicon steel valuable for magnetic circuits where alternating current is used. Tran-Cor is a high-silicon steel produced by the American Rolling Mill Co. for cores for electrical transformers. Electrical steel, or Electric sheet, is sheet steel for armatures and transformers, in various grades from 1 to 4.5% silicon. Hipersil is a high-permeability silicon steel of the Westinghouse Electric Corp. The Relay steel of the Allegheny Ludlum Steel Co., used for relays and magnets, contains 0.5 to 2.75% silicon.

A very tough and strong tool steel for forming tools, pneumatic tools, and long punches is made with the addition of silicon and some molybdenum. Solar steel, of the Carpenter Steel Co., has 1% silicon, 0.50 molybdenum, 0.40 manganese, and 0.50 carbon. It is water-hardening, and has a breaking strength of 323,000 psi, with elongation 4.5%. Silman steel, of the Vanadium Alloys Steel Co., has

*2.1% silicon, 0.25 chromium, 0.30 vanadium, 0.85 manganese, and 0.55 carbon. The silicon gives it wear-resistant properties, making it suitable for shear blades and punches; the other alloying elements give toughness and resistance to fatigue. These steels are often referred to as Shock-resistant steel. Black giant steel, of the Bethlehem Steel Co., for bending, drawing, and stamping dies, has 1.4% carbon, 2.2 silicon, 0.90 manganese, 0.45 chromium, and 0.5 tungsten. The high silicon precipitates some of the carbon in graphitic form, giving the steel a low coefficient of friction and high resistance to wear.*

As a casting metal, steel or iron containing considerable amounts of silicon makes sound castings without blow holes, as the silicon aids in the deoxidation of the molten metal. The silicon-manganese steels with silicon up to 2% and up to about 1% manganese are tough, strong, and wear-resistant, and are useful for gears, cams, and rolls. A steel with 1.5% silicon, 0.50 manganese, and 0.40 carbon has a tensile strength of 110,000 psi and elongation 18%. SAE steel 9255 has 2% silicon and 0.75 manganese. Silicon, up to 1%, is used in nickel and chromium steels to increase hardness and to resist oxidation at high temperatures. Larger amounts of silicon are used to give acid resistance.

**Silicones.** A group of resinlike materials in which silicon takes the place of the carbon of the organic synthetic resins. Silicon is quadrivalent like carbon, and is thus capable of forming long molecular chains like those present in the carbon compounds. The molecular structure, however, is somewhat different. In the long-chain organic synthetic resins the carbon atoms repeat themselves, attaching themselves on two sides to other carbon atoms, while in the silicones the silicon atom alternates with an oxygen atom so that the silicon atoms are not tied to each other. The polymerization of the silicone monomer may be carried out in the same manner as with organic synthetic resin monomers to produce resinlike materials from liquids or soft rubbery masses to hard and tough solids. They are classed as Inorganic plastics as distinct from the older Organic plastics. They are more heat-resistant than the organic resins, and have higher dielectric strength. They are also highly water-resistant. They can be compounded with plasticizers, fillers, and pigments. For varnishes

and insulating coatings they are applied in solvent solution and cured at 450 to 500°F. Silicone insulating varnishes will withstand continuous operating temperatures at 350°F or higher. Silicone enamels and paints are more resistant to chemicals than most organic plastics, and when pigmented with mineral pigments will withstand temperatures up to 1000°F. For lubricants the liquid silicones are compounded with graphite or metallic soaps and will operate between -50 and 500°F. The silicone liquids are stable at their boiling points, between 750 and 800°F, and have low vapor pressures, so that they are also used for hydraulic fluids and heat-transfer media.

Silicone rubber is a long-chain Dimethyl silicone which will flow under heat and pressure, but can be vulcanized by cross linking the linear chains. Basically, it consists of alternate silicon and oxygen atoms with two methyl groups attached to each silicon atom. The tensile strength is 300 psi, but with fillers it is raised to 600 psi. It is odorless and tasteless, is resistant to most chemicals but not to strong acids and alkalis, will resist heat to 500°F, and will remain flexible to -70°F. The dielectric strength is 500 volts per mil. Silastic, of the Dow Corning Corp., is a silicone rubber. It is a white rubbery material with an elongation of 70 to 115%, and has good adhesion to various materials. It is used for electric insulation, for coating fabrics, and for gaskets and other parts. The Silicone oils of this company, used for lubrication and as insulating and hydraulic fluids, are methyl silicone polymers. They retain a stable viscosity at both high and low temperatures. As hydraulic fluids they permit smaller systems to operate at higher temperatures. A phenyl ethyl silicone is used for impregnating glass-fiber cloth for electrical insulation and it has about double the insulating value of ordinary varnished cloth. A great variety of molecular combinations are obtainable in the silicon polymers, giving resins of varying characteristics. Those having one or more carbon-silicon bonds are termed Organosilicon polymers. Silicon tetramethyl,  $\text{Si}(\text{CH}_3)_4$ , is a liquid that boils at 26°C. Methyl chloro silane,  $(\text{CH}_3)_2\text{SiCl}_2$ , is a liquid used for waterproofing steatite and other ceramic electrical insulators. The ceramic is treated with the vapor from the silane which reacts with the moisture particle in the ceramic, forming a thin water-repellent coating of methyl silicone and hydrochloric acid, the latter then being washed off. Dri-Film 9977, of the General Electric Co., is a liquid mixture of dimethyl dichloro

silane and methyl trichloro silane, used for ceramic insulators. These chemicals, as well as the phenyl and vinyl compounds, are called Silanes and are used for the production of oils, insulators, and rubberlike resins. The silicon-chlorine groups in the molecules can be converted easily to Si-O, Si-N, Si-S, and other groups.

**Silk.** The fibrous material in which the silkworm, or larva of the moth *Bombyx mori*, envelops itself before passing into the chrysalis state. Silk is closely allied to cellulose and resembles wool in structure, but unlike wool it contains no sulphur. The natural silk is covered with a wax or silk glue which is removed by scouring in manufacture, leaving the glossy Fibroin, or raw-silk fiber. The fibroin consists largely of the amino acid Alanine,  $\text{CH}_3\text{CH}(\text{NH}_2)\text{CO}_2\text{H}$ , which can be synthesized from pyruvic acid. The fiber is unwound from the cocoon and spun into threads. Each cocoon has from 2,000 to 3,000 yd of thread. One pound of raw silk is obtained from  $2\frac{1}{2}$  lb of cocoons. The chief silk-producing countries are China, Japan, India, Italy, and France. Japanese raw silk is shipped in bales of 100 kin,  $133\frac{1}{3}$  lb. European silk bales weigh 220.5 lb, and Canton bales  $106\frac{2}{3}$  lb. The conditioned weight in shipping is the dry weight plus 11% moisture. A book is a bundle of Asiatic silk containing 50 to 60 skeins, about 4 to 4.5 lb. Floss silk is a soft silk yarn practically without twist, or is the loose waste silk produced by the worm when beginning to spin its cocoon. Hard silk is thrown silk from which the gum has not been discharged. Soft silk is thrown silk yarn, degummed, dyed or undyed. Souple silk is dyed skein silk from which little gum has been discharged. It is firmer but is less lustrous. Organizine silk is from the best grade of cocoons. Marabout silk, used for making imitation feathers, is a white silk, twisted, and dyed without discharging the gum. Silk waste is a term used to designate all silk other than that reeled from the cocoon. It includes cocoons not fit for reeling, partly unwound cocoons, broken filaments, mill waste, and discarded noils. It is used in the spun-silk yarn industry. Noils consist of the short, staple knotty combings.

In China the cultivation of the silkworm is claimed to date back to 2640 B.C. Silk was first woven in Rome about 50 B.C. The eggs of the silkworm were smuggled into Europe in the year 552. Sericulture, or silkworm culture, is a highly developed industry. The larvae,

which have voracious appetites, are fed on mulberry leaves for 24 days, after which they complete their cocoons in 3 to 4 days. In from 7 to 10 days these are heated to kill the chrysalis to prevent bursting of the shell. The reeling is done by hand and by machine. Wild silk is from a night peacock moth which does not feed on the mulberry. It is coarser and stronger, but darker in color and less lustrous. Tussah silk is a variety of wild silk from South China and India. Charka silk is raw silk produced in Bengal on native hand-reeling machines. Byssus silk is a long fiber from a mussel of Sardinia and Corsica which spins the thread to attach itself to rocks. The fiber is golden brown, soft, lustrous, and elastic, and not dissolved by acids or alkalies. It was formerly used for fine garments but is no longer obtained commercially. Canton silk is soft and fluffy, but is greenish in color and lacks firmness. It is from the *B. textor*, and is used for weft yarns and in crepes. This silk when grown in India and known as Indian silk is the finest of all silks with fibers 0.0004 in. compared with 0.001 in. for Japanese silk. Before the war Japan produced most of the silk of the world from a cultivated moth of the tussah variety, *Antheria yama mai*. Shantung silk is from a tussah moth, *A. pernyi*, which feeds on oak leaves.

The fabric called Shantung is a rough-textured plain-woven silk with irregular fillings, heavier, and more bumpy than pongee. Grosgrain is a heavy close-woven corded fabric of silk. It is used for tapestry, and in narrow widths for ribbons. China silk, or Habutai, is an unweighted all-silk fabric of close, firm, but uneven texture woven of low quality, unthrown raw silk in the gum, but it is also imitated with textiles with a silk warp and a rayon filling. The lightweight grades of 3, 3½, and 4 momme (42, 36, and 31 sq yd per lb) are classed as sheer fabrics, and are used for impregnated fabrics for umbrellas, raincoats, hospital sheetings. Unimpregnated habutai is used for curtains, lamp shades, handkerchiefs, and caps. Heavy-weight habutai of 12 momme, or 10 yd per lb, is used for parachutes. Pongee is a rough-textured plain-woven silk fabric with irregular filling yarns. It is made in natural color or dyed, and like China silk has a gummy feel. Bolting cloth, for screening flour, is a fine, strong, silk fabric. The yarn is a fine-thread, hard-twist, tram thrown in the gum from high-quality raw silk. The fabric has a lino weave with two warp threads swiveled around the weft. It comes in various



meshes, the finest having 166 to 200 threads per linear inch. It is produced on hand looms in Switzerland and France.

**Silver.** A white metal, symbol Ag, very malleable and ductile, and classed with the precious metals. It occurs in the native state, and also combined with sulphur and chlorine. Copper, lead, and zinc ores frequently contain silver; about 70% of the production of silver is a by-product of the refining of these metals. Mexico and the United States produce more than half of the silver of the world. Canada, Peru, and Bolivia are also important producers. Although nearly 90% of the silver produced in Arizona comes from copper ores, most of that produced in California is a by-product of gold quartz mining. It is profitable to extract the silver from lead ores having only 3 oz per ton. Silver is the whitest of all the metals and takes a high polish, but easily tarnishes in the air because of the formation of a silver sulphide. It does not corrode. It has the highest electrical and heat conductivity. The specific gravity is 10.7, and the melting point is 1762°F. When heated above the boiling point, it passes off as a green vapor. It is soluble in nitric acid and in hot sulphuric acid. The tensile strength of cast silver is 41,000 psi and Brinell hardness 59. The metal is marketed on a troy-ounce value.

Since silver is a very soft metal, it is not normally used industrially in its pure state, but is alloyed with a hardener, usually copper. Sterling silver is the name given to a standard high-grade alloy containing a minimum of 925 parts in 1,000 of silver. It is used for the best tableware, jewelry, and electrical contacts. Sterling silver is made by melting the silver and copper together in a crucible using a cover of charcoal. The 7.5% copper makes the alloy so hard that it requires annealing between rollings. When quenched from a temperature of 1400°F, sterling silver is as soft as 18 Rockwell, but when quenched from 700°F, it is hard, 47 Rockwell. Silver may sometimes be hardened with other elements besides copper. Silanca is a silver hardened with small amounts of zinc and antimony, but the name sterling is applied only to the Silver-copper alloy.

The standard grades of commercial silver are Fine silver, Sterling silver, and Coin silver. Fine silver is 99.9% pure. Coin silver is usually an alloy of 90% silver and 10 copper. Until recently, the ratio of value of silver to gold had remained for nearly 2,500 years

as 15.5 and 16 to 1. It is used for coinage, silverware, ornaments, silver plating, for alloying with gold, and in the form of its salts for photography and other uses. About 20 million ounces are used annually for photographic and motion-picture film. Electrical contacts are made frequently of fine silver and also of sterling silver, but mostly of coin silver since the higher proportion of copper hardens the metal and gives greater wear resistance. Silver-copper alloys with 80 to 90% silver can be age-hardened after quenching. With about 2.5% of the copper replaced by aluminum, the alloys can be age-hardened to 190 Brinell. The Silver powder of the Alloymet Mfg. Co., used for making pressed parts, is chemically precipitated. It has a purity of 99.97%, with particle size 200 to 400 mesh. Doré metal, used for jewelry, is silver containing some gold. Silver plating is sometimes done with a Silver-tin alloy containing 20 to 40 parts silver and the remainder tin. It gives a plate having the appearance of silver but with better wear resistance. Silver-clad sheet, made of a cheaper nonferrous sheet with a coating of silver rolled on, is used for food-processing equipment. It is resistant to organic acids but not to products containing sulphur. Silver-clad steel, used for machinery bearings, shims, and reflectors, is made with pure silver bonded to the billet of steel and then rolled. For bearings, the silver is 0.010 to 0.35 in. thick, but for reflectors the silver is only 0.001 to 0.003 in. thick.

**Silver nitrate.** Formerly known as Lunar caustic. A colorless, crystalline, poisonous, and corrosive material of the composition  $\text{AgNO}_3$  made by dissolving silver in nitric acid. It is used for silvering mirrors, for silver plating, and in indelible inks. It is an active oxidizing agent. It is used in combination with calcium chloride to prevent tooth decay, but cannot be used alone for this purpose as it blackens the teeth. Silver chloride,  $\text{AgCl}$ , is a white granular powder used in silver-plating solutions. This salt of silver and other halogen compounds of silver, especially Silver bromide,  $\text{AgBr}$ , are used for photographic plates and films. The image cast on the plate by the lens breaks down the compound in proportion to the intensity of the light. Silver chloride crystals in sizes up to 10 lb are grown synthetically by the Harshaw Chemical Co. for use as radar screens and for infrared and electrical applications. The crystals are cubical, and can be heated and pressed into sheets instead of being sawed. The

specific gravity is 5.56, index of refraction 2.071, and melting point 455°C. They are slightly soluble in water and soluble in alkalis. The crystals transmit more than 80% of the wave lengths from 50 to 200 microns. Silver sulphide,  $\text{Ag}_2\text{S}$ , is a gray-black, heavy powder used for inlaying in metal work. Silver potassium cyanide,  $\text{KAg}(\text{CN})_2$ , is a white, crystalline, poisonous solid used for silver-plating solutions.

**Silver solder.** High-melting-point solder employed for soldering joints where more than ordinary strength is required. The economy of silver solder is in the lower cost of labor in producing a tight, strong joint. Most silver solders are copper-zinc brazing alloys with the addition of silver, and the soldering is done with a blowtorch. They may contain from 9 to 80% silver, and the color varies from brass yellow to silver white. Cadmium may also be added to lower the melting point. Silver solders do not necessarily contain zinc, however, and may be alloys of silver and copper in proportions arranged to obtain the desired melting point and strength. A silver solder with a relatively low melting point contains 65% silver, 20 copper, and 15 zinc. It melts at 1280°F, has a tensile strength of 64,800 psi, and elongation 34%. The electrical conductivity is only 21% that of pure copper. A solder melting at 1400°F contains 20% silver, 45 copper, and 35 zinc. ASTM silver solder No. 3 is this solder with 5% cadmium replacing an equal amount of the zinc. It is a general-purpose solder. ASTM silver solder No. 5 contains 50% silver, 34 copper, and 16 zinc. It melts at 1280°F, and is used for electrical work and refrigeration equipment. Any tin present in silver solders makes them brittle; lead and iron make the solders difficult to work. Silver solders are malleable and ductile and have high strength. They are also corrosion-resistant and are especially valuable on food machinery and apparatus where lead is objectionable. They can be employed to braze stainless steels. Sil-Fos is the trade name of Handy & Harman, for a phosphor-silver brazing solder with a melting point of 1300°F. It contains 15% silver, 80 copper, and 5 phosphorus. Lap joints brazed with Sil-Fos have a tensile strength of 30,000 psi. The phosphorus in the alloy acts as a deoxidizer, and the solder requires little or no flux. It is used for brazing brass, bronze, and nickel alloys. The grade made by this company under the name of

Easy solder contains 65% silver, melts at 1325°F, and is a color match for sterling silver. TL silver solder of the same company has only 9% silver and melts at 1600°F. It is brass yellow in color, and is used for brazing nonferrous metals. A Lead-silver solder recommended by the Indium Corp. of America, to replace tin solder, contains 96% lead, 3 silver, and 1 indium. It melts at 310°C, spreads better than ordinary lead-silver solders, and gives a strength of 4,970 psi in the joint. The German Silberstein solder has 97.25% lead, 2.5 silver, and 0.25 copper. Silver-magnesium solder, used in Germany for brazing stainless-steel heat exchangers, contains 85% silver and 15 magnesium. It has a melting point at 1790°F, and retains high strength up to 850°F.

**Sisal.** The hard, strong, light-yellow to reddish fibers from the large leaves of the sisal plant, *Agave sisalana*, and the henequen plant, *A. fourcroydes*, employed for making rope, cordage, and sacking. About 80% of all binder twine is normally made from sisal, but sisal ropes have only 75% of the strength of Manila rope and are not as resistant to moisture. Sisal is a tropical plant, and grows best in semiarid regions. The agave plant is native to Mexico, but most of the sisal comes from Haiti, East Africa, and the East Indies. The retting, separation, and washing of the fiber are done by machine, and less than 5% of the weight of the leaf results in good fiber. The plant is cut for fiber after 3 years and produces for 5 years after. It is harvested throughout the year and yields 1,500 lb per acre. Mexican sisal is classed in seven grades from the Superior white fiber 105 cm in length to the grade C-1, short-spotted fiber 60 cm in length. Yucatan sisal, or Henequen, is from the henequen plant and is reddish in color, stiffer and coarser, and is used for binder twine. The Indian word henequen means knife, from the knifelike leaves. The plant is more drought-resistant than sisal. Henequen also comes from the East Indies as the spotted or reddish grades of sisal. Sisal is usually shipped in 400-lb bales. Maguey, or Cantala, is from the leaves of the *Agave cantala* of India, Philippines, and the Dutch East Indies. It is used for binder twine. The fibers are white, brilliant, stiff, and light in weight. The fibers are not as strong as sisal, but have a better appearance and greater suppleness. Zapupe fiber, of Mexico, is from the *A. zapupe*. The fiber is similar to sisal, finer

and softer than henequen. Salvador sisal, of El Salvador, is from the *A. letonae*. The leaves are more slender than Mexican sisal, and the fiber is softer and finer. It is used for cordage and fabrics.

The fibers of sisal are not as long or as strong as those of Manila hemp and swell when wet, but they are soft and are preferred for binder twine either alone or mixed with Manila hemp. Sisal fiber is also used instead of hair in cement plasters for walls and in laminated plastics. Corolite is a molded plastic of the Columbia Rope Co. made with a mat of sisal fibers so as to give equal strength in all directions. Agave fibers from other varieties of the plant are used for various purposes, notably Tampico, from the *A. rigida*, which yields a stiff, hard, but pliant fiber employed for circular power brushes, and Istle, a similar stiff brush fiber from several plants. Tampico is valued for polishing wheels, as the fibers hold the grease buffing compositions, and it is not brittle but abrades with flexibility. Jaumave istle is from the *A. funkiana* of Mexico. It yields long, uniform fibers finer than tampico. Lechuguilla is a type of istle from the *A. lechuguilla*.

There are at least 50 species of agave in Mexico and southwestern United States, which yield valuable by-products in addition to fiber. From some varieties saponin is obtained as a by-product. From a number of thick-leaved species the buds are cut off, leaving a cavity from which juice exudes. This juice is fermented to produce Pulque, a liquor with a ciderlike taste containing about 7% alcohol. The juice contains a sugar, Agavose,  $C_{12}H_{22}O_{11}$ , which is used in medicine as a laxative and diuretic.

**Slag.** The molten material that is drawn from the surface of iron in the blast furnace. Slag is formed from the earthy materials in the ore and from the flux. Slags are produced in the melting of other metals, but iron blast-furnace slag is usually meant by the term. Slag is used in cements and concrete, for roofing, and as a ballast for roads. Blast-furnace slag is one of the lightest concrete aggregates available. It has a porous structure and, when crushed, is angular. About 1,300 lb of slag is produced for every long ton of metallic iron. It is also crushed and used for making Pozzuolana and other cements. Slag contains about 32% silica, 14 alumina, 47 lime, 2 magnesia, and small amounts of other elements. It is crushed, screened, and graded for marketing. Crushed slag weighs 1,900 to 2,100 lb per cu yd, or

about 30% lighter than gravel. Honeycomb slag weighs only about 30 lb per cu ft. The finest grade of commercial slag is from  $\frac{3}{16}$  in. to dust; the run-of-crusher slag is from 4 in. to dust. Basic phosphate slag, a by-product in the manufacture of steel from phosphatic ores, is finely ground and sold for fertilizer. It contains not less than 12% phosphoric oxide,  $P_2O_5$ , and is known in Europe as Thomas slag. Foamed slag is a name used in England for honeycomb slag used for making lightweight, heat-insulating blocks. A superphosphate cement is made in Belgium from a mixture of basic slag, slaked lime, and gypsum. Vast quantities of American slags are crushed and used for roads and railway ballast and for cement blocks. The finely crushed slag is used in agriculture for neutralizing acid soils.

**Slate.** A shale possessing a straight cleavage. Most shales are of sedimentary origin, and their cleavage was the result of heavy or long-continued pressure. In some cases slates have been formed by the consolidation of volcanic ashes. The slaty cleavage does not usually coincide with the original stratification. Slate is of various colors, black, gray, green, and reddish. It is used for electric panels, blackboards, slate pencils, table tops, roofing shingles, floor tiles, and treads. The terms Flagstone and Cleftstone are given to large flat sections of slate used for paving, but the names are also applied to blue sandstones cut for this purpose. Slate is quarried in large blocks, and then slabbed and split. The chief slate-producing states are Pennsylvania, Vermont, Virginia, New York, and Maine. Roofing slates vary in size from 12 by 6 in. to 24 by 14 in., and from  $\frac{1}{8}$  to  $\frac{3}{4}$  in. in thickness, and are usually of the harder varieties. The roofing slate from coal beds is black, fine-grained, and breaks into brittle thin sheets. It does not have the hardness or weather resistance of true slate. As late as 1915 more than 85% of all slate mined was used for roofing, but the tonnage now used for this purpose is small. Ribbon slate, with streaks of hard material, is inferior for all purposes. Lime impurities can be detected by the application of dilute hydrochloric acid to the edges and noting if rapid effervescence occurs. Iron is a detriment to slates for electric purposes. The average compressive strength of slate is 15,000 psi and the weight 175 lb per cu ft. Slate flour is ground slate used as a filler in linoleum and in calking compounds. Slate lime is an intimate mixture of finely

divided calcined slate and lime, about 60% by weight lime to 40 slate. It is employed for making porous concrete for insulating partition walls. The process consists in adding a mixture of slate lime and powdered aluminum, zinc, or magnesium to the cement. The gas generated on the addition of water makes the cement porous.

**Smoke agents.** Chemicals used in warfare to produce an obscuring cloud or fog to hide movements. Smokes may be harmless and are then called Screening smokes, or Smoke screens, or they may be toxic and called Blanketing clouds. There are two types of smokes: those forming solid or liquid particles, and those forming fogs or mists by chemical reaction. The first naval smoke screens were made by limiting the admission of air to the fuel in the boilers, and the first Army Smoke pots contained mixtures of pitch, tallow, saltpeter, and gunpowder. The British Smoke candles contained 40% potassium nitrate, 29 pitch, 14 sulphur, 8 borax, and 9 coal dust. They gave a brown smoke, but one that lifted too easily.

The fog used by the American Army on the Rhine was an oil mixture sprayed at high velocity into the air. The microscopic droplets were calculated to be so small that there were 70,000 billion per cubic inch. The spray made an impenetrable fog which remained for a long period. White phosphorus gives a dense white smoke by burning to the pentoxide and changing to phosphoric acid in the moisture of the air. Its vapor is toxic. Sulphuric trioxide,  $\text{SO}_3$ , is an effective smoke producer in humid air. It is a mobile, colorless liquid vaporizing at  $45^\circ\text{C}$  to form dense white clouds with an irritating effect. The French Opacite is Tin tetrachloride,  $\text{SnCl}_4$ , a liquid that fumes in the air. The smoke is not as dense, but it penetrates gas masks and is corrosive. Sulphuryl chloride,  $\text{SO}_2\text{Cl}_2$ , is a liquid that decomposes on contact with the air into sulphuric and hydrochloric acids. F.S. smoke is made with a mixture of chlorosulphonic acid and sulphur trioxide. Silicon tetrachloride,  $\text{SiCl}_4$ , is a colorless liquid that boils at  $60^\circ\text{C}$ , and fumes in the air forming a dense cloud. Mixed with ammonia vapor it resembles a natural fog. The heavy mineral known as Amang, separated from tin ore, containing ilmenite and zircon, is used in smoke screens. Titanium tetrachloride,  $\text{TiCl}_4$ , is a colorless to reddish liquid boiling at  $136^\circ\text{C}$ . It is used for smoke screens and for skywriting from airplanes. In moist air it forms dense, white

fumes of Titanic acid,  $\text{H}_2\text{TiO}_3$ , and hydrogen chloride. The commercial liquid contains about 25% titanium by weight.

A common smoke for airplanes is Oleum. It is a mixture of sulphur trioxide in sulphuric acid, which forms fuming sulphuric acid, or Pyrosulphuric acid,  $\text{H}_2\text{S}_2\text{O}_7$ . The dense liquid is squirted into the exhaust manifold. Zinc smoke is made with mixtures of zinc dust or zinc oxide with various chemicals to form clouds. H.C. smoke is zinc chloride with an oxidizing agent to burn up residual carbon so that the smoke will be gray and not black. Signal smoke is colored smoke used for signaling in war, aviation and ship distress signals, and for aviation marking signals. They are mixtures of a fuel, an oxidizing agent, a dye, and sometimes a cooling agent to regulate the rate of burning and to prevent decomposition of the dye. Only definite, unmistakable colors are used so that the signals may be distinguished from fires, and the dyes are mainly anthraquinone derivatives. Sugar is one of the best combustible materials with potassium chlorate as the oxidizing agent, and either potassium or sodium bicarbonate as the cooling agent.

**Snakeskins.** The snakeskins employed for fancy leathers are in general the skins of large tropical snakes which are notable for the beauty or oddity of their markings. Snakeskins for shoe upper leathers, belts, and handbags are glazed like kid and calfskin after tanning. Small cuttings are used for inlaying on novelties. The leather is very thin, but is remarkably durable and is vegetable-tanned and finished in natural colors, or is dyed. Python skins are widely used for ladies' shoes. Regal python skins from Borneo, the Philippines, and the Malay Peninsula sometimes measure 30 ft in length and have characteristic checked markings. Diamond-backed rattlesnakes are raised on snake farms in the United States. The meat is canned as food, and the skins tanned into leather. Only the back is used for leather, as the belly is colorless.

**Soap.** A cleansing compound produced by saponifying oils, fats, or greases with an alkali. When caustic soda is added to fat, glycerin separates out, leaving Sodium oleate,  $\text{Na}(\text{C}_{18}\text{H}_{33}\text{O}_2)$ , which is soap. But since oils and fats are mixtures of various acid glycerides, the soaps made directly from vegetable and animal oils may be mixtures of oleates, palmitates, linoleates, and laurates. If an excess of alkali is



used, the soap will contain free alkali, and the greater the proportion of the free alkali the coarser is the action of the soap. ASTM standards for milled toilet soap permit only 0.17% free alkali. Sodium soaps are always harder than potassium soaps with the same fat or oil. Hard sodium soaps are used for chips, powders, and toilet soaps. Soft caustic potash soaps are the liquid, soft, and semisoft pastes. Mixtures of the two are also used. Soaps are made by either the boiled process or the cold process. Chip soap is made by pouring the hot soap onto a cooled revolving cylinder from which the soap is scraped in the form of chips or ribbons which are then dried to reduce the moisture content from 30 to 10%. Soap flakes are made by passing chips through milling rollers to make thin, polished, easily soluble flakes.

Powdered soap is made from chips by further reducing the moisture and grinding. Milled soaps are made from chips by adding color and perfumes to the dried chips and then passing through milling rollers and finally pressing in molds. Toilet soaps are made in this way. Nearly half of the American production of soaps consists of granulated, powdered, chips, flakes, and scouring powders. Only about 10% is toilet soap. Soap is used widely in industrial processing in the textile and other industries, and is one of the indicators of industrialization. The American consumption increased from 21.6 lb per capita in 1920 to 25.4 lb in 1930, and 28.1 lb in 1940, but in the next decade an increasing proportion of synthetic detergents replaced soaps for both household and industrial uses. Soaps have definite limitations of use. They are unstable in acid solutions and may form insoluble salts. In hard waters they may form insoluble soaps of calcium or magnesium, unless a phosphate is added. Many industrial cleansers, therefore, may be balanced combinations of soaps, synthetic detergents, phosphates, or alkalies, designed for particular purposes.

About half of all soap is made with tallow, 25% with coconut oil, and the remainder with palm oil, greases, fish oils, olive oil, soybean oil, or mixtures. A typical American soap contains 80% mixed oils and 20 coconut oil, with not over 0.2 free alkali. The wartime soap used in Germany called Rif had only 40% fat content, with the remainder sodium silicate, kaolin, or clays. Auxiliary ingredients are used in soap to improve the color, for perfuming, as an astringent,

or for abrasive or harsh cleansing purposes. Phenol or other antiseptics are used in Antiseptic soap. The Disinfectant soap used by the Army contained 2% "G-11" which was dihydroxyhexachloro diphenyl methane. Solvents are added to industrial soaps for scouring textiles or when used in soluble oils in the metal industry. Zinc oxide, benzoic acid, and other materials are used in facial soaps with the idea of aiding complexion. Excessive alkalinity in soaps dries and irritates the skin, but Hand grit soap usually has 2 to 5% alkaline salts such as borax or soda ash and 10 to 25% abrasive minerals. Softer Hand soap may contain marble flour. Silicate of soda, used as a filler, also irritates the skin. Transparency usually varies with the content of coconut, palm, or olive oil. Castile soap is a semitransparent soap made with olive oil. Marseilles soap and Venetian soap are names for castile soap with olive oil and soda. Ordinary soft soaps used as bases for toilet soap are made with linseed and olive-oil mixtures. Linseed oil, however, gives a disagreeable odor. Soybean oil, corn oil, and peanut oil are also used, although peanut oil, unless the arachidic acid is removed, makes a hard soap. Tall oil soaps are sodium soaps made from the fatty acids of tall oil. They are inferior to sodium oleate in detergency, but superior to sodium rosinate.

Saddle soap is any soap used for cleaning leather goods which has the property of filling and smoothing the leather as well as cleaning. The original saddle soaps were made of palm oil, rosin, and lye, with glycerin and beeswax added. Oil for the best soaps are of the non-drying type. Soft soap of USP grade always has a therapeutic value. High-grade soft soap for industrial use is made with coconut or palm kernel oil with caustic potash. But soft soap in paste form is generally made of low titer oils with caustic soda, usually linseed, soybean, or corn oil. The lauric acid of coconut oil gives the coconut oil soaps their characteristic of profuse lathering, but lauric acid affects some skins by causing itching. Palm-kernel oil develops free acids, and upon aging the soap acquires the odor of the oil. Palm oil produces a crumbly soap. It does not lather freely, but is mild to the skin. Olive oil is slow lathering, but has good cleansing powers. It is often used in textile soaps. Cottonseed oil is used in some laundry soaps, but develops yellow spots in the soap. Corn oil with potash makes a mild soft soap. Soybean oil also makes a soft soap. Rosin is used to make yellow laundry soaps. ASTM standards for bar soap permit up to

25% rosin. Sulphonated oils do not give as good cleansing action as straight oils, but are used in shampoos where it is desirable to have some oil or greasiness. Blending of various oils is necessary to obtain a balance of desired characteristics in a soap. Hand soaps may be made with trisodium phosphate or with disodium phosphate, or Sodium perborate,  $\text{NaBO}_3 \cdot \text{H}_2\text{O}$ , known as Perborin, all of which are crystalline substances which are dissolved in water solution. Soap powder is Granular soap made in a vacuum chamber or by other special processes. It usually contains 15 to 20% soap and the balance sodium carbonate. Scouring powder is an intimate mixture of soap powder and an insoluble abrasive such as pumice. Floating soaps are made light by blowing air through them while in the vats. Soapless shampoos and tooth powders contain saponin or chemical detergents.

**Soapstone.** A massive variety of impure talc employed for electric panels, gas-jet tips, stove linings, tank linings, and as an abrasive. It can be cut easily and becomes very hard when heated because of the loss of its combined water. The waste product from the cutting of soapstone is ground and used for the same purposes as talc powder. Steatite is a massive stone rich in talc that can be cut readily, while soapstone may be low in talc. When free of iron oxide and other impurities, block steatite is used for making spacer insulators for electronic tubes and for special electrical insulators. Block steatite suitable for electric insulation is mined in Montana and in India and Sardinia. Steatite is also ground and molded into insulators. It can be purified of iron and other metallic impurities by electrolytic osmosis. When fluxed with alkaline earths instead of feldspar, the molded steatite ceramics have a low loss factor at high frequencies, and have good electrical properties at high temperatures.

Alberene stone, quarried in Virginia, is blue-gray in color. The medium-hard varieties are used for building trim and for chemical laboratory tables and sinks, and the hard varieties are employed for stair treads and flooring. Alberene stone marketed by the Alberene Stone Corp. as a basic refractory substitute for chrome or magnesite for medium temperatures has a fusion point of  $2400^\circ\text{F}$ . Virginia greenstone is a gray-green soapstone resistant to weathering, used as a building stone. Talc crayons for marking steel are sticks of soapstone.

**Soda ash.** The common name for anhydrous Sodium carbonate,  $\text{Na}_2\text{CO}_3$ , which is the most important industrial alkali. It is a grayish-white lumpy material, which loses water of crystallization when heated. For household use in hydrous crystallized form,  $\text{Na}_2\text{CO}_3 \cdot 10\text{H}_2\text{O}$ , it is called Washing soda, Soda crystals, or Sal soda, as distinct from Baking soda, which is Sodium hydrogen carbonate, or Sodium bicarbonate,  $\text{NaHCO}_3$ . Sal soda contains more than 60% water. Another grade, with one molecule of water,  $\text{Na}_2\text{CO}_3 \cdot \text{H}_2\text{O}$ , is the standard product for scouring solutions. Federal specifications call for this product with a total alkalinity not less than 49.7%  $\text{Na}_2\text{O}$ . Commercial high-quality soda ash contains 99% min  $\text{Na}_2\text{CO}_3$ , or 58 min  $\text{Na}_2\text{O}$ . It varies in size of particle and in bulk density, being marketed as extra-light, light, and dense. The extra-light has a density of 23 lb per cu ft, and the dense is 63 lb per cu ft. Laundry soda is soda ash mixed with sodium bicarbonate, with 39 to 43%  $\text{Na}_2\text{O}$ . Modified sodas, used for cleansing where a mild detergent is required, are mixtures of sodium carbonate and sodium bicarbonate. They are used in both industrial and household cleaners. Tanners' alkali, used in processing fine leathers, and Textile soda, used in fine wool and cotton textiles, are modified sodas. Flour bland, used by the milling industry in making free-flowing, self-raising food flours, is a mixture of sodium bicarbonate and tricalcium phosphate.

Soda ash is made by the Solvay process, which consists in treating a solution of common salt with ammonia and with carbon dioxide and calcining the resulting filter cake of sodium bicarbonate to make Light soda ash. Dense soda ash is then made by adding water and recalcination.

Soda ash is less expensive than caustic soda and is used for cleansing, for softening water, in glass as a flux, and to prevent fogging, in the wood-pulp industry, for refining oils, in soapmaking, and for the treating of ores. Caustic ash, a strong cleaner for metal scouring and for paint removal, is a mixture of about 70% caustic soda and 30 soda ash. Flake alkali, of the Columbia Chemical Div., Pittsburgh Plate Glass Co., contains 71% caustic soda and 29 soda ash. Soda ash is also used as a flux in melting iron to increase the fluxing action of the limestone, as it will carry off 11% sulphur in the slag. Soda briquettes, used for desulphurizing iron, are made of soda ash formed into pellets with a hydrocarbon bond. Hennig purifier is

soda ash combined with other steel-purifying agents made into pellets. The natural hydrous sodium carbonate of Egypt and Libya is called Nitron. Natural soda ash is also obtained in Wyoming from thick beds located 1,500 ft underground which contain 47%  $\text{Na}_2\text{CO}_3$ , 36  $\text{NaHCO}_3$ , and water of crystallization, designated as Trona. The salt brine of Owens Lake, California, is an important source of soda ash. The brine, which contains 10.5%  $\text{Na}_2\text{CO}_3$  and 2.5 Sodium borate decahydrate, is concentrated and treated to precipitate the trona. Soda ash and sodium carbonate may be sold under trade names. Purite is sodium carbonate of the Mathieson Alkali Works.

**Sodium.** A metallic element, symbol Na, and atomic weight 23, occurring only in the form of its salts. The most important mineral containing sodium is the chloride, NaCl, which is common salt. It also occurs as the nitrate, Chile saltpeter, as a borate in borax, and as a fluoride and a sulphate. When pure, sodium is silvery white, ductile, melts at  $97.6^\circ\text{C}$ , and boils at  $877^\circ\text{C}$ . The specific gravity is 0.972. It can be obtained in metallic form by the electrolysis of salt. When exposed to the air, it oxidizes rapidly and must be kept in airtight containers. Sodium is a powerful desulphurizer for iron and steel. It is used in the form of soda-ash pellets. Desulphurizing alloys for brasses and bronzes are Sodium-tin, with 95% tin and 5 sodium, or Sodium-copper. Sodium is widely used in industry in the form of its salts, particularly sodium chloride and soda ash. Sodium dichromate,  $\text{Na}_2\text{Cr}_2\text{O}_7 \cdot 2\text{H}_2\text{O}$ , a red powder, is used in hot-water solution with sulphuric acid to give a golden-brown brass finish to zinc parts. Cronak, of the New Jersey Zinc Co., is a name applied to this finish.

**Sodium aluminate.** A white powder of the composition  $\text{Na}_2\text{Al}_2\text{O}_4$ , used as a water-softening agent with lime and soda in steam boilers. It has a melting point of  $1800^\circ\text{C}$  and is soluble in water. It is made by the reaction of alumina with some source of sodium oxide such as caustic soda or soda ash, or by heating bauxite with sodium carbonate and extracting with water.

**Sodium cyanide.** A salt of hydrocyanic acid of the composition NaCN, used for carbonizing steel for casehardening, for heat-treating baths, for electroplating, and for the extraction of gold and silver

from their ores. For carburizing steel it is preferred to potassium cyanide because of its lower cost and its higher content of available carbon. It contains 53% CN, as compared with 40% in potassium cyanide. The nitrogen also aids in forming the hard case on the steel. The 30% grade of sodium cyanide, melting at 1156°F, is used for heat-treating baths instead of lead, but it forms a slight case on the steel. Sodium cyanide is very unstable, and on exposure to moist air liberates the highly poisonous Hydrocyanic acid gas, HCN. For gold and silver extraction it easily combines with the metals, forming soluble double salts,  $\text{NaAu}(\text{CN})_2$ . Sodium cyanide is made by passing a stream of nitrogen gas over a hot mixture of sodium carbonate and carbon in the presence of a catalyst. It is a white crystalline powder, soluble in water. It is usually packed in 100- and 200-lb containers, made up in 1-oz briquettes, 4-oz eggs, or fused and broken. Cyanegg is the name of the E. I. du Pont de Nemours & Co., Inc., for 96 to 98% sodium cyanide in egg shape for casehardening steel. The melting point is 1040°F. The white Copper cyanide used in electroplating has the composition  $\text{Cu}_2(\text{CN})_2$ , containing 70% copper. It melts at 474.5°C, is insoluble in water, but is soluble in sodium cyanide solution. Sodium ferrocyanide, or yellow Prussiate of soda, is a lemon-yellow crystalline solid of the composition  $\text{Na}_4\text{Fe}(\text{CN})_6 \cdot 10\text{H}_2\text{O}$ , used for carbonizing steel for casehardening. It is also employed in paints and printing inks and for the purification of organic acids. It is soluble in water. Calcium cyanide in powder or granulated forms is used as an insecticide. It liberates 25% of hydrocyanic acid gas. Cyanogas, of the American Cyanamid Co., is gaseous HCN from calcium cyanide.

**Sodium hydroxide.** Known commonly as Caustic soda, and also as Sodium hydrate. Lye is an old name used in some industries and in household uses. A white, massive crystalline solid of the composition NaOH, used for scouring and cleaning baths, for etching aluminum, in quenching baths for heat-treating steel, in cutting and soluble oils, and in a wide variety of other commercial uses. Sodium hydroxide is made by the causticization of soda ash or by the electrolysis of salt. The specific gravity is 2.13 and melting point 318°C. It is soluble in water, alcohol, and in glycerin. Sodium hydroxide is sold in liquid and in solid or powder forms on the basis of its  $\text{Na}_2\text{O}$  content. A

high-grade commercial caustic soda contains 98% min NaOH equivalent to 76 min  $\text{Na}_2\text{O}$ . The liquid contains 50% min NaOH. Phosflake, of the Columbia Chemical Div., Pittsburgh Plate Glass Co., used in washing machines, is a mixture of caustic soda and trisodium phosphate. Caustic potash is Potassium hydroxide, KOH, which has the same uses but is more expensive. Caustic potash is a white, lumpy solid. It is soluble in water and makes a powerful cleansing bath for scouring metals. It is marketed as solid, flake, granular, or broken, and also in 40 and 50% liquid solutions. It is also used in soaps and for bleaching textiles. When used in steel-quenching baths, it gives a higher quenching rate than water alone and does not corrode the steel like a salt solution.

**Sodium nitrate.** Also called Soda niter and Chile saltpeter. A mineral found in large quantities in the arid regions of Chile, Argentina, and Bolivia, where the crude nitrate with iodine and other impurities is called Caliche. It is used for making nitric and sulphuric acids, for explosives, as a flux in welding, and as a fertilizer. The composition is  $\text{NaNO}_3$ . It is usually of massive granular crystalline structure with a hardness of 1.5 to 2 and specific gravity 2.29. It is colorless to white, but sometimes colored by impurities. It is readily soluble in water. In other parts of the world it occurs in beds with common salt, borax, and gypsum. Synthetic Chile saltpeter is made by nitrogen fixation and is marketed granulated, in crystals, or in sticks. It is colorless, odorless, has a specific gravity of 2.267 and a melting point  $316^\circ\text{C}$ . It has a bitter, saline taste. Norway saltpeter, used in fertilizers and explosives, is Calcium nitrate,  $\text{Ca}(\text{NO}_3)_2$ , in colorless crystals soluble in water. Calcium nitrate of fine crystal size is used as a coagulant for rubber latex.

**Sodium silicate.** A water-soluble salt commonly known as Water glass or Soluble glass. Chemically, it is Sodium metasilicate of the composition  $\text{Na}_2\text{SiO}_3$  or  $\text{NaSiO}_3 \cdot 9\text{H}_2\text{O}$ . Two other forms of the silicate are also available, Sodium sesquisilicate,  $3\text{Na}_2\text{O} \cdot 2\text{SiO}_2$ , and Sodium orthosilicate,  $2\text{Na}_2\text{O} \cdot \text{SiO}_2$ . All of these are noted for their powerful detergent and emulsifying properties, and for their suspending power. The material has good adhesion, and large quantities are used in water solutions for industrial adhesives. When solid, sodium

silicate is glassy in appearance and dissolves in hot water. It melts at  $1018^{\circ}\text{C}$ . It is obtained by melting sodium carbonate with silica, or by melting sand, charcoal, and soda. The fused product is ground and dissolved in water by long boiling. Potassium silicate is made in the same way, or a double soluble glass is made by using both sodium and potassium carbonates. Potassium silicate is more soluble than sodium silicate. Kasil, of the Philadelphia Quartz Co., is a potassium silicate, a colorless sirupy liquid with 19.5%  $\text{SiO}_2$  and 7.8 of  $\text{K}_2\text{O}$ , used for welding rods.

Sodium silicate is marketed as a viscous liquid or in powder form. It is used as a detergent, as a protection for wood and porous stone, as a fixing agent for pigments, for cementing stoneware, for lute cements for such uses as sealing electric-light bulbs, for waterproofing walls, greaseproofing paper containers, for coating welding rods, as a filler for soaps, and as a catalyst for high-octane gasoline. It increases the cleansing power of soaps but irritates the skin. However, it is used in cleaning compounds because it is a powerful detergent. Sodium silicate is also used for insulating electric wire. It is applied in solution and the coated wire is then heated, leaving a flexible coating. Mixed with whiting it is used as a strong cement for grinding wheels. Sodium metasilicate marketed by the Philadelphia Quartz Co. as a cleaner of metals is a crystalline powder. Hot solutions of this salt in water are caustic and will clean grease readily from metals. Drymet, of the Cowles Detergent Co., is the anhydrous sodium metasilicate. It is a fine white powder with total alkalinity of 51%  $\text{Na}_2\text{O}$ . It is easily soluble in water, and is used as a detergent and in soap powders to give free-flowing, noncaking properties. The anhydrous material for a given detergent strength weighs little more than half the weight of the hydrous powder. Dryorth is the anhydrous material of 60% alkalinity. It is a powerful detergent and grease remover. Crystamet, of the same company, is the material with 42% water of crystallization. It is a free-flowing white powder. Penchlor, of the Pennsylvania Salt Mfg. Co., is an Acidproof cement made by mixing cement powder with a sodium silicate solution. It is used for lining chemical tanks and drains. Aquagel, of the Silica Products Co., is a hydrous silicate of alumina, used in the same manner for waterproofing concrete.



**Solder.** An alloy of two or more metals used for joining other metals together by surface adhesion. A requirement is that it have a lower melting point than the metals being joined, and also have an affinity for, or be capable of uniting with, the metals to be joined. The most common solder is called Half-and-half, or Plumbers' solder, and is composed of equal parts of lead and tin. It melts at 360°F. The weight of this solder is 0.318 lb per cu in., tensile strength 5,500 psi, and the electrical conductivity 11% that of copper. SAE Solder No. 1 has 49.5 to 50.5% tin, 50 lead, 0.12 max antimony, and 0.08 max copper. It melts at 357.8°F. Much commercial half-and-half, however, usually contains larger proportions of lead and some antimony, with less tin. These mixtures have higher melting points, and solders with less than 50% tin have a wide melting range and do not freeze quickly. Sometimes a wide melting range is desired, in which case a Wiping solder with 38 to 45% of tin is used. Solder No. 4663, of the Westinghouse Electric Corp., is a narrow-melting-range solder, melting from 183 to 185°C, while Solder No. 1580 is a wiping solder with a melting range from 183 to 231°C. The first contains 60% tin and 40 lead, and the second has 42% tin and 58 lead. Slicker solder is the best quality of plumbers' solder, containing 63 to 66% tin and the balance lead. The earliest solders were the Roman solder called Argentarium, containing equal parts of tin and lead, and Tertiarium, containing 1 part tin and 2 lead. Both alloys are still in use, and throughout early industrial times Tertiarium was known as Tinman's solder.

Good-quality solders for electrical joints should have at least 40% tin, as the electrical conductivity of lead is only about half that of tin, but conductivity is frequently sacrificed for better wiping ability, and the wiping solders are usually employed for electrical work. Soft solders should not contain zinc because of poor adhesion from the formation of oxides. Various melting points to suit the work are obtained with solders by varying the proportions of the metals. The low-melting-point solders are those that have a melting point at 230°C or lower, and the high-melting-point solders melt at 705°C and higher. The flow point, at which the solder is entirely liquid, is often considerably above the melting point. Tin added to lead lowers the melting point of the lead until at 356°F, or 68% tin, the melting point rises with increase in tin content until the melting point of

pure tin is reached. A standard solder with 48% tin and 52 lead melts at 360°F. A 45-55 solder melts at 440°F. Cheap solders may contain as low as 25% tin, but they do not adhere well. SAE solder No. 4 contains 22.5 to 23.5% tin, 75 lead, and 2 max antimony. It melts at 370.4°F.

Solders with low melting points are obtained from mixtures of lead, tin, and bismuth. Bismuth solder is also more fluid, as the bismuth lowers the surface tension. Bismuth, however, hardens the alloy, although to a lesser extent than antimony. A bismuth solder containing equal parts of lead, tin, and bismuth melts at 284°F. Cadmium solders have low melting points, are hard, and are usually cheaper than tin solders, but they have the disadvantage of blackening and corroding, and the fumes are toxic. In Germany Cadmium zinc solders were used because of the scarcity of tin. A solder containing 80% lead, 10 tin, and 10 cadmium has about the same strength as a 50-50 tin-lead solder and has greater ductility, but is darker in color. Cadmium-tin solder, with high cadmium, is used to solder magnesium alloys. Soft solders for soldering brass and copper, especially for electrical connections, may be of tin hardened with antimony. Solder wire, marketed by the American Brass Co. for this purpose, contains 95% tin and 5 antimony. Thallium may be used in high-lead solders to increase strength and adhesion.

Hard solders may be any solder with a melting point above that of the tin-lead solders; more specifically they are the brazing solders, silver solders, or aluminum solders applied with a brazing torch. Aluminum solders may contain up to 15% aluminum. Soluminium, an early German solder, contained 55% tin, 33 zinc, 11 aluminum, and 1 copper. Mouray's solder contained 80 to 90% zinc, 3 to 8 copper, and 6 to 12 aluminum. A solder prepared by the National Bureau of Standards contains 78% tin, 8 zinc, and 5 aluminum. It has good strength and ductility. The solder known as Richard's solder is a yellow brass with 3% aluminum and 3 phosphor tin. Solders with nickel content are used for soldering nickel silver, and silver and gold solders are used for jewelry work. Silver solder in varying proportions is also used as a high-melting-point solder for general work, and small amounts of silver are sometimes used in lead-tin solders to conserve tin, but the melting point is high. Lead-silver solders with more than 90% lead and some silver, in use during

the war emergency, had high melting points and poor spreading qualities. Indium improves these solders, and a solder with 96% lead, 3 silver, and 1 indium has a melting point at 310°C and a tensile strength of 4,970 psi. Adding 0.85% silver to a 40% tin soft solder gives equivalent wetting on copper alloys to a 63% tin solder, but the addition is not effective on low-tin solders. A Gold-copper solder used for making high-vacuum seals and for brazing difficult metals such as iron-cobalt alloys, contains 37.5% gold and 62.5 copper. The Cold solder used for filling cracks in metals may be a simple mixture of pyroxylin cement with aluminum powder, or it may be a vinyl resin with aluminum powder and colloidal silica in a solvent to form a puttylike paste.

**Solvents.** Liquids having the power of dissolving various materials. The usual commercial solvents for organic substances are the alcohols, ether, benzene, and turpentine, the latter two being common solvents for paints and varnishes containing gums and resins. The so-called Coal-tar solvents are light oils from coal tar, distilling off between 150 and 270°C, the Hi-flash solvent being a water-white liquid of specific gravity 0.855 to 0.890, distilling between 150 and 185°C, with a flash point above 100°F. Carbon bisulphide and dichlorethylene are good solvents for rubber. Ethyl acetate,  $\text{CH}_3\text{-COOC}_2\text{H}_5$ , made from ethyl alcohol and acetic acid, is an important solvent for nitrocellulose and lacquers. It is a liquid boiling at 77°C. One of the best solvents for cellulose is cuprammonium hydroxide. Amyl and other alcohols, amyl acetate, and other volatile liquids are used for quick-drying lacquers, but many synthetic chemicals are available for such use. Dioxan, a water-white liquid of specific gravity of 1.035 and composition  $\text{CH}_2\text{CH}_2\text{OCH}_2\text{CH}_2\text{O}$ , is a good solvent for cellulose compounds, resins, and varnishes, and is used also in Paint removers, which owe their action to their solvent power. Ethyl lactate, used as a solvent for cellulose nitrate, is a liquid with boiling point of 150°C and specific gravity of 1.03. Octyl alcohol, a liquid of the composition  $\text{CH}_3(\text{CH}_2)_6\text{CH}_2\text{OH}$ , specific gravity 1.429, and boiling point of 195°C, has a high solvent power for nitrocellulose and resins. Diafoam, of the Resinous Products & Chemical Co., is a secondary octyl alcohol used as a defoaming agent in plastics and lacquers. Methyl hexyl ketone,  $\text{CH}_3(\text{CH}_2)_5\text{COCH}_3$ ,

is a powerful high-boiling solvent which also acts as a dispersing agent in inks, dyestuffs, and perfumes. It is a water-white liquid boiling at 173°C.

The chlorinated hydrocarbons have powerful solvent action on fats, waxes, and oils and are used in degreasing. Water is a solvent for most acids and alkalis and for many organic and inorganic materials. Acids or alkalis that decompose the material are not solvents for the material. Solvents are used to produce a solution that can be applied, as in the case of paints, and the evaporation of the solvent then leaves the material chemically unchanged. They may also be employed to separate one substance from another, by the selection of a solvent that dissolves one substance but not the other. They are also used in scouring solutions. Dichlorethyl ether, a yellowish liquid with a chloroformlike odor, of the composition  $\text{ClCH}_2\text{CH}_2\text{OCH}_2\text{CH}_2\text{Cl}$ , is a good solvent for fats and greases and is used in scouring solutions and in soaps. Dichlorethylene is a liquid of the composition  $\text{C}_2\text{H}_2\text{Cl}_2$ , specific gravity 1.278, and boiling point about 52°C. It is used as a solvent for the extraction of fats and for rubber. A low-boiling solvent for oils and waxes is Butyl chloride,  $\text{CH}_3\text{CH}_2\text{CH}_2\text{CH}_2\text{Cl}$ . It is a water-white liquid of specific gravity 0.8875, boiling at 78.6°C. Isocrotyl chloride is a liquid of the composition  $\text{CH}_3\text{C}(\text{CH}_3)_2\text{CHCl}$ , with specific gravity of 0.919, boiling point 68°C, used for cleaning and degreasing. Cyclohexane,  $(\text{CH}_2)_6$ , made by the hydrogenation of benzene, is a good solvent for rubbers, resins, fats, and waxes. It is a water-white highly inflammable liquid of specific gravity 0.777, boiling point 80.8°C, and flash point 10°F. This solvent is marketed in England as Sextone. The Sulfolanes of the Shell Oil Co. are selective solvents for separating mixtures having different degrees of saturation, and can be removed easily by water wash. Dimethyl sulpholane is produced from pentadiene by reacting with  $\text{SO}_2$  and hydrogenation. Cyclohexanol, also called Hexalin and Hexahydrophenol,  $\text{C}_6\text{H}_{11}\text{OH}$ , is a solvent for oils, gums, waxes, rubber, and resins. It is made by the hydrogenation of phenol, and is a liquid boiling at 158°C.

Dichlorethyl formal,  $\text{CH}_2(\text{OCH}_2\text{CH}_2\text{Cl})_2$ , is a water-insoluble high-boiling solvent for cellulose and for fats, oils, and resins. The boiling point is 218.1°C, and specific gravity 1.234. The Nitro-

paraffins constitute a group of powerful solvents for oil, fats, waxes, gums, and resins. Blended with alcohols they are solvents for cellulose acetate, producing good flow and hardening properties for nonblushing lacquers. Nitromethane,  $\text{CH}_3\text{NO}_2$ , is a water-white liquid, specific gravity 1.139, boiling point  $101^\circ\text{C}$ , and freezing point  $-29^\circ\text{C}$ . It is also used as a rocket fuel. At  $500^\circ\text{F}$  it explodes into a hot mixture of nitrogen, hydrogen, carbon monoxide, carbon dioxide, and water vapor, but with a catalyst the disintegration can be controlled into a smooth continuous explosion. Nitroethane,  $\text{CH}_3\text{CH}_2\text{NO}_2$ , has a specific gravity of 1.052, boiling point  $114^\circ\text{C}$ , and freezing point  $-90^\circ\text{C}$ .

A Plasticizer is a liquid or solid that dissolves in or is compatible with a resin, gum, or other material and renders it plastic, flexible, or easy to work. A sufficient quantity of plasticizer will result in a viscous mixture which consists of a suspension of solid grains of the resin or gum in the liquid plasticizer. The plasticizer is in that sense a solvent, but unlike an ordinary solvent the plasticizer remains with the cured resin to give added properties to the material, such as flexibility. Dibutyl phthalate, a water-white oily liquid of specific gravity 1.048, boiling point  $340^\circ\text{C}$ , and composition  $\text{C}_{16}\text{H}_{22}\text{O}_4$ , is a plasticizer for Buna N rubber and polyvinyl chloride plastics. Monoplex DOA, of the Rohm & Haas Co., used to give flexibility to vinyl resins at low temperatures, is Diisooctyl adipate. It has a flash point at  $400^\circ\text{F}$ , and freezing point at  $55^\circ\text{C}$ . Thickening agents for sizes, coatings, and paints not only increase the viscosity but also add other properties such as giving better adhesion or toughening the film. They must be compatible with the other components.

**Sorbitol.** A Hexahydric alcohol,  $\text{CH}_2\text{OH}(\text{CHOH})_4\text{CH}_2\text{OH}$ , which occurs naturally in many fruits, but is now made on a large scale by the direct hydrogenation of corn sugar, or dextro glucose. It is a white, odorless, crystalline powder of a faint sweet taste. It melts at  $97.7^\circ\text{C}$ , and is easily dissolved in water. It is used as a humectant, softener, blending agent, for the production of synthetic resins, plasticizers, and drying oils, and as an emulsifier in cosmetics and pharmaceuticals. Sorbo and Arlex, of the Atlas Powder Co., are water solutions of sorbitol. Mannitol is an isomer form of the same alcohol and is also produced commercially.

**Sound insulators.** Materials employed, chiefly in walls, for reducing the transmission of noise. Insulators are used to impede the passage of sound waves, as distinct from Isolators used under machines to absorb the vibrations that cause the sound. For factory use the walls, partitions, and ceilings offer the only mediums for the installation of sound insulators. All material substances offer resistance to the passage of sound waves, and even the glass windows may be considered as insulators. But the term refers to the special materials placed in the walls for this specific purpose. Insulators may consist of mineral wool, hair felt, fiber sheathing boards, or simple sheathing papers. Sound insulators are marketed under a variety of trade names, such as Celotex, made from bagasse, and Fibrofelt, made from flax or rye fiber. Wheat straw is also used for making insulating board. Sound insulators are often also heat insulators. Linofelt, of the Union Fiber Co., Inc., is a sound- and heat-insulating material used for walls. It consists of a quilt of flax fiber between tough waterproof paper. It comes in sheets  $\frac{5}{16}$  to  $\frac{3}{4}$  in. thick. Torofoleum is a German insulating material made from peat moss treated with a waterproofing agent. It will withstand temperatures up to 230°F, is finely porous, and weighs less than 1 lb per bd ft. Vibration insulators, or Isolators, to reduce vibrations that produce noises, are usually felt or fiberboards placed between the machine base and the foundation. Keldur, of the International Products Corp., is a fibrous insulating material made up in sheets  $\frac{3}{4}$  in. thick, with a resilient binder. Korfund isolator, of the Korfund Co., Inc., is a resilient mat of cork treated with oil and bound in a steel frame. It will take loadings up to 4,000 lb per sq ft. Vibro-Insulator, of the B. F. Goodrich Co., is an isolator of Ameripol synthetic rubber.

**Soybean oil.** Also known as Soya bean oil. A pale-yellow oil obtained by expression from the seeds of the plant *Glycine soya*, native to Manchukuo, but grown also in the United States. It is primarily a food oil, but is also used as a drying oil for linoleum, paints, and varnishes, or for mixing with linseed oil, although the untreated oil has only half the drying power of linseed oil. It is also used in core oils and in soaps. The bean contains up to 20% oil. The average yield factor is 15%, but by trichlorethylene extraction a bushel of beans will yield 11 lb of oil and 46 lb of high-protein meal contain-

ing less than 1% oil. The oil content decreases in warm climates. Southern-grown soybeans contain 2 to 5% less oil than those grown in Illinois. The usual conversion factor is 8.5 lb of oil and 48 lb of meal per bushel of beans. There are 280 varieties of the bean grown in the United States and 2,500 varieties listed. The pods contain two or three beans which range in color from light straw through gray and brown to nearly black. Most varieties are straw colored or greenish yellow. The stalks and leaves of the plant contain much nitrogen, and about half of the crop is usually plowed under for fertilizer.

The specific gravity of the oil is about 0.925, iodine value 134, and it should have a maximum of not more than 1.5% free fatty acids and not more than 0.3% moisture and volatile matter. The fractionated oil yields 15% cut soybean oil of an iodine value of 70 to 90, used for soaps, lubricants, and rubber compounding; 72% Neo-fat oil of an iodine value of 145 to 155, used for varnish and paint oils alone or in blends with other oils, or for glycerin making; 13% bottoms, used for soaps, lubricants, and giving a by-product pitch used in insulation and mastic flooring. Snowflake oil of the Archer-Daniels-Midland Co. is a heavy-bodied oxidized soybean oil for paints. It has a specific gravity of 0.986 to 0.989, and iodine number from 64 to 95. Soyalene, of this company, is an alkali-refined soybean oil for varnishes. The specific gravity is 0.924, and the iodine number is 130. Much soybean oil is also used for making margarine.

Soybean meal is the product obtained by grinding the soybean chips from the expeller process, or the Soybean oil cake from the hydraulic process. The meal is marketed as stock feed or fertilizer. It is chiefly used as a protein feed for dairy cattle, but it is inferior to fish meal for poultry, as it lacks the mineral salts and vitamins of fish meal. Soybean meal hardened with formaldehyde is used as a filler with wood flour in plastics to give better flow in molding. Gelsoy is a protein gel extracted from soybean meal. It is used in foodstuffs as a thickening agent, and is also used as a strong adhesive.

Soybean flour for bakery food products for the American market is made from treated beans which have the bitter taste removed. The food flour is made in three types: that with about 23% oil left in, low fat with only 6%, and solvent type, with practically all the oil removed. Soybean flour has a yellow color which in cakes gives the

appearance of the use of eggs. Up to 25% is used in blends with wheat flour. It is also used in dehydrated soup mixes and in meat products, and to replace some of the milk and butterfat in confectionery. It has high protein content and also contains lecithin.

**Spanish moss.** The fiber from the plant *Tillandsia usneoides*, which grows throughout tropical and subtropical America, and along the southeastern coast of the United States, hanging from branches of trees. Spanish moss is used for cheap upholstery and for packing glass and fragile articles. A fiber produced in Argentina for the same purpose and for stuffing mattresses is Caranday fiber from the leaves of the palm *Copernicia cerifera*. The tree grows in marshy ground in Corrientes Province.

**Speculum metal.** An alloy formerly used for mirrors, and also in optical instruments. It contains 65 to 67% copper and the remainder tin. It takes a beautiful polish and is hard and tough. Speculum metal should have a maximum of crystals of  $\text{Cu}_3\text{Sn}$ , containing 66.6% copper. An old Roman mirror contained about 64% copper, 19 tin, and 17 lead, and an Egyptian mirror contained 85% copper, 14 tin, and 1 iron. The old Greek mirrors were carefully worked out with 32% tin and 68 copper. They had 70% of the reflecting power of silver, with a slight red excess of reflection that gave a warm glow, without the blue of nickel or antimony. This alloy is now plated on metals for reflectors. A modern telescope mirror contains 70% copper and 30 tin. Chinese speculum contains about 8% antimony and 10 tin. Speculum plate advocated by the Tin Research Institute for electroplating, to give a hard, white, corrosion-resistant surface for food-processing equipment and optical reflectors, has 55% copper and 45 tin. It is harder than nickel, and retains its reflectivity better than silver.

**Sperm oil.** The waxy oil extracted from the head cavity of the sperm whale, *Physeter breviceps*, and the Bottlenose whale, *P. macrocephalus*. The spermaceti is first separated out, leaving a clear yellow oil. It is purified by being pressed in bags at a low temperature. It is graded according to the temperature of pressing. A good grade of sperm oil has a specific gravity of 0.875 to 0.885, and a flash point above 440°F. Inferior grades of sperm oil may be from sperm-



whale blubber. Commercial sperm oil is likely to be one-third head oil and two-thirds body oil. Sperm oil differs from fish oil and whale oil in consisting chiefly of liquid waxes and not fats. Sperm oil absorbs very little oxygen from the atmosphere and is not influenced by variations in temperature. It is therefore valuable as a lubricating oil. It burns with a white shining flame, and was formerly used as a high-grade lamp oil. It is also an excellent soap oil. Sulphonated sperm oil is used as a wetting agent in textile manufacture. Sperm oil from the head has an iodine value of 76 and a saponification value 140.

Spermaceti is the white, crystalline flakes of fatty substance, or wax, that separate out from sperm oil on cooling after boiling. It is a true wax and does not yield glycerin when saponified. It is purified by pressing. It is also separated out from dolphin head oil. Spermaceti is odorless and tasteless, has a melting point of 43°C, is insoluble in water, but soluble in hot alcohol. It burns with a bright flame. It was formerly used for candles but now is employed chiefly as a fine wax for ointments and compounds. Sperm oil and spermaceti are inedible and indigestible.

**Spice.** An aromatic vegetable substance, generally a solid used in powdered form, employed for flavoring foods. There is no sharp dividing line between Flavors and spices, but in general a spice is a material that is used to stimulate the appetite and increase the flow of gastric juices. They are not classed as foods in themselves, having little food value, but as food accessories. Pepper is distinctly a spice, while vanilla is merely a flavor, though often grouped with the spices. Some spices are also used widely as flavors and in perfumes, and also in medicine either for antiseptic or other value or to disguise the unpleasant taste of drugs. A Condiment is a strong spice, or a spice of sharp taste, although the word is often erroneously applied to any spice. A Savory is a fragrant herb or seed used for flavor in cooking. Spices are obtained from the stalks, bark, fruits, flowers, seeds, or roots of plants.

Allspice, also known as Pimento and Jamaica pepper, is the dried unripe fruit of the small evergreen tree *Pimenta officinalis* of the myrtle family growing in the West Indies and tropical America. The fruit is a small berry which when dried is wrinkled and reddish

brown. It has a flavor much like a combination of clove, nutmeg, and cinnamon. Pimento oil is a fragrant essential oil distilled from the berries, which contain 4%. It contains eugenol and cineol and is used in flavors, in bay rum, and in carnation perfumes. Coriander is the dried fruit of the perennial plant *Coriandrum sativum* grown in the Mediterranean countries and India. It is one of the oldest of spices and has a pleasant aromatic taste. Oil of coriander, extracted from the dried seed, is used in medicine, beverages, and flavoring extracts. It has a higher aromatic flavor than the fruit. Savory is a fragrant herb of the mint family, *Satureia hortensis*, used in cooking, and in medicine as a carminative. It contains Carvacrol, a complex phenol also occurring in caraway and camphor. The word savory also designates other herbs that are used directly in foods as flavors.

Celery seed, used as a savory, is the seed of the plant *Apium graveolens*. The leafstalks of this plant, known as Celery, are bleached white and eaten raw or cooked. The plant is widely grown for seed in France and Spain. Celery-seed oil is a pale-yellow oil extracted from the seeds and used as a flavor and in perfumery. Fennel is the dried oval seed of the perennial plants *Foeniculum vulgare* and *F. dulce*. The stalks of the latter are blanched like celery and eaten as a vegetable in Europe. Fennel is used as a flavoring in confectionery and liqueurs, and as a carminative in medicine. Fennel oil is a pale yellowish essential oil with specific gravity of 0.975, distilled from the seed. It has an aromatic odor and a camphorlike taste with a secondary sweetish, spicy taste. It contains Fenchone,  $C_{10}H_{16}O$ , an isomer of camphor, with also pinene, camphene, and Anethole, or Anise camphor,  $C_8H_8O$ . The latter is used in dentrifices and pharmaceuticals. Fenugreek is the seed from the long pods of the annual legume *Trigonella foenum-graecum* native to southern Europe. It is used in curries, in medicine, and for making artificial maple flavor. Oregano, used as an ingredient in Chile powder, is the pungent herb *Coleus amboinica*.

Dill seed, from the herb *Aenethum graveolens*, of the parsley family, is used as a condiment for pickles. Dill leaves are used as seasoning for soups, sauces, and pickles. Dill oil, extracted from the whole herb, is used as a flavor in the food industry. It resembles caraway oil and has a finer flavor than Dill-seed oil which is

more plentiful. Dill is grown in the central United States and in central Europe. Cardamon is the highly aromatic and delicately flavored seeds of the large perennial herb *Elettaria cardamomum*, of India, Ceylon, and Central America. The seeds are used in pickles, curries, and cakes, and the oil is employed as a flavor. Garlic is the root bulb of the lily *Allium sativum*, used as a condiment, and in medicine as an expectorant under the name of Allium. It contains allyl sulphide which gives it a pungent odor and taste. The Allicine extracted from garlic is used in medicine as an antibacterial. It is a colorless, oily liquid with a sharp garlic odor.

Cumin is the seed of the *Cuminum cyminum*, the true Cumin, and *Nigella sativa*, the Black cumin, both of India. The seed is used in confectionery and in curries. A kind of black cumin known as Shiah zira, from the plant *Carum indicum* of India, is superior in taste and fragrance to ordinary cumin. Caraway is the spicy seed of the biennial herb *C. carvi* of Europe and North Africa. The seeds are used on cookies. Caraway oil, distilled from the seeds, contains carvone and limonene, and in combination with cassia gives a pleasant odor. It is used in soap, perfumes, and mouth washes. Sage is the grayish-green hairy leaves of the shrublike plant *Salvia officinalis* used as a spice. It is cultivated extensively in the Mediterranean region. Oil of sage is used in perfumery. Clary sage oil is distilled from the flowers of the *S. sclarea* of France, Italy, and North Africa. It has the odor of a mixture of ambergris, neroli, and lavender, and is used in flavoring vermouth liquor and muscatel wines, and also in eau de cologne. Sassafras is sometimes classed as a spice but is a flavor. It is the aromatic spicy bark of the root of the tree *Sassafras albidum* which grows wild in eastern United States. It is used mostly for making root beer, but also for flavoring tobacco, and in patent medicines. Sassafras oil is an oil extracted from the whole roots, which contains 2% of the yellow oil, and is used in medicine, perfumery, and soaps. It produces artificial heliotrope. The oil contains Safrol,  $C_{10}H_{10}O_2$ , also produced from brown camphor oil. Brazilian sassafras oil, or Ocotea oil, is distilled from the root of the tree *Ocotea cymbarum*, also of the laurel family. The root yields about 1% of an oil which contains 90% safrol, and has the odor and flavor of American sassafras oil. Sarsaparilla is an oil obtained from the long

brown roots of the climbing vine *Smilax regellii* of Honduras, *S. aristolochiaefolia* of Mexico, and other species, all growing in tropical jungles. The roots are used in medicine, and the oil is used as a flavor. It is odorless, but has an acrid sweet taste. It contains three saponins.

Wintergreen oil is from the leaves of the small evergreen plant *Gaultheria procumbens* of the Middle Atlantic states. The oil does not exist in the plant but is formed by the reaction between a glucoside and an enzyme when the chopped leaves are steeped in water. It is largely Methyl salicylate,  $C_8H_8O_3$ . It is used in flavoring candies and soft drinks and in medicine. Hop oil, used to give hop flavor to cereal beverages, and also in perfumes, is obtained from Lupulin, a glandular powder found in the female inflorescence of the hop plant, *Humulus lupulus*. Hops are used directly in making beer, and the oil is produced from the discard hops which contain 0.75% oil.

**Spodumene.** A mineral of the composition  $Li_2O \cdot Al_2O_3 \cdot 4SiO_2$ , with some potassium and sodium oxides. It is the chief ore of the metal lithium. It is found in South Dakota and the Carolinas, and has an average content of 4%  $Li_2O$ , ranging from 2.9 to 7.6%. Crystals of spodumene in South Dakota are 8 to 10 ft long and 1 ft in thickness, appearing like logs of wood, with as high as 6.5% lithium. The specific gravity is 3.13 to 3.20, and the melting point is 1395 to 1425°C. Spodumene is three times more active than feldspar as a flux in ceramics, giving fluidity, increasing surface tension, and eliminating pinholes. A mixture of 25% spodumene with 75 feldspar is an active vitrifying agent in ceramics. The melting point of the mixture is 1110°C, which is below the usual minimum temperature used for chinaware; it thus forms a glaze. Lithospar is a name for feldspar and spodumene from the pegmatites of King's Mountain, North Carolina. In Germany lithium is obtained from the lithium mica Zinnwaldite, which is a mixture of potassium-aluminum orthosilicate and lithium orthosilicate with some iron, and contains less than 3%  $Li_2O$ . Kryolithionite, a mineral found in Greenland, has the composition  $Na_3Li_3(AlF_6)_2$  and contains up to 11.5%  $Li_2O$ . It has a crystal structure resembling garnet. A transparent emerald-green spodumene in small crystals, known as Hiddenite, is found in North Carolina, and is cut into gem stones.

**Sponge.** The cellular body of a marine animal, of the genus *Spongia*, of which there are various species. It is employed for wiping and cleaning, as it will absorb and hold a great quantity of water in proportion to its weight. Sponges grow like plants, attached to the sea bottom. They are prepared for use by maceration in water, and are then beaten and treated with acids to remove concretions. They may also be bleached chemically. The best sponges come from the Mediterranean and Red Seas, and from the Caribbean Sea. Tarpon Springs, Fla., is the center of the American sponge fisheries. The sponge skeleton, after the retting and beating off of the soft membranes, is an elastic fibrous structure chemically allied to silk. It has sievelike membranes with small pores leading into small pear-shaped chambers. The best sponges are spheroidal, regular, and soft. Most of the Florida sponges are the Sheepswool sponge used for cleaning and industrial sponging. The fine Honeycomb sponge of the Mediterranean is used as a bath sponge. About 80% of the North African catch consists of honeycomb sponges, with the remainder Turkey cup and Zimocca sponges.

**Sponge iron.** Iron made from ferrous sand and pressed into briquettes, which can be charged directly into steel furnaces instead of pig iron. It was originally made on a larger scale in Japan where only low-grade sandy ores were available. Sponge iron is made by charging the sand continuously into a rotary furnace to drive off the light volatile products and reduce the iron oxide to metallic iron, which is passed through magnetic separators, and the finely divided iron briquetted. Unbriquetted sponge iron, with a specific gravity of 2, is difficult to melt because of the oxidation, but the briquetted material, with a specific gravity of 6, can be melted in the electric furnace. Sponge iron to replace scrap in steelmaking is also made from low-grade ores by reducing the ore with coke-oven gas or natural gas. It is not melted, but the oxygen is driven off, leaving a spongy granular product. As it is very low in carbon, it is also valuable for making high-grade alloy steels.

A form of sponge iron employed as a substitute for lead for couplings packings was made in Germany under the name of Sinterit. The reduction is carried out in a reducing atmosphere at a temperature of 1200 to 1350°C, instead of heating the iron oxide with car-

bon. Since the porous iron corrodes easily, it is coated with asphalt for packing use. Iron sponge, employed as a purifier for removing sulphur and carbonic acid from illuminating gas, is a sesquioxide of iron obtained by heating together iron ore and carbon. It has a spongy texture filled with small cells.

**Sponge rubber.** Rubber expanded with a cellular structure and cut or molded into blocks or forms for use as a substitute for sponges or for resilient upholstery padding or insulation. Ordinary chemically blown sponge rubber is made up of interconnecting cells in a labyrinthlike formation. When made by beating latex, it may show spherical cells with the porous walls perforated by the evaporation of moisture. It is also called Foam rubber. Special processes are used to produce celltight and gastight Cellular rubber which is non-absorbent. The Unicel ND, of E. I. du Pont de Nemours & Co., Inc., used as a blowing agent for sponge rubber, is Dinitro pentamethyl tetramine. It is mixed in the rubber, and in the presence of the rubber acids it is decomposed, liberating gas during the vulcanization to form small cells. The Cellular rubber of the U.S. Rubber Co., produced in sheets of a density of 3.5 to 12 lb per cu ft, for refrigeration insulation, is made with a chemical that releases nitrogen gas to produce innumerable microscopic cells during the molding. The Rubatex of the Rubatex Div., Great American Industries, Inc., is this type of cellular rubber. In the form of insulation board for heat and cold, nitrogen-filled rubber has a thermal conductivity of 0.237 Btu per hr per deg F temperature difference per inch of thickness. The 5.5-lb. board has a crushing strength of 33 psi. Under the name of Royal insulation board it is marketed in thicknesses from  $\frac{3}{4}$  to  $1\frac{1}{2}$  in. Cellular rubber is also used for floats. Bubblfil, of E. I. du Pont de Nemours & Co., Inc., is an expanded cellulose used to replace sponge rubber and kapok as an insulating and buoyancy material. It is expanded into a material with air-filled beads, light, tough, and resilient. Foamex, of the Firestone Tire & Rubber Co., is a foam rubber made from synthetic latex in several density grades. It is stronger than that made from natural rubber and is flexible at very low temperatures. Styrofoam is polystyrene plastic expanded into a non-permeable multicellular mass 42 times the original size. It has only one-sixth the weight of cork, but will not withstand hot water or

temperatures above 170°F, as it is thermoplastic. The thermal conductivity is 0.27 Btu per hr per deg F per in. It is used for cold-storage insulation, and is resistant to mold. Cellular cellulose acetate, of E. I. du Pont de Nemours & Co., Inc., is a cellulose acetate foam plastic for insulation. It comes in density grades from 4 to 9 lb per cu ft, is light in weight, and has good structural strength when bonded between wood or metal. Ipoka was a German foam rubber made of urea-formaldehyde plastic blown and molded into blocks for cold-storage insulation. Various plastics are used for making substitutes for cellular rubber. Plasti-Cell, of the Sponge Rubber Products Co., is an expanded polyvinyl chloride molded to densities from 2 to 12 lb per cu ft. It is used for floats, buoys, and insulation.

**Sprengle explosives.** Chlorate compounds that have been rendered reasonably safe from violent explosion by separating the chlorate from the combustible matter. The potassium chlorate is made up into porous cartridges and dipped, just before use, in liquid combustible such as nitrobenzene or dead oil. Potassium chlorate so treated is called Rack-a-rock. Sprengle explosives were formerly used as military explosives, are very sensitive to friction and heat, and are now valued when it is desired to economize on nitrates. Cheddite is a French explosive consisting of a chlorate with an oily material, such as castor oil thickened by a nitrated hydrocarbon dissolved in it. A typical cheddite has 80% potassium chlorate, 8 castor oil, and 12 mono-nitro-naphthalene. With sodium chlorate it is less sensitive to detonation and more powerful but is hygroscopic. Potassium chlorate cheddite is a soft, yellowish, fine-grained material, and is a slow, mild explosive which will split rocks rather than shatter them. Minelite is a chlorate with paraffin wax. Steelite is a chlorate explosive with rosin. Prométhée is another French chlorate explosive. In this explosive the oxygen carrier consists of 95% potassium chlorate and 5 manganese dioxide, and the combustible contains 50% nitrobenzene, with turpentine and naphtha. It is extremely sensitive and will explode by friction. Silesia is a German high explosive used for blasting. It is potassium chlorate with rosin, with some sodium chlorate to make it less sensitive.

**Spring steel.** A term applied to any steel used for making springs. The majority of springs are made of steel, but brass, bronze, nickel

silver, and phosphor bronze are used where corrosion resistance or electrical conductivity is desired. Carbon steels, with from 0.50 to 1.0% carbon, are much used, but vanadium and chrome-vanadium steels are also employed, especially for heavy car and locomotive springs. Special requirements for springs are that the steel be low in sulphur and phosphorus, and the analysis be kept uniform. For flat or spiral springs that are not heat-treated after manufacture, hard-drawn or rolled steels are used. These may be tempered in the mill shape. Music wire is widely employed for making small spiral springs. A much-used straight-carbon spring steel has 1% carbon and 0.30 to 0.40 manganese, but becomes brittle when overstressed. ASTM carbon steel for flat springs has 0.70 to 0.80% carbon and 0.50 to 0.80 manganese, with 0.04 max each of sulphur and phosphorus. Motor springs are made of this steel rolled hard to a tensile strength of 250,000 psi. Watch spring steel, for mainsprings, has high carbon, 1.15%, and low manganese, 0.15 to 0.25, rolled hard and giving an elastic limit above 300,000 psi.

Silicon steels are used for springs. They have high strength and impact resistance. These steels average about 0.40% carbon, 0.75 silicon, and 0.95 manganese, with or without copper, but the silicon may be as high as 2%. Flexo steel, of the Carpenter Steel Co., used for automobile leaf springs and for recoil springs, contains 2% silicon, 0.75 manganese, and 0.60 carbon. The elastic limit is 100,000 to 300,000 psi, depending on the drawing temperature, with hardness 250 to 600 Brinell.

Manganese steels for automotive springs contain about 1.25% manganese and 0.40 carbon, or about 2% manganese and 0.45 carbon. When heat-treated, the latter has a tensile strength of 200,000 psi and elongation 10%. Part of the manganese may be replaced by silicon and the Silicon-manganese steels have tensile strengths as high as 270,000 psi. The addition of chromium or other elements increases the elongation and improves the physical properties. Uma spring steel, of the Republic Steel Corp., is a chromium-manganese steel with 1 to 1.2% chromium, 0.80 to 1 manganese, and about 0.50 carbon. In the rolled condition it has an ultimate strength of 135,000 psi and Brinell hardness up to 332. Manganese steels are deep-hardening but are sensitive to overheating. The addition of chromium, vanadium, or molybdenum widens the hardening range.



Wire for coil springs ranges in carbon from 0.50 to 1.20%, and in sulphur from 0.028 to 0.029. Bessemer wire contains too much sulphur for spring use. Cold working is the method for hardening the wire and for raising the tensile strength. An 0.85% carbon rod, with an ultimate strength of 140,000 psi, when drawn with four or five passes through dies will have a strength of 235,000 psi. Wire drawn down to a diameter of 0.015 in. may have an ultimate strength of 400,000 psi. The highest grades of wire are referred to as music wire. The second grade is called Hard-drawn spring wire. The latter is a less expensive basic open-hearth steel with manganese content of 0.80 to 1.10%, and an ultimate strength up to 300,000 psi. Specially treated carbon steels for springs are sold under trade names such as Enduria of the Bethlehem Steel Co. Resilla is a silicon-manganese spring steel of this company.

**Spruce.** The wood of various coniferous trees of northern Europe and North America. Spruce is a leading commercial wood of north Europe and is exported from the Baltic region as White fir and White deal. It is also called Norway spruce and Spruce fir. The wood is white, and has a straight, even grain. It is tough and elastic, and is more difficult to work than pine. The weight is 36 lb per cu ft. Norway spruce is *Picea abies*, and this tree yields the Jura turpentine of Europe. Spruce is used for making paper pulp, for packing boxes, and as a general-utility lumber. White spruce is from the tree *P. canadensis*, of the United States and Canada. It has quite similar characteristics. Red spruce, *P. rubra*, is the chief lumber spruce in the eastern United States. It is also called Yellow spruce, West Virginia spruce, and Canadian spruce. Black spruce, *P. mariana*, of New England, eastern Canada, and Newfoundland, is used for making paper pulp. It is also called Blue spruce, Bog spruce, and Spruce pine. White spruce, or Shingle spruce, is from *P. glauca*. It is also called Skunk spruce because of the peculiar odor of the foliage. All of these three species are called Eastern spruce, and they grow from Nova Scotia to Tennessee and westward to Wisconsin except that red spruce does not grow in the Lake states. All are mountain trees and are slow growing. Silver spruce, Yellow spruce, Sitka spruce, or Western spruce, is from the enormous tree, *P. sitchensis*, of the west coast of the United States and Canada. It is soft and light in

weight, but strong, close-grained, and very free from knots. The wide sapwood is creamy white, and the heartwood pinkish to brownish. The weight is less than eastern spruce, but it has high strength in proportion to weight. The trees reach a height of 280 ft and a diameter of 10 ft in 600 years, but the growth is rapid in early life. The wood is used for boxes, crates, millwork, and paper pulp. It is particularly adapted for groundwood pulp, giving higher strength in paper than most groundwood. The various species of commercial spruce have an average specific gravity, when kiln-dried, of 0.40, a compressive strength of 840 psi perpendicular to the grain, and a shearing strength of 750 parallel to the grain. It combines stiffness and strength per unit weight, and has a uniform texture free from pitch. Japanese spruce is from *Abies mariesii*, and Himalayan spruce is from *P. morinda*. The latter resembles Norway spruce.

**Spruce extract.** The waste sulphite liquor from paper-pulp mills purified for use in tanning leather. The tanning agent in the liquor is Ligno-sulphonic acid. Spruce extract is not used alone in tanning but is mixed with quebracho or other tanning material, or the leather may first be tanned with spruce and then with syntans. Sulphite liquor from spruce is used in Germany and Sweden for making ethyl alcohol. Spruce gum is the gum exudation of the *Picea rubra*, *P. mariana*, and *P. canadensis* of the northeastern United States and Canada. It exudes from cuts in the trees as a transparent viscous liquid which hardens when it loses the volatile oil and is broken off in the wintertime. The gum is brown or reddish black in color, has a turpentinelike odor and a bitter pungent taste. It is used in cough medicines and in chewing gum.

**Squill.** Also known as Red squill and Sea onion. A reddish powder used chiefly for the control of rats in warehouses and docks. It is obtained from the onionlike bulb of the perennial plant *Urginea maritima* growing on the beaches of Italy and other Mediterranean countries. The bulb is pear-shaped, from 1 to 6 lb in weight and 6 to 12 in. in diameter. The outer scales are dry, brittle, and reddish brown, and the inner scales are cream color to deep purple. Red squill powder is a powerful emetic to man or animals other than rats or mice. As rats and mice do not vomit, they are poisoned by it while it is harmless to poultry and domestic animals. It is also used in

medicine. It contains Calcium oxalate and in contact with the skin it gives a sensation like nettle poisoning. White squill is another variety used in medicine as an emetic, heart tonic, and expectorant. The substitute for red squill known as Antu, of E. I. du Pont de Nemours & Co., Inc., is Naphthyl thiourea, a gray powder of little odor or taste about 100 times more poisonous to rats than squill and not normally injurious to domestic animals. Another poison more toxic to rats than squill is Ratbane 1080 which is Sodium fluoracetic acid made synthetically. The poison occurs as natural fluoracetic acid in the Gifblaar plant, *Dichapetalum cymosum*, of South Africa, which has been used locally for killing rodents. The poison, however, also kills domestic animals, and can thus be employed only in restricted places.

**Stainless iron.** A chromium-iron alloy usually containing from 12 to 20% chromium, but it may contain as low as 9%. The chromium gives to the alloy the property of being highly resistant to oxidation and corrosion even at elevated temperatures. The resistance to nitric acid increases with the chromium content, and the grades with 16 to 20% chromium are used for nitric acid equipment. The Brinell hardness is as high as 325, and the tensile strength is up to 150,000 psi. It differs from stainless steel in having low carbon, and is sometimes referred to as Rustless iron. Stainless iron is employed for tank plates, and for parts where corrosion- or acid-resisting qualities are valuable, but where the higher strength and hardness of the stainless steels are not required. Stainless iron No. 12, of the Crucible Steel Co. of America, contains 11 to 13% chromium, 0.35 to 0.60 manganese, and 0.12 max carbon. The tensile strength is 164,000 psi, elongation 11%, and Brinell hardness 321. It forges easily and can be machined readily when annealed. It is used for turbine blades, pump rods, and parts for food machines. Grade No. 18 of the same company contains 17 to 19% chromium and 0.07 to 0.12 carbon, and has a tensile strength of 100,000 psi, elongation 25%, and Brinell hardness 200. It is more resistant to acids and corrosion than the No. 12. Uniloy 1409, of the Cyclops Steel Co., has 12% chromium, 0.50 nickel, and 0.10 carbon. The heat-treated rolled alloy has a tensile strength of 105,000 psi, elongation 25%, and Brinell hardness 240. Uniloy 1409M is this alloy with a small amount

of molybdenum sulphide to make it free-machining. Circle L12M, of the Lebanon Steel Foundry Co., is a 13% chromium cast steel with 0.10 carbon and 0.25 selenium to give it good machinability. The tensile strength is 85,000 psi, elongation 20%, and Brinell hardness 170.

Turbine blade steel, which is Lesco L of the Latrobe Electric Steel Co., is a stainless iron having 11 to 13% chromium, 0.50 max each of silicon and manganese, and 0.10 max carbon. Lesco LM has 13 to 15% chromium and has higher corrosion resistance; Lesco M and Lesco H, with 15 to 18, and 18 to 20% chromium, have still higher resistance. These stainless irons are furnished also with 0.20 to 0.30% sulphur to give free-machining qualities. Rustless RR-11, of the Rustless Iron & Steel Corp., is a structural stainless iron containing 11 to 12% chromium and 0.07 carbon. The ultimate strength is 75,000 psi, elongation 25%, Brinell hardness 170, and coefficient of expansion 0.0000125 per deg C. Defirust of this company contains 12 to 15% chromium and 0.10 carbon, with some nickel. It resists temperatures to 1250°F. Defiheat iron contains 26 to 29% chromium and 0.20 carbon, with a small amount of nickel. The tensile strength is 70,000 to 95,000 psi, and scaling point 2100°F.

Stainless iron does not require heat-treatment, but its physical properties are often improved by such treatment, and it can be hardened, although ordinary steel of the same carbon content will not harden. Columbium or titanium may be added to the 10 to 20% chromium irons to give a softening effect, shorten the time of annealing, and minimize intergranular corrosion. In Germany a 17% chromium iron with 0.10% carbon and a small amount of titanium has been used to replace chromium-nickel stainless steels. Nitrogen in very small proportions produces a fine-grain structure. From 1 to 2% nickel in these irons hardens and strengthens the alloy when heat-treated. A small amount of silver in the alloys modifies the grain structure and prevents pitting.

**Stainless steels.** A group of steels containing high chromium which gives them great corrosion resistance. They were first produced in America in 1914 under English and German patents and contained 12 to 18% chromium. The original composition was

13.5% chromium and 0.35 carbon. This steel is machinable, has a tensile strength of 150,000 psi, and Brinell hardness 325. It is hardened by air cooling or by quenching in oil. With high carbon the steels are not stainless unless the amount of chromium is increased. With very low carbon the steels are more malleable, but they then do not possess air-hardening properties nor do they keep a keen edge in cutting tools. Hardness is necessary to bring out the stainless qualities, and the scale must be polished off. Because of the difficulty of polishing after hardening, the steels are always brought to a high finish before hardening. The higher carbon steels, with carbon up to 0.90%, are used for cutlery and retain a keen cutting edge. Sterling stainless steel, Type A, of the Firth-Sterling Steel Co., is a typical stainless steel used for automobile parts and for cutlery. It contains 13.5% chromium and 0.35 carbon. The tensile strength is from 100,000 to 240,000 psi, elongation 4 to 27%, specific gravity 7.77, and Brinell hardness 185 to 500. Steels of this type are also used for making pen nibs to replace gold pens tipped with osmium. Staybrite, of this company, has 10% chromium, 3 to 4 silicon, and 0.45 carbon. It is used for cutlery. Colonial stainless F.M.S., of the Colonial Steel Co., with a maximum of 0.12% carbon and up to 0.35 sulphur, is easily machined, and is used for valve parts, screws, and gun barrels.

A group of stainless steels is produced by the United States Steel Corp. under the name of U.S.S. steels. A heat-resisting steel used for pipe and tubes for refineries and chemical plants is U.S.S. steel 12A1. It contains 11.5 to 13.5% chromium, 0.10 to 0.30 aluminum, and 0.08 max carbon. It combines high strength and ductility. The aluminum acts as a ferrite stabilizer. It requires heat-treatment to obtain greatest corrosion resistance, but the steel does not harden. U.S.S. steel 27, for severe oxidation and reducing conditions at 1500 to 2100°F, is a nitrogen-bearing ferritic alloy containing 23 to 30% chromium, 0.10 to 0.25 nitrogen, and 0.20 max carbon. The nitrogen eliminates embrittlement, and the steel is higher in mechanical characteristics than a plain chromium steel. Duraloy is the name of a group marketed by the Duraloy Co., and Heiloy is the name of stainless steels used by the Heil Co., for dairy equipment. Radianite, of the Latrobe Electric Steel Co., contains 16.5 to 18% chromium, 0.70

to 0.80 carbon, and not over 0.50 each of silicon and manganese. It keeps a fine cutting edge, and retains a high polish. Lusterite is another grade with higher carbon, and is a Keen-edge steel for surgical instruments and knives. Hy-Glo steel, of this company, has 17% chromium and 0.60 carbon. It has a tensile strength up to 250,000 psi, hardness up to 600 Brinell, and is used for cutlery and tools.

Columbium is added to stainless steels of various grades to minimize intergranular corrosion and to shorten the time of annealing, but intergranular corrosion can be eliminated by keeping the carbon content below 0.03%. Steels of this type are now regularly marketed. A free-cutting stainless steel is made by adding about 0.40% zirconium sulphide. The latter makes the steel easy to machine and does not impair the resistance to corrosion, but it decreases the ductility. Carpenter stainless No. 5 contains 14% chromium, 0.40 zirconium sulphide, and 0.10 carbon. E-Z stainless steel, of the Latrobe Electric Steel Co., is stainless steel with 13.5% chromium and 0.34 carbon, having in addition 0.20 to 0.30% sulphur to make it easy to machine. Ni-Stainless steel, of the same company, is regular stainless with the addition of 1.5 to 2% nickel. It gives added abrasion resistance and is used for pump rods, pistons, and valves. Sterling stainless FC, of the Firth-Sterling Steel Co., contains 0.40% molybdenum, and 0.25 sulphur for free-cutting qualities. Circle L25M, of the Lebanon Steel Foundry, is a 21-10 chromium-nickel steel with 0.25% selenium to give free machining. None of the plain chromium steels are austenitic, but additions of nickel produce the austenitic condition. The 18-8 chromium-nickel steels were called Super stainless steels in England, and they have become designated as stainless steels in America, but they do not belong to the original class of stainless steels. The steels with low nickel are called ferritic and are harder than the plain stainless steels. Colonial 410 has 12.5 to 14.5% chromium, 1 nickel, and 0.12 carbon. Armco 17-4PH steel, of the Armco Steel Corp., is a martensitic steel containing 17% chromium, 4 nickel, and 4 copper. It has high strength and hardness and good corrosion resistance. It is hardened by heating to 900°F and air cooling, the low heat reducing danger of distortion and scaling. Stainless steels are used for turbine blades, pump and

chemical equipment parts, dairy equipment, and where corrosion resistance and heat resistance are needed. Black stainless steel is produced by immersing the sheets in a bath of molten potassium dichromate and sodium dichromate. This gives a shiny black finish.

**Starch.** A large group of substances with the empirical formula  $(C_6H_{10}O_5)_x$ , occurring widely in grains, tubers, and fruits. They are used industrially for pastes, adhesives, fillers, explosives, and stiffening materials. The common cereal grains contain from 55 to 75% starch. Potatoes have about 18% starch and 78 water. Most of the commercial starch is made from corn. The starches from different plants have similar chemical reactions, but all have different granular structure, and the differences in size and shape of the grain have much to do with the variations in adhesive properties in glues and sizings. Cornstarch has a polygonal grain of simple structure. It is the chief food starch, although Sweet potato starch is used in confections where gelatinization is valued. Cornstarch is also used for textiles and for laundry use.

Tapioca starch has rounded grains truncated on one side and of lamellar structure. It gives quick tack and high adhesion in glues. Tapioca is from the root of the *Manihot utilisima* now grown in many parts of the world. It is called Cassava in the East Indies, Manioc in Brazil, Mandioca in Paraguay, and Yuca in Cuba. It is used in enormous quantities for food in some countries, the Dutch East Indies alone producing 8 to 10 million tons annually. In Brazil it is also used for the production of alcohol. But in the United States it is used mainly for making adhesives and paper and textile coatings. Pearl tapioca, which is the material in globules and flakes, is used for foodstuffs. Gapelek is dried cassava root, usually sliced, used for fodder. Rice starch is polygonal and is lamellar. Potato starch has conchoidal or ellipsoidal grains of lamellar structure. White potato starch is used for sizing textiles, nitrostarch, soluble starch, and dextrans. The starch molecule is a chain of glucose units, and the waxy starches valued for glues are those with branch chains. These starches do not crystallize easily. Amioca starch, developed during the war to replace tapioca, is from crossbred waxy corns. The starch contains only amylopectin molecules as a nonlinear polymer of glucose, which give stability in solution, clarity, and adhesiveness. While ordinary

starch gelatinizes slowly over a range of 30 deg from 64 to 94°C, the waxy starch gelatinizes sharply at 70°C over a range of only 8 deg, thus resembling the root starches.

Clear Flo starch, of the National Starch Products, is a sodium salt of a starch acid-ester derivative. It contains carboxyl, COOH, and sulphonic acid, HSO<sub>3</sub>, groups, and has great hydrating capacity, gelatinizing taking place at low temperatures and with sharpness. It is used in adhesives and water paints. The Dry Flo starch of this company is a treated starch with a hydrophobic hydrocarbon radical that is water-repellent. The fine starch powder flows almost like a liquid, and will not wet with water but can be wet with alcohol. It is used as a flattening agent in paints. Sulphonated starches are used as dirt-suspending agents with detergents in the cleansing of textiles. They prevent redeposition of dirt on the fibers. Nu-Film is a starch of this type.

Prolonged grinding of grain starches reduces the molecular weight, and the lower weight starches have greater solubility in cold water. In general, starch is a white, amorphous powder having a specific gravity from 0.499 to 0.513. It is insoluble in cold water. When boiled with water, starch produces a paste. Soluble starch is made by treating starch with cold, dilute acid. Starch gives a blue color with iodine, while the dextrans give violet and red. Animal starch is glycogen, the reserve food of animals, stored in the muscles and internal organs. Green fruits, especially bananas, often contain much starch until the ripening process has changed the starch to sugar. Potato starch, produced from the common white potato, *Solanum tuberosum*, is the most important commercial starch in Europe. Sweet-potato starch, from *Ipomoea batata*, gelatinizes completely at 165°F and has excellent colloidal and pasting qualities. An average of 10 lb of starch is produced per bushel. It is used as a foodstuff stabilizer and for textile finishing. Arrowroot starch is from the tubers of the *Maranta arundinacea* of the West Indies. It is very easily digested, and is valued for food products. Florida arrowroot is from the *Zamia floridana*. Other types of arrowroot are grown in the East. East Indian arrowroot is from the plant *Curcuma angustifolia* which belongs to the ginger family. Starch acetates are used as textile sizing and to replace dextrin in adhesives, and also for greaseproofing paper.

Alant starch, or Inulin, is not a starch but is a polysaccharide, or



insoluble sugar, used for making bread for diabetics. It is also used for making fructose. It is obtained from the potatolike roots of the Jerusalem artichoke, *Helianthus tuberosus*, a type of sunflower native to America but now grown widely in Europe. Starch sponge is an edible starch in the form of a coarse-textured, porous, crispy, sponge-like material, used for confections by impregnating with chocolate or sweets. In crushed form it is added to candy or cookies. It is produced by freezing starch paste, thawing, and pressing. The freezing insolubilizes the starch so that no soluble starch goes off when the water is pressed out. Nitrostarch, or Starch nitrate,  $C_{12}H_{12}O_{10}-(NO_2)_3$  is a fine white powder made by treating starch with mixed acid. It is highly explosive and is used for blasting, as a military explosive, and in signal lights. Grenite is nitrostarch mixed with an oil binder for use in grenades. Trojan explosive is a mixture of 40% nitrostarch with ammonium and sodium nitrates and some inert material to reduce the sensitiveness.

**Statuary bronze.** Copper alloys used for casting statues, plaques, and ornamental objects that require fine detail and a smooth, reddish surface. Most of the famous large bronze statues of Europe contain from 87 to 90% copper, with varying amounts of tin, zinc, and lead. Early Greek statues contained from 9 to 11% tin with as much as 5% lead added apparently to give greater fluidity for sharper casting. A general average bronze will contain 90% copper, 6 tin, 3 zinc, and 1 lead. Statuary bronze for cast plaques used in building construction contains 86% copper, 2 tin, 2 lead, 8 zinc, and 2 nickel. The nickel improves fluidity and hardens and strengthens the alloy, and the lead promotes an oxidized finish on exposure. The statuary bronze used for hardware has 83.5% copper, 4 lead, 2 tin, and 10 zinc.

**Stearic acid.** A hard, white, waxlike substance used for making paint driers, soaps, candles, lubricating greases, and in buffing compounds, cosmetics, and waterproofing compounds. It is the common constituent of hard fats, and is a white mass of the composition  $CH_3-(CH_2)_{16}COOH$ , soluble in alcohol but insoluble in water. The specific gravity is 0.922 to 0.935, and melting point 129 to 130°F. It is obtained from fats and oils by splitting and distilling, or it can be made from oleic acid by hydrogenation. Pearl stearic acid is the

material in free-flowing powdered bead form for compounding purposes. Stearic acid is also marketed in cakes, powder, or flake form, as single-pressed, double-pressed, or triple-pressed. The successive pressings remove more of the liquid oils, thus raising the melting point and giving a whiter, harder product with lower iodine value. Stearic acid is also used for making candles, usually mixed with palmitic acid or paraffin. Oleostearin, used for filling and finishing leather, is the stearin remaining after extraction of the edible Oleo oil from cattle fats. Oleo oil is the yellow oil obtained by cold-pressing the first-run tallow; Tallow oil is a grade following the first two grades of oleo oil. Stearite is a trade name for Synthetic stearic acid made by the hydrogenation of unsaturated animal and fish oils. It is used in rubber compounding, as it is more uniform than ordinary stearic acid. Hystrene, of the Trendex Co., is purified and hardened stearic acid in grades of 70, 80, and 97% stearic acid, with the remainder palmitic acid, used for candles, cosmetics, and stearates. Intarvin is a synthetic edible fat made from stearic acid by synthesizing Margaric acid,  $C_{16}H_{33}COOH$ , and then esterifying with glycerin. It is used for diabetics, as it will produce Acetoacetic acid in the system.

**Stearin pitch.** The brown to black by-product residue produced in the distillation of animal and vegetable oils and fats. It is used in varnishes, insulating compounds, floor coverings, and cold-molding compositions. It produces a low-cost paint that surface-skins and dries with a smooth enamellike finish. Stearin pitch is obtained as the residue from the oil splitting for the manufacture of candles, soaps, or fatty acids. It may also be called Candle tar, Candle pitch, or take its name from a specific oil such as Linseed pitch or Palm pitch. The pitch obtained from nondrying oils such as corn or palm is usually softer and more pliable than that from semidrying oils such as linseed or cottonseed.

**Steel.** Iron with carbon chemically dissolved in it, with no carbon in the free graphitic state. When raised to a red heat and cooled suddenly, it becomes exceedingly hard by the formation of carbides. This hardness can be modified by subsequent heat-treatment. Steels with less than 0.15% carbon harden only slightly, and these are technically classed as irons, although the name steel is used even

when the carbon is quite low, especially if there are other carbide-forming elements in the material. Steel is graded according to the percentage of carbon in it, and is roughly divided into four groups: Low-carbon steel, with 0.15 to 0.30% carbon; Medium-carbon steel, with 0.30 to 0.60% carbon; High-carbon steel, with 0.60 to 0.90% carbon; and Very high-carbon steel, with 0.90 to 1.5% carbon. Steel with more than 1.25% carbon is very brittle unless there are some other balancing elements. The low-carbon steels machine easily and can be forged readily. Those containing above 0.90% carbon are difficult to forge and machine. In general, the low-carbon steels are used for construction parts and the high-carbon steels for tools and high-strength parts. All steels contain some manganese, usually at least 0.30%, left after deoxidizing and desulphurizing with ferromanganese. The latter forms  $MnS$  and  $MnO$  which passes off in the slag, but sometimes an excess of manganese is used for hard steels as the manganese is a carbide-forming element. Sulphur in steel forms the weak and soft sulphide  $FeS$  which weakens the steel and promotes hot-shortness or brittleness at red heat. But sometimes a very small amount of sulphur is left in the steel to aid machinability. Oxygen in the steel forms the embrittling compound  $FeO$  and is undesirable in any quantity. Normally, phosphorus is considered detrimental in steels, but small amounts, up to 0.20%, in low-carbon steels increase the hardness, strength, and also increase corrosion resistance. Dirty steel is steel with inclusions of iron oxide from scrap used in the converter or of aluminum oxide from the aluminum used in deoxidizing. The melting point of steel varies with the carbon, but is always higher than that of cast iron with the same amount of combined carbon. The average weight of carbon steel is 0.283 lb per cu in.

Ordinary steel has only carbon as the influencing element, except that there are usually residual manganese, sulphur, and some other elements in very small amounts. The carbon forms the hard carbide  $Fe_3C$  when the steel is cooled suddenly, and the strength of the steel is greater with the increase in amount of carbon up to 0.85% which is the saturation point of the carbon in the iron. Above this point the metal becomes increasingly brittle unless there are other carbide-forming elements to take up the carbon that is thrown out. In modern practice a very large proportion of steels contain chromium, man-

ganese, vanadium, or other carbide-forming elements. Open-hearth steel is made by fusing cast iron with steel scrap or wrought iron in a regenerative furnace. Cementation consists in heating bars of wrought iron in contact with carbon. The product is known as Blister steel, as the surface of the bars is covered with blisters. Blister steel has a crystalline fracture decreasing toward the center of the bar where there is less carbon. Shear steel is produced from this blister steel by cutting and piling together, heating to a high temperature, and rolling or hammering into bars. Shear steel was originally the only form of commercial steel.

Bessemer steel is made by decarbonizing cast iron by forcing a powerful blast of air through the molten iron. Crucible steel is made by melting wrought iron in a crucible with charcoal and ferromanganese, or special steel mixes in a crucible furnace. The slag separates by gravity from the molten metal in the crucibles, and the oxides combine with carbon and manganese or aluminum, and boil off. The metal is poured into ingots which are reheated and rolled into bars or other forms. The crucible process permits a high degree of control and reduces sulphur and phosphorus.

Electric steel is made in either the induction or the arc-type furnace, and is of a uniform quality and of a higher strength and ductility than open-hearth steel of the same carbon content. The ordinary wrought steel used for wrought-steel pipe has a tensile strength of 52,000 psi, yield point 30,000 psi, and elongation 20%. The tensile strength of a typical open-hearth steel varies from about 50,000 psi for a 0.12% carbon steel to 110,000 psi for a 0.55% carbon steel, with elongations of 29 and 12%, respectively. Ordinary forgings are made from steels of 0.15 to 0.30% carbon, and strong forgings from steel with 0.35 to 0.40% carbon, but most strong forgings are now made with alloy steels. Raising the carbon content from 0.40 to 0.45% will increase the possible hardness of the steel about 10%, but greater variations in strength and hardness of a steel may come from heat-treatment. Aircraft quality steel, or Magnaflux steel, refers to the quality and tests of the steel rather than to a type of steel. This steel is used for important highly stressed parts, and it is subject to restrictive chemical specifications, macro etch tests, and other mechanical tests. The magnaflux method of inspection is done by magnetizing the material and applying a

magnetic powder which adheres along the lines of flux leakage, showing any surface or subsurface irregularities.

**Steel powder.** Finely divided steel powder used for molding under hydraulic pressure into various parts which are then sintered at a temperature of 1075°C. The tensile strength of the molded and sintered products is about the same as that of cast steel of the same composition. It has the advantage that there is no metal loss in machining, and accurate gears, cams, and other parts can be made without machining labor. Sinterloy is the name of a steel powder marketed by Charles Hardy, Inc., in compositions of 0.05, 0.40, and 0.80% carbon. Some grades also contain nickel and chromium. Durex iron, of the Moraine Products Div., General Motors Corp., is iron or steel made by compressing iron powder containing a small percentage of carbon and sintering in special furnaces with controlled atmospheres. It can be controlled by pressure to form 70 to 95% of the density of pure iron; or with a porosity range from 5 to 30% by volume when it is desired to impregnate with oil. The final compressed and sintered product has a structure similar to that of carbon steel, and intricate shapes can be made to close tolerances that require no machining. It is used for mechanical parts or the porous variety for bearings. Porex is a trade name of this company for porous metals made from powders and used as filters. The production of products by the compression and sintering of powders is called Powder metallurgy. P.M.P. iron, of the Powdered Metals Corp., used for bearings, contains 90% iron and 10 copper. With a density of 5.5 lb per cu in. it has a tensile strength of 30,000 psi and will absorb 30% of oil by volume. When compressed to a higher density, it has greater strength, and is used for cams and machine parts. Stainless-steel powder has a typical analysis of 17.36% chromium, 8.89 nickel, 0.11 carbon, 0.47 silicon, 0.022 phosphorus, and 0.008 sulphur. It is prealloyed, and the powder has the original grain boundaries broken down. The Prealloyed steel powders of the Vanadium Alloys Steel Co. are in a wide variety of compositions of carbon and alloy steels. The particles are spherical and are in meshes 50 to 100. Physical properties of parts made by powder metallurgy are generally about the same as those of wrought metal, but the tensile strength, density, and hardness can be controlled by choice of powder size and

by the pressure. Any degree of porosity may be obtained, and Stainless steel filters are thus made. The stainless steel powder of the American Electro Metal Corp. has spongelike particles, and it comes in mixed screen sizes from 100 to 325 mesh to give high green strength in the pressed part before sintering.

**Steel wool.** Long, fine fibers of steel used for abrasive purposes, chiefly for cleaning utensils and for polishing. It is made from low-carbon bessemer wire of high-tensile strength, usually having 0.10 to 0.20% carbon and 0.50 to 1 manganese. The wire is drawn over a track and shaved by a stationary knife bearing down on it, and may be made in a continuous piece as long as 100,000 ft. Steel wool usually has three edges but may have four or five, and strands of various types are mixed. There are nine standard grades of steel wool, the finest of which has no fibers greater than 0.0005 in. thick, the most commonly used grade having fibers that vary between 0.002 and 0.004 in. Steel wool comes in batts, or in flat ribbon form on spools usually 4 in. wide. Stainless steel wool is also made, and Copper wool is marketed for some cleaning operations.

**Stillingia oil.** A drying oil obtained from the kernels of the seeds of the tree *Stillingia sebifera*, cultivated in China. The seeds contain about 23% of a light-yellow oil resembling linseed oil but of somewhat inferior drying power. The oil has a specific gravity of 0.943 to 0.946 and iodine value of 160. It has the peculiar property of expanding with great force at the congealing point. Stillingia oil is edible, but deteriorates rapidly, becoming bitter in taste and disagreeable in odor. Stillingia tallow, also known as Chinese vegetable tallow, is obtained by pressing from the coating, or mesocarp, of the seeds. Sometimes the whole seed is crushed, producing a softer fat than the true tallow. The tallow contains palmitic and oleic acids and is used in soaps and for mixing with other waxes. Some stillingia trees are grown in Texas.

**Strontium.** A metallic element of the alkaline earth group, symbol Sr. It occurs in the minerals Strontianite,  $\text{SrCO}_3$ , and Celestite,  $\text{SrSO}_4$ , and resembles barium in its properties and combinations. Celestite is mined chiefly in Spain and Mexico. Strontium has a pale-yellow color, specific gravity 2.54, melting point about  $900^\circ\text{C}$ , and it de-

composes water. It is obtained by electrolysis of the fused chloride. Strontium compounds are used as deoxidizers in nonferrous alloys, and in fireworks to furnish oxygen and give a colored flame. The chief use is for red signal flares. It has been used in some hard, heat-resistant lubricating greases. Strontianite was used in Germany for desulphurizing steel.

**Strontium nitrate.** A yellowish-white, crystalline powder of the composition  $\text{Sr}(\text{NO}_3)_2$ . It is the strontium salt of nitric acid and is prepared by roasting Celestite, leaching out the strontium sulphide, and dissolving the strontium carbonate in dilute nitric acid. The yellowish commercial product is 99.5% pure. It is soluble in water but insoluble in alcohol. The specific gravity is 2.96 and melting point is  $645^\circ\text{C}$ . Strontium nitrate gives a beautiful crimson flame and is used in red lights, railway-signal flares, and signal stars. It also furnishes the oxygen necessary for the combustion of the compounds. A typical flare compound contains 50% strontium nitrate,  $37\frac{1}{2}\%$  potassium chlorate, and  $12\frac{1}{2}\%$  shellac, the last serving as a binder and to furnish heat of combustion. The Strontium sulphate used as a brightening agent in paints, and as a filler in rubber and in sealing wax, is powdered celestite. Strontium carbonate, used in pyrotechnics and in glass and ceramics, is  $\text{SrCO}_3$ , marketed 99.5% pure. Strontium sulphide,  $\text{SrS}$ , used for luminous paint, gives a persistent blue-green glow, but it deteriorates rapidly unless placed between glass plates and sealed in.

**Styrax.** A grayish-brown, viscous, sticky, aromatic balsam obtained from the small tree *Liquidambar orientalis* of Asia Minor. It is also called Levant styrax. It is used in cough medicines and for skin diseases, as a fixative for heavy perfumes, and for flavoring tobacco and soaps. American styrax is obtained by tapping the sweet gum, *L. styraciflua*, of Alabama, a tree producing 8 oz of gum per year. It is a brownish semisolid and has the same uses as Levant styrax. It is shipped from Central America under the name of Liquidambar, and in the southern United States is called Sweet gum and Storax. The gum is not present in large amounts in the wood, but its formation is induced by cuts. The red gum of Louisiana yields 2.5 oz per tree per year. Benzoin is another balsam obtained from several species of *Styrax* trees. It is a highly aromatic solid with an odor like vanilla,

and is used in medicine and in perfumes and incense. Sumatra benzoin is from the tree *S. benzoin* and comes in reddish-brown lumps or tears. In medicine it was originally called Gum Benjamin. Siam benzoin, from southern Asia, is from the trees *S. tonkinense* and *S. benzoides*. It is in yellowish or brownish tears. The Sumatra benzoin contains cinnamic acid, while the Siamese gum contains benzoic acid. Benzoic acid, or Phenylformic acid,  $C_6H_5COOH$ , formerly produced from benzoin, is now made synthetically from benzol or toluol. It is a white crystalline solid melting at  $122^{\circ}C$ , soluble in water and in alcohol, used as a food preservative, an antiseptic, for flavoring tobacco, as a weak acid mordant in printing textiles, and in the manufacture of dyestuffs, pharmaceuticals, and cosmetics. It is poisonous, and not more than 0.1% is used in food preserving in the form of its salt, Benzoate of soda, or Sodium benzoate,  $C_6H_5COONa$ , a white crystalline powder. Anisic acid,  $CH_3OC_6H_4COOH$ , used for pharmaceuticals, is the methyl ether of hydroxy benzoic acid. It is produced synthetically from carbon tetrachloride and phenol, and is a solid melting at  $184^{\circ}C$ .

**Suède.** Also called Napped leather. A soft-finished, chrome-tanned leather made from calf, kid, or cowhide splits, or from sheepskin. It is worked on a staking machine until it is soft and supple, and then buffed or polished on an abrasive wheel. It has a soft nap on the polished side and may be dyed in any color. Suède is used for shoe uppers, coats, hats, and pocketbooks. Artificial suède, or Izarine, of the Atlas Powder Co., has a base of rubberized fabric. A thin coating of rubber cement is applied to one side which is sprinkled with fine cotton fibers dyed in colors. The sheet is beaten from the bottom to make the fibers stand out until the cement hardens. It is then vulcanized. The fabric looks and feels like fine suède.

**Sugar.** A colorless to white or brownish crystalline, sweet material produced by evaporating and crystallizing the extracted juice of the Sugar cane or the Sugar beet. Refined sugar is practically pure Sucrose,  $C_{12}H_{22}O_{11}$ , and in addition to being a sweetening agent for many foods it is a valuable carbohydrate food, and also a food preservative. When used with cooked fruits to make jams and jellies, it is both a preservative and an added food material. Lack of sugar in the diet develops ketosis, the disease of diabetics, and results in the



wasting away of muscles, using up of the reserve fats, and the production of poisonous ketones. The natural brown sugar contains about 2% of the minerals found in the plant, calcium, iron, phosphorus, magnesium, and potassium and, although these are valuable as foods, they are lost in the refining process to make white sugar. Sugar can be refined readily to 99.7% purity with retention of the vitamins and mineral salts by treating with methyl alcohol, but the process has not been commercialized. Sugar is also one of the most economical raw materials for the production of ethyl alcohol, being used for this purpose in the form of molasses or invert sugar.

Sugar cane, *Saccharum officinarum*, is a tropical plant, originating in Asia and first brought to the Canary Islands in 1503 and thence to the West Indies. The plant will not withstand frost, but can be grown in a few favored regions outside of the tropics such as Louisiana. It is now grown on plantations in Cuba, Hawaii, Brazil, Philippines, East Indies, Puerto Rico, Peru, and many other countries. The cane or stalks of the plant are crushed to extract the juice, which is then concentrated by boiling, crystallized, and clarified with activated carbon or other material. The sugar beet is a white-rooted variety of the common beet, *Beta vulgaris*, and grows in temperate climates. It is cut up and boiled to extract the juice, and the production and refining of the sugar are essentially the same as for cane sugar. There is no difference in the final product, although Raffinose, or Melitriose,  $C_{18}H_{32}O_{16}$ , a tasteless trisaccharide, occurs in the sugar beet, and may not be completely changed to sucrose by hydrolysis, so that a greater quantity may sometimes be needed to obtain equal sweetening effect.

Refined commercial sugar contains 99.98% sucrose, and is graded by screening to crystal size. The best qualities are the larger crystals from the first and second runs. The soft sugars are from further crystallizing, until the noncrystallizing brown sugars are reached. Raw sugar testing 96° by the polariscope is the grade used as a basis for raw-sugar quotations. About 107 lb of this grade of sugar are required to produce 100 lb of refined sugar.

Cane sirup is the high-grade sirup or liquid sugar, while Molasses is the heavy residual sirup left after the crystallization. Edible molasses is the yellow to brownish, light purified residue sirup. Blackstrap molasses is the final, inedible, unpurified residue heavy

sirup, used for the production of ethyl alcohol. It contains 50 to 60% sugar by weight, mostly sucrose but some glucose. Cuban sugar mills average 48 gal of blackstrap molasses per ton of sugar, and 2.5 gal of molasses containing 50% sugar produces 1 gal of 95% alcohol. Papelon is a name used in northern South America for solidified edible molasses. Gur is the crude unrefined brown sugar of India. It polarizes between 50 and 60°. The Pilancillo used in Mexico is unrefined brown sugar. Treacle is an English term for edible molasses. The Beet pulp after extraction of the juice is marketed as cattle feed. The refuse from sugar cane is used as fuel and for making insulating board. Liquid sugar is cane sugar in various liquid densities and various degrees of invert, used in large-scale food manufacturing as it saves handling costs. For food manufacturing it may be obtained with calcium and other mineral contents and is then golden in color. Flo-Sweet, of the Refined Syrups & Sugar, Inc., is such a liquid sugar. Caramel, used for flavoring and coloring foodstuffs and liquors, has a deep brown color and a characteristic taste. It is burnt sugar marketed as liquid or powder.

A type of edible sugar sirup is also obtained from the juice of a variety of Sorghum grass, *Sorghum vulgare*, native to South Africa, but now grown in southern United States. The juice or sirup, called Sorghum sirup, or Sorgo sirup, is light in color, has a characteristic delicate flavor, and contains gums and starch, which prevent crystallization. It also contains other sugars besides sucrose, and considerable mineral salts of value as foods. The total sugar in the juice is from 9 to 17%, varying with the age of the plant. It is used in some sections to replace sugar, and is employed in some confectionery to give a distinctive flavor.

Apple sirup, or Apple honey, used as a sweetening agent in the food industry, for curing hams, and as a substitute moistening agent for tobacco, is made from cull apples. The reduced sirup is treated to remove the bitter calcium malate. The sirup contains 75% solids of which 65% consists of the sugars levulose, dextrose, and sucrose. Palm sugar, or Jaggary, is the evaporated sap of several varieties of palm, including the coconut and the palms from which kittool, gomuti, and palmyra fibers are obtained. The sap contains about 14% sugar. It is much used in India and the Pacific Islands. The alcoholic beverage Arrack is made by fermenting this sap. Wood molasses is

made by concentrating and neutralizing the dilute sugar solution produced by pressure hydrolysis of wood chips using dilute sulphuric acid at high temperature. The molasses has a slightly bitter taste, but is used for stock feed and for industrial purposes. The molasses yield is 150 to 190 gal of 50% sugar strength per ton of wood, with 10 to 20 lb of methanol and 10 to 30 lb of furfural as by-products. Saccharin, sometimes used as a substitute sweetening agent instead of sugar, is Benzoic sulphinide,  $C_6H_4SO_2NHCO$ , a coal-tar product. It is 450 times sweeter than sugar, but has a disagreeable flavor and no food value. Amino sugar, or Glucosamine, has an  $NH_2$  group in the molecule in place of the alpha hydroxyl group  $OH$  of glucose. It is found in marine animals.

**Sugar pine.** The common name of the wood of the *Pinus lambertiana*, a coniferous tree growing in California and Oregon. The tree grows ordinarily to a height from 150 to 175 ft with a diameter of 4 to 5 ft. Occasional trees are more than 200 ft in height and 12 ft in diameter, and are often free of limbs up to 75 ft from the ground. It is the largest of the pines. The stand is estimated to be 35 billion board feet and is cut at the rate of 300 million feet annually. Sugar pine is durable, has moderate strength, fairly even grain, and is not subject to excessive shrinkage or warping. Because of the latter quality it has come into use to replace the scarcer eastern pines for patterns. It does not darken on exposure like western pine. It is widely employed for construction work and for Factory lumber for doors, frames, boxes, and wooden articles. Sugar pine is classified into three standard classes of grades according to freedom from knots and faults as select, commons, and factory, or shop. The selects are designated as No. 1, and 2 clear, C select, and D select. The commons are graded as No. 1, 2, 3, and 4; the factory as No. 3 clear, No. 1 shop, No. 2 shop, and No. 3 shop. The shops are judged with the idea that they will be cut up into small pieces, and are consequently classified by the area of clear cuttings that can be obtained.

**Sulfamic acid.** A white crystalline odorless solid of the composition  $HSO_3 \cdot NH_2$ . It is very soluble in water, but only slightly soluble in alcohol or ether. The melting point is  $205^\circ C$ , and the molecular weight 97.1. Sulfamic acid is used for bating, pickling, and tanning leather. It makes a silky and tight grain in leather. It is

also used in the form of Ammonium sulfamate for making textiles and paper fire-resistant, for the manufacture of dyes, and as a weed killer. Lead sulfamate,  $\text{Pb}(\text{SO}_3\text{NH}_2)_2$ , is very soluble in water and is used in lead plating. The solution has high throwing power and gives rapid plates.

**Sulphonated oil.** A fatty oil that has been treated with sulphuric acid, the excess acid being washed out, and only the chemically combined acid remaining. The oil is then neutralized with an alkali. Sulphonated oils are water-soluble and are used in cutting oils and in fat liquors for leather finishing. Sulphonated castor oil is called Turkey red oil. Leatherlubric is the trade name of E. F. Houghton & Co. for sulphonated sperm oil used for leather. Solcod is the sulphonated cod oil of the same company. Sulphonated stearin and Sulphonated tallow are also used in leather dressing. They are cream-colored pastes readily soluble in hot water. Mahogany soap is a name for oil-soluble petroleum sulphonates used as dispersing and wetting agents, corrosion inhibitors, emulsifiers, and to increase the oil absorption of mineral pigments in paints. Petronate, of L. Sonneborn Sons, Inc., is a petroleum sulphonate containing 62% sulphonates, 35 mineral oil, and 3 water. Phosphorated oils, or their sulphonates, may be used instead of the sulphonates as emulsifying agents or in treating textiles and leathers. They are more stable to alkalis. Phos-oils, of the Beacon Co., are phosphorated vegetable oils. Aquasol, of the American Cyanamid Co., is a sulphonated castor oil used as an emulsifying agent. Cream softener is a name used in the textile industry for sulphonated tallow.

**Sulphur.** An element, symbol S, which occurs abundantly in its uncombined state. It is obtained from the gypsum deposits of Texas and Louisiana, and from volcanic deposits in Sicily, Mexico, Chile, and Argentina. It is purified by distillation. It can also be obtained by distillation from iron pyrites and as a by-product from copper and zinc smelting. The Sterri exported from Sicily for making sulphuric acid is broken rock rich in sulphur. Sulphur forms a crystalline mass of a pale-yellow color. Its hardness is 1.5 to 2.5 and specific gravity 2.05 to 2.09. It melts at 232°F. At about 780°F it is converted into a ruby-colored vapor. The amorphous sulphur has a specific gravity of 1.955. When melted and cast into sticks, it is known as Brim-

stone. Sulphur also condenses in light flakes, in which form it is known as Flowers of sulphur. Flotation sulphur is a fine, free-flowing dust containing a minimum of 95% sulphur. It has particles of extreme fineness, 80% of which are less than 4 microns in diameter. It is recovered in gas production from coal. Also, the sour natural gas of Arkansas contains a large proportion of the offensive smelling, colorless Hydrogen sulphide gas,  $H_2S$ , which yields sulphur powder.

Sulphur has a great affinity for most metals and combines with great energy when heated together with them. Sulphur, even in very small quantities, makes metal alloys brittle and must ordinarily be kept out of commercial metals. Sulphur has many uses in the formation of sulphur compounds and sulphuric acid, for making gunpowder, for vulcanizing rubber, for bleaching cloth, as a fumigant, and in medicine. It is also used as a cement for anchoring iron in stone and for lining iron pipes for brine waters. Commercial crude Sicilian sulphur contains from 2 to 11% of impurities and is sold in three grades. Refined sulphur is marketed in crystals, roll, or various grades of powder, and the Sicilian superior grade is 99.5% pure. This is the grade used in rubber manufacture. The sulphur of the Texas Gulf Sulphur Co. is 99.5% pure and is free of arsenic, selenium, and tellurium. Crystex, of the Stauffer Chemical Co., is a sulphur, 85% insoluble in carbon bisulphide, used in rubber compounding. Thionyl chloride,  $SOCl_2$ , is a yellow liquid used in synthesis as a source of sulphur with or without oxygen.

Vegetable sulphur is not sulphur, but the name is a colloquial term for Lycopodium, also known as Club moss. It is a fine yellow powder derived from the spores of a fernlike plant, *Lycopodium clavatum*, a perennial growing in North America, Europe, and Asia. Its chief use is in medicine, but it is also employed in fireworks and flashlight powder and as a dusting powder for sand molds for fine castings.

**Sulphur dioxide.** Also known as Sulphurous acid anhydride. It is colorless gas of the composition  $SO_2$ , employed for industrial bleaching, as a preservative, and in refrigeration. It is used extensively for domestic refrigerating machines. The gas is poisonous, but has a pungent, suffocating odor and is thus detected easily. It is also easy to locate small leaks by cloud test with ammonia. It is corrosive to

organic materials but does not attack copper or brass. Sulphur dioxide in refrigerating machines has a condensing pressure of 51.7 lb gage at 86°F, and a pressure of vaporization of 2.9 lb gage at 5°F. It boils at  $-10^{\circ}\text{C}$ . It is soluble in water, forming Sulphurous acid. Sulphur dioxide is produced by roasting pyrites in a furnace. It is also obtained from metallurgical waste gases. Sulphurous acid is a colorless liquid of the composition  $\text{H}_2\text{SO}_3$ , with suffocating fumes. It is made commercially by absorbing the sulphur dioxide gas in water. The USP grade has a strength of 6%. Sulphurous acid is used in industrial bleaching.

**Sulphuric acid.** Also called Oil of vitriol and Vitriol. An oily, highly corrosive liquid of the composition  $\text{H}_2\text{SO}_4$ , used for pickling and cleaning metals, plating baths, making explosives, rayon, electric batteries, production of fertilizers, and for many other purposes. In weak solutions sulphuric acid is sometimes known in the metal industries as Dipping acid, and in the automotive trade as Battery acid. Concentrated acid, or Fuming sulphuric acid, was known as Nordhauser acid. The specific gravity is 1.834 and boiling point  $210^{\circ}\text{C}$ . It is miscible in water in all proportions. The color is yellowish to brownish according to the purity. It disintegrates wood, rubber, and most organic materials and many metals, but the weak acid does not dissolve lead or mercury. Sulphuric acid is made from sulphur or from pyrites, or by oxidizing the sulphur dioxide from the waste gases of copper and zinc smelters and absorbing the gas in water. In Germany it is made from gypsum by breaking down and treating the  $\text{SO}_2$  gas. The common commercial grade of sulphuric acid known as oil of vitriol is  $66^{\circ}\text{Bé}$ , which is 93.2% acid. Other grades are 50 and  $60^{\circ}\text{Bé}$ . Sulphuric anhydride, or Sulphur trioxide,  $\text{SO}_3$ , is the acid minus water. It is a colorless volatile liquid boiling at  $46^{\circ}\text{C}$ , and forms sulphuric acid when mixed with water. It is used for sulphonation. Sulfan, of the Allied Chemical & Dye Corp., is a stabilized sulphuric anhydride for textile processing and chemical manufacture.

Niter cake, which is Sodium acid sulphate,  $\text{NaHSO}_4$ , or Sodium bisulphate, contains 30 to 35% available sulphuric acid and is used in hot solutions for pickling and cleaning metal articles. It comes in colorless crystals or white lumps, of a specific gravity of 2.435 and melting point  $300^{\circ}\text{C}$ . Sodium sulphate, or Glauber's salt, is a white

crystalline material of the composition  $\text{Na}_2\text{SO}_4 \cdot 10\text{H}_2\text{O}$ , used in making kraft paper, rayon, and in glass. It was first produced from Hungarian spring water by Johann Glauber, and when obtained from mineral springs is called Crazy water crystals. The Burkeite, sodium sulphate-sodium carbonate double salt, which separates out of Searles Lake brine, is used to produce sodium sulphate and other chemicals as by-products. Salt cake,  $\text{Na}_2\text{SO}_4$ , is impure sodium sulphate used in the cooking liquor in making paper pulp from wood. It is also used in freezing mixtures. Synthetic salt cake, used for making kraft pulp, is produced by sintering soda ash and sulphur. Chrome cake is a greenish by-product salt cake which contains some chromium as an impurity. It is used in papermaking. Kaiscroda is a German name for salt cake of high purity obtained as a by-product from the production of magnesium chloride from potash minerals. Sodium sulphite,  $\text{Na}_2\text{SO}_3$ , or  $\text{Na}_2\text{SO}_3 \cdot 7\text{H}_2\text{O}$ , is a white to tan crystalline powder very soluble in water but nonhygroscopic. Santosite, of the Monsanto Chemical Co., is a grade of sodium sulphite containing 93% sodium sulphite with the balance chiefly sodium sulphate. Sodium sulphide,  $\text{Na}_2\text{S}$ , is a pink flaky solid, used in tanneries for dehairing, and in the manufacture of dyes and pigments. The commercial product contains 60 to 62%  $\text{Na}_2\text{S}$ , 3.5 NaCl and other salts, and the balance water of crystallization. Sodium sulphydrate,  $\text{NaSH}$ , is in lemon-yellow flakes. It has much less alkalinity than sodium sulphide, and is used in tanneries in unhairing solutions, and for making thiourea and other chemicals. Aminoethyl sulphuric acid,  $\text{NH}_2\text{CH}_2\text{CH}_2\text{OSO}_3\text{H}$ , is used to increase wet strength and water repellency of paper and for treating cotton fibers. White vitriol is Zinc sulphate,  $\text{ZnSO}_4 \cdot 7\text{H}_2\text{O}$ , in colorless crystals soluble in water and melting at  $39^\circ\text{C}$ . It is used for making zinc salts, as a mordant, for zinc plating, and as a preservative in adhesives.

**Sumac.** The dried ground leaves of the bush *Rhus coriaria* of Sicily, or *R. typhina* of eastern United States, used for tanning leather. The Sicilian leaves contain up to 30% tannin, and the American leaves up to 38%. It contains gallotannin and ellagitannin, and gives a rapid tan. Sumac produces a light strong leather of fine soft grain and has a bleaching action which can produce a white leather. It is used for book and hatband leathers.

**Sunflower oil.** A pale-yellow drying oil with a pleasant odor and taste obtained from the large seeds of the common sunflower plant, *Helianthus annuus*, of which there are many varieties. The plant is native to Peru but is now grown in many parts of the world, particularly in California, Canada, Argentina, Chile, Uruguay, and Russia. It requires boron in the soil. The specific gravity of the oil is 0.925. Sunflower oil is used in varnish and soap manufacture or as a food oil. The by-product cake is used chiefly for cattle feed, but Sunflower meal is also blended with wheat flour or cornmeal in foods. It is higher in vitamin B than soybean flour. Sunflower seeds are also used as poultry feed. Madia-seed oil is quite similar to sunflower oil and has the same uses. It is obtained from the seeds of the plant *Madia sativa*, native to California. The seeds contain 35% oil, and the cold-pressed oil has a pleasant taste. Watermelon-seed oil, produced in Senegal as Bereff oil, is an edible oil similar to sunflower. It contains about 43% linoleic acid, 27 oleic, 19.5 stearic, and 5 palmitic acid.

The leaves of selected varieties of some species of sunflower contain from 1 to 6% Sunflower rubber and up to 8 resin. The *H. occidentalis*, *H. giganteus*, *H. maximiliani*, and *H. strumosus*, are cultivated in Russia both for the oil seed and for the rubber in the leaves. These perennials yield leaves up to 10 years. A stand of 50,000 plants per hectare yields about 150 kilos of rubber and 325 kilos of resin. Another similar rubber-bearing plant of southern Russia is the *Asclepias cornuti*, known as Vatochnik. It is a perennial, producing leaves for 10 to 15 years. The leaves yield 1 to 6.5% rubber and large percentages of resin.

**Sun hemp.** The bast fiber of the plant *Crotalaria juncea*. It is used for cordage and rope in place of jute, but is lighter in color and is more flexible, stronger, and more durable than jute. It resembles true hemp, but is not as strong. It is more properly called Sann hemp from the Hindu word Sann. It is also known as Sunn fiber, Indian hemp, and Bombay hemp. The plant, which is a shrub, is cultivated extensively in India. It grows to a height of about 8 ft, with slender branches yielding the fiber. The method of extraction is the same as for true hemp. The best fibers are retained locally for making into cloth. It is also used in the United States for making



cigarette paper, and for oakum. Madras hemp is from another species of the same plant.

**Superbronze.** A name applied to brasses containing both aluminum and manganese. They are ordinarily high brasses modified with 2 to 3% manganese and 1 to 6 aluminum, with sometimes also some iron. They have greatly increased strength and hardness over the original brasses, but the ductility is reduced and they are difficult to work and machine. The early superbronze was known as Heusler alloy. Muntz metal is also frequently modified with manganese, iron, and aluminum. The alloys are used where high strength and corrosion resistance are required, and they are often marketed under trade names. Tensilite, of the American Manganese Bronze Co., is a bronze of this type. A grade containing about 64% copper, 30 zinc, 2.5 manganese, 3 aluminum, and 1 iron has a tensile strength, cast, up to 100,000 psi and elongation 16%. Mallory metal is a superbronze of the P. R. Mallory Co., but Mallory 100 metal is a high-conductivity, heat-treatable strong alloy containing 2.6% cobalt, 0.40 beryllium, and the balance copper. It has a tensile strength of 90,000 psi and an elongation of 8 to 15%.

**Sycamore.** The wood of the tree *Acer pseudo-platanus*, which is also classed as a kind of maple, especially in England. The species cut as sycamore in the United States is largely *Platanus occidentalis*. The wood has a close, firm, tough texture and is yellowish in color, with a reddish-brown heartwood. The light-colored sapwood is up to 3 in. thick in commercial trees. When quartered, the wood resembles quartered oak. The weight is about 38 lb per cu ft. The surface is lustrous and takes a fine polish. It is used for veneers, flooring, furniture, cooperage, and for handles and rollers. Two other species grown in the Southwest are California sycamore, *P. racemosa*, and Arizona sycamore, *P. wrightii*.

**Synthetic resins.** A large group of resinlike materials, properly called Resinoids, although this term is now seldom used except as applied to resin bonds for grinding wheels. The resins, or Plastics, are complex compounds produced synthetically by either polymerization or condensation of various chemicals. The physical characteristics and high molecular weights depend upon the number of repeating

molecular groups that make up the resins. The basic molecule of a synthetic resin is called a Monomer, and the recurring additions of monomers is called a Polymer. Polymerization is the chemical union of many simple molecules, and the chemical formula of the final product is identical with that of the structural unit or monomer. The process of polymerization is achieved through the action of light, heat, pressure, or a chemical catalyst. Thus, in the polymerization of styrene, the basic formula  $C_6H_5CH:CH_2$  is repeated over and over to form polymers, or polystyrene, with constantly increasing molecular weights until the process is stopped when the desired characteristics are reached. Condensation plastics are made by the action between two different molecules. In this fusion of two molecules, a simple molecule, such as water or ammonia, may be eliminated in the process. For example, when a dibasic acid,  $R(COOH)_2$ , is reacted with a diamine  $R'(NH_2)_2$ , as in the production of the nylons, water is eliminated, the nature of the molecule is changed, and it is increased in size. Where certain terminal groups are present, in this case  $-COOH$  and  $-NH_2$ , polycondensation produces plastics with increasing molecular weights, but the molecular formula is different from that of either of the two original materials condensed. Styrene and butadiene can be polymerized separately to form polymerization plastics, but when both together are condensed, as in making Buna S rubber, the copolymer is a different product from either product formed by separate polymerization.

The chief groups of synthetic resins are Phenolaldehyde, Aminoaldehyde, and the Hydroxycarboxylic, or alkyd, vinyl, acrylic, styrene, and indene. Cellulose nitrate, cellulose acetate, and the proteins such as casein are classed with the others as plastics, but they are not synthetic resins like the others. Molding plastics consist of the partly polymerized resin either alone or mixed with pigment and filler, usually in powder form, for molding to the final set by heat and pressure. A thermosetting resin assumes a permanent set under heat and cannot be remolded like a thermoplastic resin. The filler may be wood flour, fibers, or mineral powders, but it should have the characteristic of being wet by the resin. Some mineral fillers such as bentonite, when used in colloidal powder form, may combine chemically with the resin to give a copolymer or cross linkage of the molecule and thus give new characteristics to the plastic. Thermo-

plastic resins can often be made thermosetting by reacting with formaldehyde or sulphur and vulcanizing to set up cross linkages. The Epon resins of the Shell Chemical Corp. are condensation linear polymers with carbon-to-carbon linkage and ether linkage, and with the hydroxyl groups widely spaced so that the curing agents crosslink the chain to produce flexibility in the thermoset resin. The hydroxyl groups are also etherified, which gives better color retention than with phenol resins. These resins are used for spar varnishes and baking enamels.

For use in adhesives, lacquers, and coatings, the resins are mixed with plasticizers and sometimes with other gums and resins to give flexibility or other characteristics. Albertol resins was a name of the original German resins mixed with natural resins for greater pliancy. Tough, shock-resistant molding plastics are now obtained by mixing synthetic rubber with the synthetic resin. When a thermoplastic phenolic resin is incorporated with a nitrile rubber, the molding is rubbery if less than 50% resin is used, but with higher resin content the product is hard and has high impact strength. The nitrile rubber-vinyl chloride blends have good flexibility and tear resistance. The Tuf-Lite plastic of the Goodyear Tire & Rubber Co. is a blend of high-styrene resin and a synthetic rubber. It is light in weight and resistant to mechanical shock. While the synthetic resins may be sold under various trade names, different names may be given to the compounded and molded plastics by the molders. There is a great variety of these names, such as Durium and Insurox. The Plastag of the Camillus Cutlery Co., made to imitate bone and antler for knife handles, is a heavily pigmented cellulose acetate.

Nypene is a terpene polymer resin of the composition  $(C_{10}H_{16})_x$ , produced from turpentine by The Neville Company. It is stable, alcohol-resistant, light in color, and permanently thermoplastic. The specific gravity is 0.98, and melting point  $145^{\circ}\text{C}$ . It is used to soften and plasticize rubber, to add adhesive qualities to rubber and latex in making rubber cements, and in compounding wax protective coatings. Copene is similar to Nypene, but with a lower molecular weight of 1,100. The melting point is about  $120^{\circ}\text{C}$ . It is used as a softening and tack-producing agent in rubber and in other plastics. Vandiset resin, of the Wilson Carbon Co., is a thermoplastic black synthetic resin produced by a regrouping of the hydrocarbons from

Venezuelan crude oil. It has quick-setting and rapid oxidation characteristics ascribed to the presence of vanadium oxide. It is used in molding plastics, varnishes, and printing inks. A group of resins is made from Fumaric acid, which is a free-flowing powder of the composition  $\text{HOOC} \cdot (\text{CH})_2 \cdot \text{COOH}$  made by the fermentation of carbohydrates. Its esters are polymerized to form liquid or solid resins which are clear and stable. Acetone-formaldehyde resins made by reacting acetone and formaldehyde with an alkaline catalyst are used in lacquers, adhesives, and printing inks. They are rapid drying, insoluble, and give high gloss. Koresin, of the General Aniline Film Corp., used to improve tackiness in synthetic rubbers, is a condensation product of acetylene and butylphenol.

Plastic film, usually in thicknesses from 0.0015 to 0.006 in., is used for wrapping and sealing, for waterproofing garments, for coating wood, paper, or fabrics, and for table coverings. It is made by continuous casting on an endless belt, and various resins and plasticizers are used to give the desired characteristics. Vinyl film 7051, of the B. F. Goodrich Co., comes in thicknesses to 0.006 in. in widths to 54 in. It is translucent, and can be printed on with vinyl inks. It can be bonded with high-frequency heaters or stitched on ordinary sewing machines. Reynolon film, of the Reynolds Metals Co., comes in various vinyl compositions or in polyethylene. The films are transparent or in colors. The Polyvinyl chloride film in thicknesses of 0.001 to 0.003 in. is used as a tough, transparent wrapping for food products.

**Talc.** A soft, friable mineral, usually oily and yielding to the touch. The very white colloidal talc, such as that from the Alpine cliffs of northern Italy, with a soapy feel, is used for cosmetics; the massive form is cut into electrical and chemical articles and kiln-fired, or ground for use as a filler for paper, paints, and rubber, as a filtering agent, and for molding into ceramic insulators, heater parts, and chemical ware. Talc is a hydrated magnesium silicate of the theoretic composition  $4\text{SiO}_2 \cdot 3\text{MgO} \cdot \text{H}_2\text{O}$ , occurring in white, gray, green, brown, or red colors, with a hardness of 1 and a specific gravity 2.8. It is a secondary material formed from magnesium silicates. The gritty varieties contain carbonate minerals. The lime talcs are preferred for porcelains. The lime-free talcs are desired for

electric heater plates where minimum thermal expansion and resistance to heat shock are needed. These talcs are also used as fire-box lining for boilers, and will withstand a temperature of 1700°C.

Talc is often sold under trade names. Asbestine, of C. K. Williams & Co., is a talc powder of 325 mesh for use as a filler. Cera-mitalc, of the International Talc Co., Inc., is a talc powder used as a source of magnesia and to prevent crazing in ceramics. The Sierra Fibrene of Innis, Speiden & Co., is a California talc milled to 400 mesh. It is very white, has a platey structure, and as an extender in paints it wets easily and promotes pigment dispersion. French chalk is a high-grade talc in massive block form used for marking. The mineral occurs in the United States in the Appalachian region from Vermont to Georgia. The Georgia talc for making Crayons is mined in blocks, and the yield of talc suitable for sawing into crayons is about 1 ton for every 8 tons of crude talc. The crayons are made  $\frac{1}{4}$  in. diameter rounds,  $\frac{1}{4}$  in. square, and  $\frac{3}{16}$  by  $\frac{1}{2}$  in. The residue is made into ground talc. The purer grades of Steatite talc, or massive talc, are valued for making high-frequency electrical insulators. The steatite talc, or Lava talc, of British Columbia, is used for this purpose.

Agalite is a mineral having the same composition as talc but with a less soapy feel. It is used as a filler in cheap writing papers, but is more wearing on the paper rolls than talc. The talc of northern New York, known as Rensselaerite, does not have the usual talc slip, and has a fibrous nature. The hydrous aluminum silicate Pyrophyllite, found in California, is similar to talc but with the magnesium replaced by aluminum. In mixtures with talc for wall tile it eliminates crazing. It is also substituted for talc as a filler for paints and paper. The material marketed by the Attapulugus Clay Co. as Attasol is a finely powdered hydrated magnesium-aluminum silicate with the particles showing on the electron microscope as fibers. It is used in colloidal dispersions for emulsifying, and in washing powders as a frothing agent. Killas is a name given to slatey schist from the tin veins of Cornwall, which is ground to a powder and used as a substitute for talc for some industrial purposes. The ceramic known as Cordierite is formed synthetically when a mixture of talc clay and alumina is fired below 680°F and then fired at 2500°F. It is used for resistor tubes and furnace parts where low thermal expansion and high thermal endurance are needed, but the material has a porosity of

about 12% and low mechanical strength. Its composition is  $2\text{MgO} \cdot 2\text{Al}_2\text{O}_3 \cdot 5\text{SiO}_2$ .

**Tall oil.** An oily resinous liquid obtained as a by-product of the sulphite paper-pulp mills. The alkali saponifies the acids, and the resulting soap is skimmed off and treated with sulphuric acid to produce tall oil. From 70 to 90 lb of crude tall oil is obtained per ton of pulp. The name comes from the Swedish Talloel, meaning pine oil. The crude oil is brown, but the refined oil is reddish yellow and nearly odorless. It is a blend of crude pine fatty acids. It has a specific gravity of 0.97 to 0.99, flash point 350 to 370°F, and acid number 160 to 170. About 50 lb of tall oil is obtained per ton of kraft paper produced. It contains 45 to 50% fatty acids of which more than 70% is linoleic acid, 20 oleic, and 5 linolenic, with some palmitic. The rosin acids in the oil are composed mainly of abietic acid. Tall oil is used in scouring soaps, asphalt emulsions, cutting oils, insecticides, rust preventives, animal dips, in the production of factice, and in plastics. It is also used to produce a glossy drying oil for varnishes by reacting the crude tall oil with maleic anhydride and then esterifying with pentaerythritol. Lumitol is a German vinyl plastic produced by reacting tall oil with acetylene. It is used for coatings. Smithco RT, of the Archer-Daniels-Midland Co., used for varnishes and paints, is refined tall oil esterified with glycerin. Smithco PE is tall oil esterified with pentaerythritol. Sulphonated tall oil is used to replace sulphonated castor oil in coating mixes for paper to increase folding strength. Opoil is a crude tall oil of the National Southern Products Co., and Facoil is the refined oil with 60% fatty acid content and low-rosin acid content.

**Tallow.** A general name for the heavy fats obtained from all parts of the bodies of sheep and cattle. The best grades of internal fats, or Suet, are used for edible purposes, but the external fats are employed for lubricants, for mixing with waxes and vegetable fats, for soaps and candles, and for treating leather. About half of the fatty materials used in the United States for soaps are grades of tallow. The tallows consist largely of stearic, palmitic, and oleic acids. The edible grades known as Premier jus, Prime, and Edible, are white to pale yellow, almost tasteless, and free from disagreeable odor, but the nonedible or industrial tallows are yellow to brown unless

bleached. The best grade of industrial tallow is Packers No. 1. Beef tallow is a white to yellow solid containing about two-thirds Stearin and palmitin with also olein. Stearin is the glyceryl ester of stearic acid. Beef tallow is used to produce stearic acid, for leather dressing, lubricating greases, and for making soap. Mutton tallow contains less liquid fat and is harder, but it becomes rancid more easily.

**Tanning agents.** Materials, known as Tannins, used for the treatment of skins and hides to preserve the hide substance and make it resistant to decay. The tanned leather is then treated with fats or greases to make it soft and pliable. Tannins may be natural or artificial. The natural tannins are chiefly vegetable, but some mineral tanning agents are used. The vegetable tannins are divided into two color classes: the Catechol and the Pyrogallol. The catechol tannins are cutch, quebracho, hemlock, larch, gambier, oak, and willow. The pyrogallol tannins are gallnuts, sumac, myrobalans, chestnut, valonia, divi-divi, and algarobilla. Catechol tannin is distinguished by giving a greenish-black precipitate with ferric salts; the pyrogallol tannins give a bluish-black precipitate. The catechol tannins, in general, produce leathers that are more resistant to heat and decay than the pyrogallols. Some tannins contain considerable coloring or dye matter, but the color that a tannin imparts to leather may be lightened or darkened by raising or lowering the acidity of the tanning bath. In the ink industry the catechol tannins are known as iron-greening, and the pyrogallol tannins as iron-bluing, and the latter are used for making writing inks.

Alum tanning is an ancient process but was introduced into Europe only about the year 1100, and the alum- and salt-tanned leather was called Hungary leather. Formaldehyde is also used as a tanning agent. Formaldehyde was patented as a tanning agent in 1898. A later patent covered a rapid process of tanning sheepskins with alcohol and formalin and then neutralizing in a solution of soda ash. Unlike vegetable agents, formaldehyde does not add weight to the skin. It is often used as a pretanning agent to lessen the astringency of the vegetable tannin and increase its rate of diffusion. Leather may also be tanned with chromic acid or chrome salts, which make the fibers insoluble and produce a soft, strong leather. Chrome alum, sodium or potassium dichromates, or products in which

chromic acid has been used as an oxidizing agent may be used. Chrome tanning is rapid and is used chiefly for light leathers. Tanolin is a name for basic Chromium chloride marketed in crystal form for use in the chrome tanning of leather. Santotan KR is a trade name of the Monsanto Chemical Co. for basic Chromium sulphate,  $\text{Cr}_2(\text{SO}_4)_2(\text{OH})_2$ , used as a one-bath chrome-tanning agent. This material is also used for treating magnesium alloy parts to give a gray to black surface color. Panchrome, an English tanning agent, is a sulphur dioxide dichromate. Chromalin is a glycerin-reduced dichromate. Chrome-tanned leather is more resistant to heat than vegetable-tanned leathers, withstanding temperatures to 200°F. Chrome tanning is used for shoe upper leathers and for gloves, belting, and packings. Iron-tanned leather is produced by pretanning with formaldehyde, then tanning with ferric salts and trisodium phosphate, and neutralizing with a solution of phthalic anhydride and sodium carbonate. The leather is soft, will absorb much oil and grease, and is suitable for use where a pliable leather is desired.

In tanning processes various supplementary materials may be used to give special properties to the leathers. Glucose or starch may be used to make the leather more plump. Hydrochloric acid is used in two-bath chrome tanning to enhance the feel and appearance of the leather. Synthetic tannins, or Syntans, are largely condensation products made by condensing sulphonic acid with formaldehyde. Neradol D is such a syntan. Tansyn is the trade name of an English syntan of this kind. Permanol, of the Monsanto Chemical Co., is a sulphonic acid condensation syntan in liquid form used to produce light-fast white leathers. The free sulphuric acid is completely neutralized. Syntans do not add weight to leather and are seldom used alone. They are marketed under trade names. Leukanol, of the Rohm & Haas Co., has a bleaching action and is used in combination with vegetable tannins to speed up the tanning and to give a light-colored leather. The German Tanigan is a complex sulphonated condensation product produced from waste pulp-mill liquor and formaldehyde or diphenyl methane.

**Tantalum.** A white, lustrous metal resembling platinum. It is one of the most acid-resistant of the metals and is classed as a noble metal. The specific gravity is 16.6, or about twice that of steel, and



the melting point is very high, 2850°C. It is very ductile and can be rolled down from 0.300 to 0.0015 in. without annealing, or drawn into extremely fine wire. Because of its high melting point the metal is not melted, but the powder obtained by chemical extraction or electrolysis is pressed into billets, sintered in vacuum, and then rolled. The metal is used especially for chemical equipment. The tensile strength of the sheet metal is 50,000 psi, and of the drawn wire 130,000 psi. The annealed metal has a hardness of 75 Brinell. It is resistant to all acids except hydrofluoric, and is not dissolved by aqua regia. It will dissolve, however, in a mixture of nitric and hydrofluoric acids, and also reacts with chlorine above 175°C. When heated in the air to about 400°C, it becomes blue; at a higher temperature, it becomes black. At very high temperatures it absorbs oxygen, hydrogen, or nitrogen, and becomes very brittle. It will absorb 740 times its own volume of hydrogen, producing a coarse, brittle substance. Tantalum can be tempered or hardened to about 600 Brinell by heating in the air to absorb gases, and will hold a fine cutting edge on tools. It can also be hardened by the addition of silicon to a hardness close to that of the diamond, but any alloying is difficult because of the high melting point.

Tantalum is used as a filament in electric-light bulbs. The metal becomes incandescent at 1700°C, or 400° below that of tungsten, so that a tantalum lamp is cooler. It is also used in radio tubes operating at high temperatures, and in vacuum tubes to absorb gases. It is lower in cost than platinum, and is used for surgical instruments and gauze, pens, instruments, and acid-resistant chemical equipment. It is also used in alloy special steels to give increased resistance to scaling at high temperatures. Tantalum coils are used to heat acid baths. A tube with a wall thickness of 0.020 in. will withstand operating steam pressure up to 150 psi. The metal has the property of passing an alternating electric current in one direction only, and is thus used for current rectifiers. As an anode, tantalum reacts instantly with oxygen in acid solutions, forming a stable oxide film which is current blocking; this property is used in rectifiers and electrolytic condensers.

**Tantalum carbide.** An extremely hard, heavy, brownish, crystalline material of high melting point, 3875°C, used for the same purposes

as tungsten carbide, as an abrasive and cutting material. It has the composition  $TaC$ , and in hardness it ranks close to the diamond. For use in cutting tools the carbide is ground to 325 mesh, mixed with a binder of powdered cobalt, iron, or nickel, molded to shape, and sintered at high heat. Ramet is the trade name of the Fansteel Metallurgical Corp. for tantalum-carbide cutting materials, and Tantaloy is a name for a sintered alloy in bar form for flowing on faces of tools with a welding torch. Vascoloy-Ramet is a name given by the Vascoloy-Ramet Corp. to tantalum-carbide cutting and wear-resistant materials in various grades. They have a hardness range from Rockwell A 88.4 to 92.5. Tantung G, of the same company, is a non-ferrous cutting alloy containing tantalum carbide. It is not as brittle as the cemented carbides and can be operated at higher cutting speeds than high-speed steel or ordinary nonferrous cutting alloys.

**Tantalum ores.** The most important ore of the metal tantalum is Tantalite. When pure, its composition is  $FeO \cdot Ta_2O_5$ , but the American ore may contain only from 10 to 40% Tantallic oxide,  $Ta_2O_5$ , and the Australian ore may contain as high as 70%. The ore is marketed on the basis of 60% tantallic oxide content. Tantalite occurs usually as a black crystalline mineral with a specific gravity up to 7.3. It often contains manganese, tin, titanium, and sometimes tungsten; the tantalum may be replaced by columbium, which is similar to it. When the columbium content in the ore predominates, the mineral is called Columbite. Tantalite also contains small amounts of germanium. The tantalite of the Belgian Congo usually contains tin. The ore from the Lukushi Basin contains 58%  $Ta_2O_5$ , 16.5  $Cb_2O_5$ , 12.5  $MnO$ , 4.5  $Fe_2O_3$ , and 1.6  $SnO_2$ , with some zirconium and titanium oxides. Thoreaulite of that region contains 72 to 74%  $Ta_2O_5$  and 20 to 22%  $SnO_2$ . Tantalum metal is produced from tantalite by dissolving in acid and separating the tantalum salts from the columbium by precipitation. The tantalum salts are reduced to powdered metal, which is then compressed into rods and sintered and rolled. One pound of tantalum is produced from about  $2\frac{1}{2}$  tons of American ore. Australia is the most important source of tantalite.

A tantalum ore that is abundant at Wodgina, Western Australia, is Manganotantalite which contains about 69% tantallic oxide, 15 Columbium pentoxide,  $Cb_2O_5$ , and 14 manganese protoxide, with a

little tin oxide. The specific gravity of the ore is 6.34. Microlite, an ore found at Wodgina and in the McPhee Range of Western Australia, contains 76%  $Ta_2O_5$  and 4 to 7  $Cb_2O_5$ . Tanteuxenite, another Western Australian ore, contains 24 to 47%  $Ta_2O_5$  and 4 to 14  $Cb_2O_5$ . Tapiolite, from Western Australia, contains 82%  $Ta_2O_5$ , and 2  $Cb_2O_5$ .

**Tar.** A black solid mass obtained in the destructive distillation of coal, peat, wood, petroleum, or other organic material. When coal is heated to redness in an enclosed oven, it yields volatile products and the residue coke. Upon cooling the volatile matter, tar and water are deposited, leaving the coal gases free. Various types of coal yield tars of different qualities and quantities. Anthracite gives little tar, and cannel coal yields large quantities of low-gravity tar. In the manufacture of gas the tar produced from bituminous coal is a viscous black liquid containing 20 to 30% free carbon, and is rich in benzene, toluene, naphthalene, and other aromatic compounds. In the dry state this tar has a specific gravity of about 1.20. Tar is also produced from coke ovens and as a by-product of blast furnaces using coal as a fuel.

Coal tars are usually distilled to obtain the aromatic substances, and the residue tar, known as Treated tar, or Pitch, is used for making roofing, for road making, and for bituminous paints and waterproofing compounds. Coal-tar pitch is the most stable bituminous material for covering underground pipes. The Fiber pipe used as conduits in chemical plants is molded of vegetable fibers impregnated with coal-tar pitch. Pitch-On metal, of the Cheney Co., is a very soft 26- and 24-gage sheet steel hot-dipped with coal-tar pitch so that the coating is firmly embedded into the pores. It is used to replace galvanized iron and copper for roofing and flashings. Crysolite paint, of the Semet-Solvay Co., is a corrosion-resistant and acid-resistant paint with a base of refined coke-oven pitch, which is mixed with vegetable drying oils. The color is black. It is used for painting tanks, smokestacks, and structural steel. Tarvia is the trade name of a refined coal tar, marketed by the Barrett Co. in various grades. Tarmac is practically the same material marketed by the Koppers Co. Bituplastic, of this company, used for coating pipes and structures, is a refined coal-tar pitch that is odorless and quick drying.

Bituvia is a road tar, produced in various grades by the Reilly Tar & Chemical Corp. Coal-tar carbon amounts to about 32% of the original tar. It is marketed in lump form for chemical use. The fixed carbon content is 92.5 to 95.6%, sulphur about 0.30, and volatile matter 3 to 6. Calcined carbon, of the Reilly Tar & Chemical Corp., contains less than 0.5% sulphur and 0.5 volatile matter.

The lightest distillate of coal tar, benzol, is used as an automotive fuel. Coal-tar oils are used as solvents and plasticizers. They consist of various distillates or fractions up to semisolids. Tar oil from brown coal tars was used for diesel fuel oil by extracting the phenols with methyl alcohol. Bardol B, of the Barrett Div., Allied Chemical & Dye Corp., is a clear yellow coal-tar fraction of specific gravity 1.0 to 1.04, used as a plasticizer for synthetic rubber, while Carbonex is a solid black tar hydrocarbon in flake form used as a rubber plasticizer. The softening point is between 205 and 220°F. Xylol is a water-white liquid of specific gravity 0.860 to 0.870, distilling between 135 and 185°C.

Naphthalene and Anthracene are among the distillates. Anthracene is a colorless crystalline product of the composition  $C_6H_4:(C_2H_2):C_6H_4$  and melting point 217°C used for the production of dyes, resins, plasticizers, tanning agents, and inhibitors. Quinoline is a liquid with a tar odor having the empirical formula  $C_6H_7N$  and boiling point 237°C used for the manufacture of antiseptics, pharmaceuticals, insecticides, vitamins, and rubber accelerators.

Pine tar is a by-product in the distillation of pine wood. It is a viscous black mass and is much used for roofing. It is also sometimes called pitch, but pitch is the tar with the pine-tar oil removed and known as Pine pitch. Navy pitch and Ship pitch are names that refer to specification pine pitch of the Navy. The Navy grade is medium hard to solid, of a specific gravity of 1.08 to 1.10, melting point not less than 148°F, completely soluble in benzol, and of a uniform black color, or red brown in thin layers. Wood tar from the destructive distillation of other woods is a dark-brown viscous liquid used as a preservative, deriving this property from its content of creosote. Stockholm tar, a name now out of commercial use, was a term employed in shipbuilding for the tar obtained from the crude distillation of pine stumps and roots.

**Taylor process wire.** Very fine wire made by the process of drawing in a glass tube. The process is used chiefly for obtaining fine wire from a material lacking ductility, such as antimony, or extremely fine wire from a ductile metal. The procedure is to melt the metal or alloy into a glass or quartz tube, and then draw down this tube with its contained material. Wire as fine as 0.00004 in. in diameter is made, but only in short lengths. It is used for electrical instrument and laboratory work.

**Tea.** The dried leaves of the shrubs *Camellia sinensis* and *Thea sinensis*, grown chiefly in southern Asia, Japan, Ceylon, Russian Transcaucasia, and the East Indies but also in Peru and in East Africa. The plant requires a warm subtropical humid climate. Tea leaves are valued for making the beverage tea which contains the alkaloid caffeine and is stimulating. The leaves contain more caffeine than coffee berries but the flavor is different. Like coffee, also, it contains tannin, which dissolves out when the leaves are steeped too long, and is an astringent. In well-prepared tea the tannins have been oxidized to the brown and red tannin which is not easily soluble and does not enter the properly steeped beverage to any great extent although it gives the color to the beverage. The flavor and aroma of tea depend largely upon the age of the leaves when picked and the method of drying. Green tea is made by drying the fresh leaves in the sun or artificially, while Black tea is made by first fermenting the leaves and then drying. Rolling is done to break the leaves and release the juices. In Great Britain green tea is preferred, while the consumption in the United States is mostly black tea. The Oolong tea of Formosa is partly fermented and is intermediate between green and black. Pouchong tea is graded by mixing oolong with aromatic flowers such as jasmine. Tea is also graded by the size and age of the leaf. Flowery orange pekoe is the smallest leaf, orange pekoe the second, then pekoe, pekoe souchong, and souchong. Tea also varies with varieties grown in different climates so that Japan tea, China tea, and Ceylon will have different flavors.

Commercial tea is usually a blend of different varieties to give uniformity under one trade name. The blending of tea is considered an art. Brick tea, made in China for the Russian trade, is produced from coarse leaves and twigs which have been fermented. They are mixed

with tea dust, treated with rice water, and pressed into bricks 11 by 14 in. Cake tea, or Puerh tea, is produced in Yunnan. The leaves are panned, sundried, and steamed, and then pressed into circular cakes about 8 in. in diameter. Tablet tea is selected tea dust pressed into small tablets. Tea waste is the final dust from the tea siftings, and is used for the production of caffeine. Teaseed oil, or Sasanqua oil, is from the seeds of another species of the tea plant, *Thea sasanqua*, of Asia. The seeds contain 58% of a pale-yellow oil with a specific gravity of 0.916 used for lubrication, hair oil, soap, and pharmaceutical preparations. Paraguayan tea, or Yerba maté, used in immense quantities as a beverage in Argentina, Paraguay, Brazil, and some other South American countries, consists of the dried smoked leaves of the small evergreen tree *Ilex paraguayensis*, native to Paraguay and southern Brazil. It was an ancient beverage of the Indians, and cultivation began on a large scale under the early missionaries. It contains a higher percentage of caffeine than tea or coffee, 3.88%, and is also used as a source of caffeine. It has less tannin than tea or coffee. The flavor of the steeped beverage is different from that of China tea and is preferred by many. In the Brazilian state of Paraná near the coffee-growing district, it is preferred to coffee and the annual consumption is 40 lb per inhabitant. There are many varieties. The center of the growing region is about the Upper Paraná River.

**Teak.** The wood of the tree *Tectona grandis*, of southern Asia. It resembles oak in appearance, is strong and firm, and in England is called Indian oak. It contains an oil that gives it a pleasant odor and makes it immune to the attacks of insects. It is used for boxes, chests, and for decking and interior woodwork on ships. The color is golden yellow, the grain is coarse and open, and the surface is greasy to the touch. It is one of the most durable of woods, and also has small shrinkage. The weight is 40 lb per cu ft. In Burma large plantations grow teak for export. Trees grow to a height of 100 ft with a diameter of 3 ft. The growth is slow, a 2-ft tree averaging 150 years of age. The wood marketed as African teak, known also as Iroko, is from the tree *Chlorophora excelsa*, of West Africa, and is unlike true teak. It is a firm, strong wood with a brownish color and a coarse, open grain. The weight is somewhat less than teak, and it

is harder to work, but it is resistant to decay and to termite attack, and is used in ship construction. Surinam teak is the wood of the tree *Hymenea courbaril* of the Guianas and the West Indies. It is also called West Indian locust. The wood is dark brown in color, hard, heavy, and difficult to work. It is not very similar to teak and not as durable. Seacoast teak, or Bua bua, is a hard, yellow, durable wood from species of the tree *Guetarda* of Malaya. Australian teak, from New South Wales, is from the tree *Flindersia australis*. It is yellowish red in color, close-grained, and hard with an oily feel resembling teak, but more difficult to work. In wood, of Burma, also called Eng teak, is from the In tree, *Dipterocarpus tuberculatus*, from which gurjun balsam is obtained. The wood is reddish brown; it is not as durable as teak. Two woods of Brazil are used for the same purposes as teak: the Itaúba, *Silvia itauba*, a tree growing to a height of about 75 ft in the upland forests of the lower Amazon, and Itaúba preta, *Oreodaphne hookeriana*, a larger tree growing over a wider area. The first is a greenish-yellow wood with compact texture and rough fiber, formerly prized for shipbuilding. The second resembles teak more closely, and is used for cabinetwork.

**Tear gases.** An important group of lachrymatory poisons used in chemical warfare and for police work. They have a powerful irritating effect on the eyes, causing temporary blindness and swelling of the eyes. They cause a copious flow of tears. Some of the gases also have a sour, irritating odor and are also classed as Harassing agents. Some of the gases are also irritating to the throat. Most of the gases, except acrolein, are poisonous in any considerable quantity, having after effects, and some, like chloropicrin, are highly toxic. Acrolein, one of the original tear gases, is Acrylic aldehyde,  $\text{CH}_2\text{:CH}\cdot\text{CHO}$ , made by heating glycerin with a dehydrating agent, but now produced by cracking the diallyl ether by-product in the manufacture of allyl alcohol from petroleum, or by direct oxidation of propylene. It is a colorless volatile liquid of specific gravity 0.8389, boiling at  $52.7^\circ\text{C}$ . It polymerizes easily, and is used for making plastics, especially aldehyde-type resins, and for the production of many chemicals. The gas is irritating to the eyes and nose, and the unpleasant effect of scorching fat is due to the acrolein

formed. Bromoacetone is a colorless liquid of the composition  $\text{CH}_2\text{BrCOCH}_3$ , with a specific gravity of 1.631 and boiling point  $126^\circ\text{C}$ . It is thrown in bombs or shells and disseminated as a mist. Bromoacetone attacks the eyes, causing a copious flow of tears. Bromobenzyl cyanide is a solid of the composition  $\text{BrC}_6\text{H}_4\text{CH}_2\text{CN}$ , with a melting point of  $25^\circ\text{C}$ ; when impure it is a liquid, but it is not purified, as it is easily decomposed. It is very persistent and has a sour, irritating odor, being classed as a harassing agent. It was called Camite by the French. Another tear gas, Chloroacetophenone,  $\text{C}_6\text{H}_5\text{COCH}_2\text{Cl}$ , is a white, crystalline solid, specific gravity 1.321, and melting point  $59^\circ\text{C}$ , which, when thrown as a vapor, has a sweet, locustlike odor but produces pains in the eyes and temporary blindness. Other tear gases include chloropicrin, benzyl chloride, benzyl bromide, cyanogen chloride, martonite, xylyl bromide. The French gas Fraissite is Benzyl iodide,  $\text{C}_6\text{H}_5\text{CH}_2\text{I}$ , a liquid boiling at  $226^\circ\text{C}$ . The gas Papite is acrolein with stannic chloride. Caderite is benzyl bromide with stannic chloride. Xylyl bromide,  $\text{CH}_3\cdot\text{C}_6\text{H}_4\cdot\text{CH}_2\text{Br}$ , is a colorless liquid boiling at  $216^\circ\text{C}$ . When disseminated as a mist from explosive bombs, it causes a copious flow of tears.

**Tellurium.** An elementary metal, symbol Te, obtained as a steel-gray powder of 99% purity by the reduction of Tellurium oxide recovered from the residues of lead and copper refineries. It is also marketed in slabs and sticks. It occurs also with gold in Washington and Colorado as Gold telluride,  $\text{AuTe}_2$ . The specific gravity is about 6.2 and melting point  $450^\circ\text{C}$ . The chief uses are in lead to harden and toughen the metal, and in rubber as an accelerator and toughener. Less than 0.1% tellurium in lead makes the metal more resistant to corrosion and acids, and gives a finer grain structure and higher endurance limit. Tellurium-lead pipe, with less than 0.1% tellurium, has a 75% greater resistance to hydraulic pressure than plain lead. A Tellurium lead, patented in England, contains 0.05% tellurium and 6 antimony. Tellurium copper is a free-machining copper containing about 1.0% tellurium. It machines 25% easier than free-cutting brass. The tensile strength, annealed, is 30,000 psi, and the electrical conductivity is 98% that of copper. A Tellurium bronze containing 1% tellurium and 1.5 tin has a tensile strength, annealed,



of 40,000 psi, and is free-machining. Tellurium is used in small amounts in some steels to make them free-machining. It forms a sulphide in the steel which aids machinability without making the steel hot-short as do increased amounts of sulphur. As a secondary vulcanizing agent with sulphur in rubber, tellurium in very small proportions, 0.5 to 1%, increases the tensile strength and aging qualities of the rubber. It is not as strong an accelerator as selenium, but gives greater heat resistance to the rubber. Telloy is the trade name of the R. T. Vanderbilt Co. for tellurium powder ground very fine for rubber compounding.

**Terne plate.** Bessemer or open-hearth steel plate having on each side a thin coating of an alloy of 20% tin and 80 lead, although other proportions may be used. Terne is an old name meaning dull and refers to the color as compared with bright tin plate. Terne plate is made by the dip process and is used for roofing, construction work, and to replace the more expensive tin plate for uses not in contact with foodstuffs. The coating is measured by the pounds per double base box containing approximately 436 sq ft, or 112 sheets, 20 by 28 in. Long ternes are those with coatings of 8, 12, and 15 lb, not heavier than No. 14 gage or lighter than No. 30 gage. Short ternes are those with coatings of 8 lb or lighter, or in very heavy coatings from 15 to 40 lb for roofing use. The name long terne is used to designate flat sheets of the heavier weights used for manufacturing purposes. The usual roofing material is 40 lb, and the coating is 25% tin and 75 lead. Industrial terne plate usually comes in base boxes of 112 sheets, 14 by 20 in., furnished as standard, deep-drawing, and extra deep-drawing. When copper steel is specified, it has at least 0.18% copper.

Lead-coated steel is now much used instead of terne plate for building use and for stamped and formed parts. Lead alone does not adhere well to steel, but the lead dip used contains small amounts of other elements. Weirlead, of the Weirton Steel Co., is a lead-coated steel in gages 16 to 28. The lead coating contains small amounts of tin, silver, and antimony, and it will not peel when bent or deep-drawn. Amaloy, of the American Machine & Foundry Co., is a lead alloy with 1% tin, used for hot-dipping iron and steel parts. Plate-Loy, of the American Smelting & Refining Co., is a hot-dip

plate, and the coating contains 2 to 4% tin, 1 antimony, 1.5 to 2 zinc, and the balance lead. It adheres well to the steel, and the plate can be seamed and soldered.

**Terra cotta.** A general English term applied to fired, unglazed, yellow, and red clay wares; in the United States it refers particularly to the red and brown square and hexagonal tiles made from common brick clay, always containing iron. Some special terra cottas are nearly white, while for special architectural work other shades are obtained. The clays are washed, and only very fine sands are mixed with them in order to secure a fine open texture and smooth surface. Terra cotta is used for roofing and for tile floors, for hollow building blocks, and in decorative construction work. Good, well-burned terra cotta is less than  $1\frac{1}{2}$  in. thick. Terra cotta is very light, 120 lb per cu ft, and will withstand fire and frost.

**Tetrachlorethane.** A colorless liquid of the chemical formula  $\text{CHCl}_2 \cdot \text{CHCl}_2$ , employed as a solvent for organic compounds such as oils, resins, and tarry substances. It is an excellent solvent for sulphur, phosphorus, iodine, and various other elements. It is used as a paint remover and bleacher, as an insecticide, and in the production of other chlorine compounds. It is also called Acetylene tetrachloride, and is made by the combination of chlorine with acetylene. Tetrachlorethane boils at  $144^\circ\text{C}$ , freezes at  $-36^\circ\text{C}$ , is noninflammable, and has a specific gravity of 1.601. It is narcotic and toxic, and the breathing of the vapors is injurious. Mixed with dilute alkalies, it forms explosive compounds. In the presence of moisture it is very corrosive to metals. Mixed with zinc dust and sawdust, it is employed as a smoke screen.

**Tetraethyl lead.** A liquid of the composition  $\text{Pb}(\text{C}_2\text{H}_5)_4$ , used to mix with gasoline to lower the rate of explosion to prevent knocking in the engine from the hammerlike blows of sudden explosions. It is volatile, and the fumes are poisonous. Only minute quantities, 0.5 to 1 cc per gal are dissolved in the gasoline; the latter, called Ethyl gasoline, is then always colored with dyes for identification. Ethyl fluid, for adding tetraethyl lead to gasoline, is marketed by the Ethyl Gasoline Corp. Ethyl fluid is usually added to high-test gaso-

lines. Tetraethyl lead is also used as an antioxidant to reduce the sludging of lubricating oils that are used at high temperatures.

**Thallium.** A rare metallic element, symbol Tl. The metal resembles lead, is soft and malleable, with specific gravity of 11.85, and melts at 570°F. At about 600°F it ignites and burns with a green light. It tarnishes in the air and forms an oxide coating. It is resistant to acids but is acted on by nitric and by sulphuric acids. It is a poor electric conductor. Thallium is capable of forming alloys with many other metals. It has a crystalline structure, and in white bearing alloys increases the strength and resistance to deformation. Alloys of lead and thallium, containing from 20 to 65% thallium, are corrosion-resistant and are used for depositing as a plate on parts for chemical machinery. The metal occurs in copper, pyrites and zinc ores, and the chief source is the flue dust of smelters from spalerite ores. Four rare minerals are ores of thallium: Vrbaitite,  $Tl_2S \cdot 3(AsSb)_2S_3$ , is found in Macedonia; Lorandite,  $Tl_2S \cdot 2As_2S_3$ , is found in Macedonia and in Wyoming; Hutchinsonite,  $PbS \cdot (TlAg)_2S \cdot 2As_2S_3$ , occurs in Switzerland and in Sweden; Crooksite,  $(CuTlAg)_2Se$ , is found in Sweden. The salts of thallium are highly poisonous, the sulphide being used as a rat poison. Thallium oxysulfide is used in light-sensitive cells. It is also sensitive to infrared rays, and is used for dark signaling. Thallium sulphate,  $Tl_2(SO_4)_3$ , is a crystalline powder used as an insecticide. It is more toxic than lead compounds. Thallium also gives high refraction to optical glass. Thallium bromide iodide crystals, grown synthetically, are used for infrared spectrometers.

**Thermit.** The name of a mixture of finely divided aluminum and pure iron oxide, which when ignited reacts to produce a superheated steel at a temperature of about 4600°F. The process was originally patented by the Goldschmitt Thermit Co. The reaction, which depends upon the affinity of oxygen for aluminum at high temperatures, is started with a gas torch or with an ignition powder, usually barium peroxide with other chemicals. The ignition powder will produce a temperature of about 2800°F. At this temperature the aluminum will ignite, and the reaction then increases the temperature, setting free the iron in molten form. It is used for the welding

of heavy pipes and large sections of iron or steel. Red thermit is the mixture with red oxide of iron, and Black thermit is with the black oxide. Railroad thermit is plain thermit with the addition of 17% nickel, manganese, and mild-steel punchings, used for all steel welds. Forging thermit is plain thermit with additions of manganese steel and mild steel punchings. Cast-iron thermit is plain thermit with 3% ferrosilicon and 20 mild steel punchings, used for welding cast-iron parts.

**Thermoelectric metals.** Also called Thermostatic metals, or Thermocouple metals. Metals or alloys used in thermocouples for measuring high temperatures. When two wires of different metals are joined, any application of heat to the coupled end will set up an electric current in the metallic circuit. Such a couple is connected by wires to a sensitive galvanometer. The electromotive force is proportional to the temperature at the junction; a reading of the indicator thus gives the temperature. Accuracy within a range of 2°F in temperature scanning can be obtained for high-temperature readings. Metals for thermocouples must be refractory, and must be selected to give the greatest possible electromotive force since the electric voltage generated is extremely small, about 50 millivolts. These bimetals are usually made in thicknesses from 0.008 to 0.250 in. One maker produces the metals in grades up to 650 ohms per sq mil ft. Thermoelectric metals in use are platinum, rhodium, iridium, nickel, iron, copper. Usually they are special alloys of these metals such as Chromel, Nichrome, and Alumel. A copper-constantan couple is used for temperatures up to 800°F, and iron-constantan or nickel-constantan up to 1650°F, a Chromel-Alumel up to 2200°F, and a platinum-platinum rhodium up to 2600°F.

Thermometals, used for indicating temperatures from about -40 to 1000°F, consists of two metals or alloys with different rates of thermal expansion bonded together so that with a change of temperature the bimetal bends or deflects. In heat-control or indicating devices the deflection is measured to indicate the temperature, or the deflection is utilized for mechanical or electrical action. A wide variety of metals is used for thermometals. The requirements are corrosion resistance, heat resistance, and uniform pull proportional to the temperature change. Thermometals welded at the contact sur-

faces are sold under trade names, such as Highflex of the H. A. Wilson Co.

**Thorium.** A rare metal which, in the form of Thorium nitrate,  $\text{Th}(\text{NO}_3)_4$ , is used for incandescent gas mantles, and in the form of other compounds is used in luminous paints and in flashlight powders. The metal is not used in a pure state owing to its high melting point and the ease with which it combines with oxygen, but it can be used with uranium for the production of plutonium. The impure metal is a gray powder with a specific gravity of 11.3. It burns easily in the air with great brilliance. The melting point is placed at  $3090^\circ\text{F}$ . The chief source of thorium nitrate is in the mineral monazite found in Brazil, India, East Africa, and to some extent in the United States. Ceylon monazite usually contains about 10% thoria, or double that of Brazil. Monazite is a sand varying in color from yellow to dark brown. The thorium is separated from the cerium, yttrium, lanthanum, and other elements in the monazite by a complicated process. The rare mineral Thorite, found in Norway, is also a source of thorium. Thorite is a Thorium silicate,  $\text{ThSiO}_4$ , sometimes also containing uranium. It occurs in crystals or massive, with a resinous luster and color orange, brown, or black. The specific gravity is 4.8 to 5.2, and hardness 5 Moh.

The incandescent mantle, invented by Welsbach in 1893, used a mixture containing 98 to 99% thorium oxide and 1 to 2 cerium oxide. The thorium nitrate is converted to the oxide by ignition, with an increase of 10 times its volume. Thorium oxide, or Thoria,  $\text{ThO}_2$ , is produced from Monazite sand, the Brazilian beach sand containing up to 8% thoria. It has a high melting point,  $3000^\circ\text{C}$ , and is used for crucibles, but its use as a refractory is limited because of its cost and its sensitiveness to sudden temperature changes. Small amounts of thorium in nickel-chromium heat-resisting alloys increase the life of the alloys. Thorium-tungsten alloys are used for filaments in very-high-voltage rectifier and electronic tubes, giving more efficient emission at lower temperatures than tungsten alone.

**Thuya.** The wood of the tree *Thuya plicata*, also known as Western red cedar, Giant arbor vitae, Shinglewood, and Pacific red cedar. The tree grows in cool, humid coast regions from Alaska to northern

California, and the wood is widely used for shingles, poles, and tanks. It is light in weight, soft, and weak, with a straight coarse grain, but is durable. The sapwood is white and the heartwood reddish. The tree grows to great size, reaching to 200 ft in height and 16 ft in diameter at the age of 1,000 years. The stand is estimated at 53 billion board feet. Northern white cedar is the wood of the tree *T. occidentalis*, of northeastern United States. It is also called White cedar, Arbor vitae, Swamp cedar, or simply cedar. The wood is soft, knotty, brittle, weak, but very durable. It is used for shingles, poles, posts, and lumber for small boats. The sapwood is white and the heartwood light brown. The trees have a diameter of 1 to 3 ft, and a height of 25 to 75 ft. Thuya leaf oil, used as a fixative in perfumery, is a colorless oil with a bornyl acetate odor, distilled from the leaves.

**Tin.** A silvery-white lustrous metal with a bluish tinge. The chemical symbol is Sn. It has been employed from the earliest times. Tin is soft and very malleable. It is rolled into sheets of foil as thin as 0.0002 in. It melts at 232°C, and has a specific gravity of 7.298. It is dissolved by mineral acids. When rubbed it gives a peculiar odor; when bent it gives a peculiar cracking or crying sound. Tin pest is the breaking up of the metal into a gray powder. This action occurs below 18°C. Tin is used as a protective coating for other metals against corrosion, for tin foil, as a solder, and in bronze alloys and babbitts. Electroplated tin gives a fine white color which is corrosion-resistant. It also gives a lubricating effect on wearing surfaces, and is thus used for plating on airplane engine pistons and rings. The chief source of tin is cassiterite, but Nigerian columbite contains about 6% tin oxide. The principal tin-producing countries are the East Indies, Malay Peninsula, and Bolivia. The Standard tin of the London Metal Exchange must contain over 99.75% tin. Chempur tin is 99.997% pure. Federal specifications for Pig tin call for two grades, 98 and 99.75%. Block tin is virgin tin cast in stone molds. Even small traces of impurities have an influence on tin. Lead softens the metal; arsenic and zinc harden it. An addition of 0.3% nickel doubles the tensile strength of tin; 2% copper increases the strength 150%. Pure tin melts sharply, but small amounts of impurities broaden the melting period. Tin powder, for use in making sintered

alloys, is 99.8% pure, and is furnished in finenesses of 100, 200, and 300 mesh.

**Tin oxide.** Also called Stannic oxide. A fine white crystalline powder of the composition  $\text{SnO}_2$ , used as an opacifier in ceramic enamels, as a ceramic color, and also as an abrasive. It is made by oxidizing tin powder in a flame. The specific gravity is 6.9 and refractive index 2.04. When mixed and fired with magnesium and cobalt oxides, it gives a sky-blue color called Cerulean blue. It gives rose-red and reds with other materials. Tin oxide is permanent to light and is acid-resistant in ceramics. Protectatin is the name of a process developed by the Tin Research Institute for applying a thin, invisible film of oxide to tin or tin plate to protect against sulphur staining and to give a base for paint. It consists in dipping the tin plate in a solution of trisodium phosphate, sodium dichromate, and sodium hydroxide, with a wetting agent.

**Tin plate.** Soft-steel plate containing a thin coating of pure tin on both sides. A large proportion of the tin plate used goes into the manufacture of food containers because of its resistance to the action of vegetable acids and its nonpoisonous character. It solders easily, and also is easier to work in dies than terne plate, so that it also is preferred over terne plate for making toys and other cheap articles in spite of a higher cost. Commercial tin plate comes in boxes of 112 sheets, 14 by 20 in., and is designated by the net weight per box when below 100 lb. Heavy tin plate above 100 lb goes by number as with steel, or by letter symbols. The weight of tin is usually 1.5 to 1.7% of the total weight of the plate. Coke plates carry as little tin as is necessary to protect and brighten the plates for temporary use. The tin of the coat forms compounds of  $\text{FeSn}_2$ ,  $\text{Fe}_2\text{Sn}$ , and  $\text{FeSn}$  with the iron of the plate, and on a coke plate this compound is 0.00006 to 0.00015 in. thick. Best cokes carry more tin than do the standard cokes. Charcoal plates have heavier coats of tin designated by the letter A. The AAAAAA, or 6A, has the heaviest coating. Tin plate is made by the hot-dip process using palm oil as a flux, or by a continuous electroplating process. Taggers was originally a name for tin plate that is undersized, or below the gage of the plate in the package, but the name Taggers tin is also applied to light-gage plate. These sizes are No. 38 gage, 55 lb; No. 37, 50 lb; and No. 36

gage, 65 lb. Ductilite, of the Wheeling Steel Corp., is a tin plate that is not made by hot rolling in packs, but is cold-rolled from single hot-rolled strip steel. It is of uniform gage and does not have the thin edges of pack-rolled plate. It also has a uniform grain structure. Weirite, of the Weirton Steel Co., is cold-reduced coke tin plate. Electroplating gives coatings of any desired thickness, and an electrolytic tin plate may have a usable coat as thin as 0.00003 in., or about one-third that of the thinnest possible dipped plate. More than half of all tin plate used in the United States is now Electrolytic tin plate. Cold-rolling electrolytic tin plate after plating between high-pressure rolls that only slightly elongate the plate gives a bright and smooth finish. Black plate, used for cans in place of tin plate where the tin protection is not necessary, is not black, but is any sheet steel other than tin plate or terne plate in tin-plate sizes. It may be chemically treated to resist rust or corrosion.

**Titanium.** A metallic element, symbol Ti, occurring in a great variety of minerals. It was first discovered as an element in 1791 in a black magnetic sand at Menachin, Cornwall, England, and called Menachite, from the name of the sand, Menachinite. Its chief commercial ores are rutile and ilmenite. In rutile it occurs as an oxide. It is an abundant element, but is often considered as a rare metal, owing to the difficulty of separating it. It has a strong affinity for oxygen, hydrogen, and carbon. The pure metal has a silvery-white color and is extremely hard. It can be forged when red hot, but when heated to 600°C in oxygen it burns to titanitic oxide. At about 800°C it burns in nitrogen. Its melting point is very high, 3272°F, but it dissolves easily in molten copper. The specific gravity is 4.5. Metallic titanium, 98% pure, is marketed in lump or in small cakes for alloying. It is also used in the form of ferrotitanium for deoxidizing and denitrogenizing steel. It is a more powerful deoxidizer than silicon or manganese, but not as strong as aluminum. An alloy used in Germany under the name of Badin metal for deoxidizing steel contained 8 to 10% aluminum, 18 to 20 silicon, 4 to 6 titanium, and the balance iron. Titanium copper, used for deoxidizing nonferrous metals, is made directly from titanium metal by adding the metal to molten copper. It cannot be poured, but the congealed alloy is broken into lumps.



Titanium metal in bars, sheets, and other standard forms is now produced commercially, but is expensive for ordinary construction purposes. Its strength is as great as alloy steels, with little more than half the weight. The tensile strength of the annealed metal is 80,000 psi with elongation 25%, while that of the cold-rolled metal is 120,000 psi with elongation 7.5%. It is corrosion-resistant, and will resist the action of acids and chemicals better than most metals. It will hold its strength at temperatures up to about 800°F. Titanium-chromium alloys will age-harden and are noted for high strength. An alloy containing 5% chromium, 2 manganese, 0.25 carbon, and the balance titanium, has a tensile strength of 195,000 psi, with elongation 2%. An alloy containing 3.5% chromium with the same amounts of manganese and carbon has a tensile strength of 138,000 psi and elongation 9.5%. The Rem-Cru alloys of the Remington Arms Co. and the Crucible Steel Corp. consist of commercially pure titanium metal and also titanium-base alloys, marketed in bars, sheets, and plates for lightweight, high-strength, corrosion-resistant construction.

Titanium is used in alloy steels to increase the tensile strength, toughness, and hardness. It is a hard carbide-forming element. In chromium steels it minimizes intergranular corrosion, and prevents precipitation of chromium carbide in welding as the titanium has a greater affinity for carbon. It may also be used instead of vanadium in high-speed steels. One of the earliest titanium steels was the French Titanor metal used for tools. The metal is also used in some heat-resistant steels to prevent the combination of molybdenum with the carbon. When added to cast iron in quantities greater than 1%, it toughens the iron remarkably, but is expensive for use in iron alloys. Small quantities of titanium in cast iron close the grain and act as a graphitizer. Titanium is alloyed with copper in strong bronzes. Its salts are used in arc-lamp electrodes, as mordants in dyeing, for yellow coloring of ceramics, and for pigments. It is also used as a gas getter in radio tubes, and as a corrosion inhibitor in mercury boilers.

Titanium carbide may be mixed with tungsten carbide in some sintered carbide cutting alloys. It is extremely hard, is lighter in weight, and less costly than tungsten carbide. It is also used for making heat-resistant parts. Kentanium, of Kennametal, Inc., is a

titanium carbide in various grades with either cobalt or nickel as the binder, used for high-temperature parts. Kentanium 138 grade, with 20% cobalt, is used for parts where high strength is required and the oxidizing conditions are not too severe, 1400 to 1800°F. It has a tensile strength of 45,000 psi, compressive strength 550,000 psi, and Rockwell A hardness 90. The grade with 5% cobalt is for parts requiring high oxidation resistance. Kentanium 151A, with 20% nickel, is used for resistance to hot aluminum or molten glass at 2600°F.

**Titanium ores.** The most common titanium ores are ilmenite and rutile. Ilmenite is an iron-black mineral having a specific gravity of about 4.5, and containing about 52% Titanic oxide,  $\text{TiO}_2$ . The ore of India is sold on the basis of titanium dioxide content, and the high-grade ore averages about 60%  $\text{TiO}_2$ , 22.5 iron, and 0.4 silica. Ilmenite is a Ferrotitanate,  $\text{FeO} \cdot \text{TiO}_2$ , but much of the material called ilmenite is Arizonite,  $\text{Fe}_2\text{O}_3 \cdot 3\text{TiO}_2$ . Titanium ores are widely distributed and plentiful, but they are difficult to reduce to the metal. Ilmenite is found in northern New York, Florida, North Carolina, and in Arkansas, but the most extensive accessible resources are found in Quebec Province, Canada. The beach sands of Senegal are mixed ores, the ilmenite containing 55 to 58%  $\text{TiO}_2$ , and the Zirconiferous quartz containing 70 to 90% zirconia. The beach sands of Brazil are washed to yield a product averaging 71.6% ilmenite, 13 zircon, and 6 monazite. The Indian ilmenite also comes from beach sands. The ore of New York state averages 19%  $\text{TiO}_2$ , while the ore of Quebec averages 35%  $\text{TiO}_2$  and 40 iron.

Rutile is a titanium dioxide,  $\text{TiO}_2$ , containing theoretically 60% titanium. Its usual occurrence is crystalline or compact massive, with a specific gravity of 4.18 and 4.25 and a hardness 6 to 6.5. The color is red to black. Rutile is found in granite, gneiss, limestone, or dolomite. It is obtained from beach sand of northern Florida, and Espirito Santo, Brazil, and is also produced in Nelson County, Virginia, and in Australia and India. Rutile and also Brookite containing titanium oxide are produced in Arkansas. The best Virginia concentrates are 92.5 to 98%  $\text{TiO}_2$ , but some are 42% from rock originally showing 18.5%  $\text{TiO}_2$  in a body of feldspar. Rutile is marketed in the form of concentrates on the basis of 79 to 98.5% titanium oxide.

It is used as an opacifier in ceramic glazes and to produce tan-colored glass. It is also employed for welding rod coatings. On welding rods it aids stabilization of the arc and frees the metal of slag.

**Titanium oxide.** The white Titanium dioxide, or Titania, of the composition  $\text{TiO}_2$ , which is an important paint pigment. It is produced from ilmenite, and is higher in price than many white pigments but has great hiding power and durability. It is also substituted for zinc oxide and lithopone in the manufacture of white rubber goods, and for paper filler. The specific gravity is about 4. Mixed with blanc fixe it is also marketed under the name of Titanox. Zopaque, of the Chemical & Pigment Co., is a pure titanium oxide for rubber compounding. The Ti-Pure of E. I. du Pont de Nemours & Co., Inc., is commercially pure titanium dioxide for pigment use. Duolith, of this company, is titanated lithopone pigment containing 15% titanium dioxide, 25 zinc sulphide, and 60 barium sulphate. Titanox L, of the Titanium Pigment Corp., is a Lead titanate,  $\text{PbTiO}_3$ , used as a less costly substitute for titanium oxide. It is yellowish in color and has only 60% of the hiding power, but is very durable and is rust-resistant for steel.

Titanium oxide is a good refractory and electrical insulator. The finely ground material gives good plasticity without binders, and is molded to make resistors for electronic use. The Micro sheet of the Glenco Corp. is titanium oxide in sheets as thin as 0.003 in. for use as a substitute for mica for electrical insulation where brittleness is not important. Titania-magnesia ceramics were made in Germany in the form of extruded rods and plates and pressed parts. Titania is also grown artificially into large crystals for piezoelectric or gemstone use. It has a higher refractive index than the diamond, and is more brilliant but not so hard. The rutile form has a refractive index of 2.7, and the Anatase is 2.5.

**Tolu balsam.** A yellowish-brown semisolid gum with a pleasant aromatic odor and taste, obtained from the tree *Myroxylon balsamum*, or *Toluifera balsamum*, of Venezuela, Colombia, and Peru. It is used in medicine, chiefly in cough sirups, and also as a fixative in perfumes. Balsam of Peru, or Black balsam, is a reddish-brown viscous aromatic liquid from bark of the tall tree *M. pereirae* of El Salvador. It is used in cough medicines and skin ointments, as an extender for

vanilla, and as a fixative in perfumes. Some white-colored balsam is also obtained from the fruit of the tree. Peru balsam contains benzyl benzoate, benzyl cinnamate, and some vanillin.

**Toluol.** Also called Toluene and Methyl benzene. A liquid of the composition  $C_6H_5CH_3$ , resembling benzene but with a distinctive odor. It is obtained as a by-product from coke ovens and from coal tar. It occurs also in petroleum, with from 0.20 to 0.70% in Texas crude oil, which is not sufficient to extract. But toluol is produced from petroleum by dehydrogenation of the Methyl cyclohexane,  $C_6H_{11}CH_3$ , with heat and a catalyzer to yield toluol and free hydrogen. Industrially pure toluol from coal tar distills off between 108.6 and 112.6°C, and is a water-white liquid with a specific gravity of 0.864 to 0.874, flash point 35 to 40°F, and freezing point about -95°C. The fumes are poisonous. Toluol is used as a solvent, and is also employed for making dyestuffs, explosives, and many chemical compounds. T oil is a sulphur toluene condensation product made under a British patent and used as a plasticizer for chlorinated rubber. Notol No. 1, of the Neville Co., is a coal-tar hydrocarbon high in aromatics used as a substitute for toluol as a lacquer solvent. The specific gravity is 0.825, and a boiling point between 177 and 280°F. Tollac, of the same company, is another hydrocarbon substitute for toluol.

**Tomato seed oil.** A food oil from the seeds of the Tomato, *Lycopersicon esculentum*, the seeds being by-products of the manufacture of the tomato-canning industry. The tomato plant is a perennial herb native to Central and South America, and was grown by the Aztecs under the name of Tomatl. There are many varieties, and the fruits are true berries. The common red varieties are 2 to 3 in. in diameter and contain a large number of seeds in the pulp. The seeds yield 17% oil by cold pressing, or 33% with ether extraction. The cold-pressed oil with a single filtering is a clear liquid of 0.9206 specific gravity, with an agreeable odor and bland taste. It is used in salad oils and margarine, as a semi-drying oil in paints, and in soaps. The iodine number is 113 and saponification value 192.

**Tonka bean.** Called in northeastern Brazil Cumarú bean. The kernel of the pit of the fruit of the Sarrapia tree, *Dipteryx odorata* or

*Coumarouna odorata*, of northern South America, used for the production of Coumarin for flavoring and scenting. It has an aroma resembling vanilla. The trees often reach a height of 100 ft, and begin to bear in 3 years. The fruit is like a mahogany-colored plum, but with a fibrous pulp. The pits, or nuts, contain a single shiny black seed 1 in. or longer. The chief production is in Venezuela, Brazil, Colombia, Trinidad, and the Guianas. The tonka bean from the tree *D. oleifera* of Central America has an unpleasant odor. Before shipping, the beans are soaked in rum or alcohol to crystallize the coumarin. The ground beans are again soaked in rum, and the aromatic liquid is used to spray on cigarette tobacco. The coumarin extract is also used as a perfume or flavor in soaps, liqueurs, and confectionery. The essential oil produced from the seed is called Cumarú oil. A substitute for tonka bean is Deer's-tongue leaf, which is the long leaves of the herb *Trilisa odoratissima* growing wild on the edges of swamps from Carolina to Florida. The leaf has a strong odor of coumarin when dry, and contains coumarin. It is used in cigarette manufacture, in flavoring, and to produce synthetic vanilla.

**Tool steel.** A high-carbon steel used for making tools. It has the property of becoming extremely hard by quenching from a temperature of 1400 to 1800°F. It can then be drawn to any degree of hardness by heating at lower temperatures. The original tool steels were accidental combinations produced by uniform expert processes rather than by alloying. One of the earliest recorded tool steels was the ancient Chalybeate steel, originally referring to steel from the Chalybes in Pontus. The unqualified term tool steel does not usually include special alloy steels containing nickel, manganese, and other metals, nor high-speed steels. However, tool steels for special purposes may contain many other elements besides carbon. The possibilities of percentage combinations of vanadium, nickel, manganese, chromium, silicon, tungsten, and other elements in alloy tool steels are infinite; and as there are hundreds of trade-named steels on the market, the name Carbon tool steel is used to designate tool steel containing only carbon, and with other elements below perceptible amounts. Desegitized steels are tool steels that have been given special treatment to produce an even dispersion of free carbides, eliminating danger of a brittle central mass.

Tool steel may contain from 0.65 to 1.50% carbon, the lower-carbon grades, up to 0.90 carbon, being used for punches, hammers, chisels, and other tools requiring some degree of elasticity, and the high-carbon grades are used for dies, drills, and edge tools. Files, saws, and engraving tools may contain up to 1.60% carbon. The manganese content is 0.20 to 0.30. Razor steel was steel with 1.5% carbon, but razors are now usually made of alloy steels. Beyond 1% carbon, there is an excess of carbon and the steels become very brittle when hardened. Theoretically, the maximum point of solution of the  $\text{Fe}_3\text{C}$  in a plain carbon steel is at 0.85% carbon. When other elements are present, other carbides are formed giving greater hardness and strength above this point. The ideal maximums of phosphorus and sulphur in a tool steel are 0.025%, with silicon at 0.20 and manganese at 0.25, but in special steels the silicon and manganese are increased. Some water-hardening carbon tool steels have higher content of silicon to give wear resistance for dies, liners, and bushings. The silicon also adds fatigue resistance. Graph-Sil steel, of the Timken Steel & Tube Co., has 1.5% carbon, 0.85 to 0.95 silicon, and 0.40 max manganese.

The lower temperature ranges are used for hardening high-carbon steels and thin pieces. Some steelmakers grade carbon steels by divisions as low as 5 points of carbon. Pompton tool steel, of the Allegheny Ludlum Steel Co., has 19 grades from 0.50 to 1.45% carbon. Modern carbon tool steels for ordinary water hardening, with or without residual vanadium, develop remarkable physical properties. Ryerson VD die steel, as quenched, has a hardness of 725 Brinell, or 96 Scleroscope.

Oil-hardening tool steels usually contain about 1% manganese, but mild-alloy tool steels may contain less, with other elements. CM and CMM tap steels, of the Colonial Steel Co., are oil-hardening, keen-edge steels; CM contains 0.50% chromium, 0.60 manganese, and 1.20 carbon; CMM contains 0.50% chromium, 0.85 manganese, 0.60 molybdenum, and 1.20 carbon. These steels have high torsional strength. Small amounts of molybdenum with higher silicon give oil-hardening steels that are wear-resistant and quite nondeforming. Graph-Mo, of the Timken Steel & Tube Co., used for gages and dies, has 1.5% carbon, 0.25 to 0.30 molybdenum, 0.75 to 0.85 silicon, and 0.40 max manganese. BTR steel, of the Bethlehem Steel Co., is a

general-purpose oil-hardening die and tool steel that is nondeforming and wear-resistant. It contains 1.20% manganese, 0.50 tungsten, 0.50 chromium, 0.20 vanadium, and 0.90 carbon.

Tool steel comes regularly in round, square, and octagon bars, and in flats, but drawn shapes are also available. Tool steels require more care in forging than low-carbon machinery steels, and they are more difficult to machine. The quality of the steel is dependent upon the method of melting, rolling, and forging as well as upon the composition. The smallest possible grain size, and freedom from non-metallic inclusions, are the qualities sought. A.S.V. steel, of the Firth-Sterling Steel Co., is made by a patented winged ingot form of casting in order to eliminate any porosity in the center. Carbon-vanadium tool steels are produced in all carbon contents with about 0.20% vanadium. They have a uniform fine grain, and constitute a class of "super" carbon tool steels. Some steels for special purposes contain more vanadium. Colhead steel, of the Vanadium Alloys Steel Co., for cold-heading dies, has 0.45% vanadium and 1 carbon. Vatoool, of Henry Disston & Sons, Inc., is a vanadium steel for taps.

**Toon.** The wood of the tree *Cedrela toona* of India, Burma, Java, and Australia. It is called Moulmein cedar in England and is also known as Indian mahogany. The wood is almost indistinguishable from the Spanish cedar of tropical America. If seasoned well, the wood does not warp and is durable. It is easily worked and takes a fine polish. The weight is about 35 lb per cu ft. The color is a deep red, and the grain has a beautiful appearance. It is used for boxes, furniture, and construction.

**Tracing cloth.** A thin, fine cotton or linen fabric, of plain weave, heavily sized and glazed on one side. It is used for making tracings in ink and is quite transparent. It can also be obtained with the glaze on both sides. Tracing cloth is usually marketed in rolls of 24 yd. The sizing of ordinary tracing cloth is easily soluble in water, and will therefore not withstand wetting, but special grades are made with impervious resin coatings.

**Tragacanth gum.** An exudation of the shrub *Astragalus gummifer* of Asia Minor and Persia, used in adhesives or for mucilage, for leather dressing, for textile printing, and as an emulsifying agent. To

obtain the gum a small incision is made at the base of the shrub, from which the juice exudes and solidifies into an alteration product, not merely the dried juice. The gum derived from the first day's incision, known as Fiori, is the best quality, and is in clear fine ribbons or white flakes. The second incision produces a yellow gum known as Biondo. The third incision produces the poorest quality, a dark gum known as Sari. Rainy weather during the incision period may cause a still inferior product. Tragacanth is insoluble in alcohol but is soluble in alkalies and swells in water. The Indian gum from India and southern Asia is from various species of *Astragalus*. It is also known as Indian hog gum, or Hog tragacanth, and as Karaya gum. It is marketed as a white odorless powder or in flakes, and there are about a dozen grades shipped from India varying chiefly in color and acidity. In general, the gum is more acid than the tragacanth from the Near East and is not as soluble in water. It is used in textile finishing, in inks, adhesives, for thickening rubber latex, and in foods and cosmetics as a thickening agent. Ghatti gum, from the abundant tree, *Anogeissus latifolia* of India, is also called Indian gum. It comes in colorless to pale yellow rounded tears of vitreous fracture. It is insoluble in alcohol, but entirely soluble in water to form a viscous mucilage, and is less adhesive than acacia gums. It is used in India for textile finishing. Aqualized gum, of Glyco Products Co., Inc., is tragacanth or karaya chemically treated to give more rapid solubility.

**Trichlorethylene.** A heavy colorless liquid of pleasant odor of the composition  $\text{CHCl}:\text{CCl}_2$ , also known as Westrosol. Its boiling point is  $87^\circ\text{C}$  and specific gravity 1.471. It is insoluble in water and is unattacked by dilute acids and alkalies. It is not inflammable and is less toxic than tetrachlorethane. Trichlorethylene is a powerful solvent for fats, waxes, resins, rubber, and other organic substances, and is employed for the extraction of oils and fats, for cleaning fabrics, and for degreasing metals preparatory to plating. The freezing point is  $-88^\circ\text{C}$ , and it is also used as a refrigerant. It is also used in soaps employed in the textile industry for degreasing. Tri-Clene is a trade name of E. I. du Pont de Nemours & Co., Inc., for trichlorethylene, marketed for dry cleaning. Triad and Perm-A-Clor are trade names of the Detroit Rex Products Co. for trichlorethylene stabilized with a



basic organic stabilizer that prevents breakdown of the solvent in degreasing metals.

**Tripoli.** A name given to finely granulated, white, porous, siliceous rock, used as an abrasive and as a filler. True tripoli is an infusorial diatomaceous earth known as Tripolite, and is a variety of opal, or Opaline silica. In the abrasive industry it is called Soft silica. It is quarried in Missouri, Illinois, eastern Tennessee, and Georgia. Pennsylvania rottenstone is not tripoli, although it is often classed with it. The material marketed for oil-well drilling mud by the Corona Products, Inc., under the name of Opalite, is an amorphous silica. The Missouri tripoli ranges in color from white to reddish, and the crude rock has a porosity of 45%, and contains 30% or more of moisture. It is air-dried and then crushed and furnace-dried. Tripoli is used in massive form for the manufacture of filter stones for filtering small supplies of water. Missouri tripoli is also used for the manufacture of foundry parting. Tripoli finely ground, free from iron oxide, is used as a paint filler and in rubber. The grade of tripoli known as O. G. (once ground) is used for buffing composition, D. G. (double ground) for foundry partings, and the air-float product for metal polishes. Tripoli grains are soft, porous, and free from sharp cutting faces, and thus give a fine polishing effect. It is the most commonly used polishing agent. The word Silex, which is an old name for silica, and is also used to designate the pulverized flint from Belgium, is sometimes applied to finely ground white tripoli employed as an inert filler for paints. Much Illinois fine-grained tripoli is used for paint filler, and for this purpose should be free from iron oxide.

**Trisodium phosphate.** A white crystalline substance of the composition  $\text{Na}_3\text{PO}_4 \cdot 12\text{H}_2\text{O}$ , also known as Phosphate cleaner, used in soaps, cleaning compounds, plating, textile processing, and boiler compounds. The commercial grade is not less than 97% pure, with total alkalinity of 16 to 19% calculated as  $\text{Na}_2\text{O}$ . The anhydrous trisodium phosphate is 2.3 times as effective as the crystalline form, but requires a longer time to dissolve. Disodium phosphate is a white crystalline product of the composition  $\text{Na}_2\text{HPO}_4 \cdot 12\text{H}_2\text{O}$  used for weighting silk, boiler treatment, cheese making, and in cattle feeds. The medicinal, or USP grade, has only 7 molecules of water and has a

different crystal structure. The commercial grade is 99.4% pure, and is readily soluble in water. Sodium tetraphosphate,  $\text{Na}_6\text{P}_4\text{O}_{13}$ , contains 39.6%  $\text{Na}_2\text{O}$  and 60.4  $\text{P}_2\text{O}_5$ . It is the sodium salt of Tetraphosphoric acid, and is marketed in beads that are mildly alkaline and highly soluble in water. The specific gravity is 2.55, and melting point  $600^\circ\text{C}$ . It is used in the textile industry as a water softener and to accelerate cleansing operations. It removes lime precipitation and sludge and saves soap. Quadrafos, of the American Cyanamid Co., used to replace quebracho for reducing the viscosity of oil-well drilling mud, is sodium tetraphosphate. It makes the calcium and magnesium compounds chemically inactive. Sodium pyrophosphate,  $\text{Na}_4\text{P}_2\text{O}_7$ , is added to soap powders to increase the detergent effect and the lathering. It is also used in oil-drilling mud. The crystalline form,  $\text{Na}_4\text{P}_2\text{O}_7 \cdot 10\text{H}_2\text{O}$ , is very soluble in water and is noncaking, and is used in household cleaning compounds.

**Tulipwood.** Also called Yellow poplar, Whitewood, and Canary whitewood. The wood of the tree *Liriodendron tulipifera* of Canada and the eastern United States. The tree grows to a height of 250 ft and to diameters of more than 10 ft. It is used for furniture, veneer, millwork, toys, woodenware, boxes, crates, and pulpwood. Owing to its close texture and even coefficient of expansion it has been used for expansion blocks in humidity regulators. The wood is yellowish, soft, and durable. It weighs about 30 lb per cu ft. The lumber may be mixed with Cucumber magnolia, *Magnolia acuminata*, and Evergreen magnolia, *M. grandifolia*, but Magnolia woods are lighter in color.

**Tung oil.** A drying oil which has almost double the rapidity of linseed oil. It is used for enamels and varnishes, in brake linings, plastic compounds, and linoleum, and for making pigment for India ink. Tung oil is pressed from the seeds of the *Aleurites montana*, and *A. fordii*. The names Wood oil or China wood oil are loosely and erroneously used to designate tung oils, but true wood oil is an oleoresin from the Keruing tree of Malaya used for water-proofing and calking boats, while tung oil is never from the wood. The oil has a powerful purgative action, and the Chinese word tung means stomach. The Chinese tung oil is from the nuts of the tree *A. montana*, the China wood oil tree, and from the *A. fordii*. The latter tree

is more hardy than the *A. montana* which requires a hot climate. The American tung oil is from the nuts of the tree *A. fordii* of the Gulf states which gives an annual production of about 30 lb of oil per tree. The tree grows to a height of 25 ft, and bears for 5 years. The seeds, or nuts, contain 50 to 55% oil. This tree is also grown in South Africa and in Argentina.

The color of tung oil varies from golden yellow to dark brown according to the degree of heat used in extraction. It has a pungent odor resembling that of bacon fat. A good grade of raw tung oil should have a specific gravity between 0.943 and 0.940, a saponification value of 190, and an iodine value of 163. The oil contains about 72% Eleostearic acid, which has a very high iodine value, 274, and gives to the oil a greater drying power than is indicated by the iodine value of the oil itself. The oil has the property of drying throughout at a uniform rate instead of forming a skin as does linseed oil, but it dries flat instead of glossy like linseed oil and is inclined to produce a wrinkled surface. It is mixed with rosin, since rosin has great affinity for it, and the two together are suitable for gloss varnishes. The oil from *A. montana*, or Mu oil, has a higher percentage of eleostearic acid than that from *A. fordii*. The Japanese wood oil is from the nuts of the larger tree *A. cordata*. The oil is superior to Chinese tung oil and is seldom exported. It does not gelatinize like Chinese tung oil when heated. It is used in Japan for varnishes, waterproofing paper, and soaps. The saponification value is 193 to 195, iodine No. 149 to 159, and specific gravity 0.934 to 0.940. The kernels of the nuts yield about 40% oil. The tree is grown also in Brazil and thrives in hot climates. Candlenut oil is from the seed nuts of the *A. moluccana* of Oceania and Southern Asia. It received its name from the fact that the Polynesians used the nuts as candles to light their houses. The oil is variously known as Kukui, Kekune, and Lumbang, and as an artist's paint oil is called Walnut oil or Artist's oil. The nut resembles the walnut but has a thicker shell. The oil has a specific gravity of 0.923, iodine value 165, and is between linseed and soybean oil in properties. It is high in linoleic and linolenic acids. The variety known as soft lumbang oil, or Bagilumbang oil, from the tree *A. trisperma* of the Philippines, resembles tung oil and is high in eleostearic acid. The chief production of lumbang oil is in the Fiji Islands.

**Tungsten.** An elementary metal, symbol W, never found free in nature. Its commercial ores are wolframite, ferberite, scheelite, and hübnerite. The important sources of tungsten ores are India, Argentina, China, Australia, Europe, and the United States, half of the world's production coming from China, but the ores are very widely distributed in small quantities. The metal was produced first in metallic form in 1783, but was not used alone until developed as a filament for incandescent lamps in 1904. For this purpose the filaments were made from Tungsten paste, or Colloidal tungsten. The present chief uses of tungsten are in high-speed steels, magnet alloys, heavy metals, electric filaments, and special steels. Tungsten is a heavy white metal with specific gravity of 19.6 and melting point 6100°F. The Brinell hardness is 290. It is obtained in powder form by reduction of the oxide  $WO_3$  in a stream of hydrogen. The powder is pressed into rods, which are worked until ductile. In ordinary tungsten metal the grains are large, not over 1,500 per sq mm, but for special purposes, such as for electric contacts, tungsten is produced with as high as 80,000 per sq mm. The tensile strength of rolled sheets is as high as 500,000 psi. Wire drawn to a diameter of 0.0014 in. has a strength of 590,000 psi, the greatest tensile strength of all the metals. Sheets are available in thicknesses from 0.001 to 0.062 in. and the rod in diameters from 0.040 to 0.375 in. It is not attacked by nitric, hydrofluoric, or sulphuric acid solutions. Tungsten wire, 99.9% pure, is used for filaments and contact points. Wire used for amplifying tubes is as small as 0.00018 in., being almost invisible, and 1 lb equaling 950 miles in length. Tungsten electrodes are used for gas-shielded welding of aluminum. Iron-tungsten alloys, with up to 60% tungsten, are used for electroplating steel tools to give a surface with a hardness of 700 to 900 Vickers. Cobalt-tungsten alloy, with up to 50% tungsten, is also used for electroplating. The hardness is somewhat lower, but the plate retains its hardness at red heat.

Tungsten is usually added to iron alloys in the form of ferrotungsten, but also in the form of Tungsten powder, which is the commercially pure metal in powder form of 200 to 325 mesh, melting at about 6000°F, and being 95 to 98% pure tungsten. Tungsten salts are used for bronze powders, and also as mordants in dyeing. Ferrotungsten, used for adding tungsten to iron and steel, is one of the

oldest of the ferroalloys. It is made in the electric furnace by reduction of the oxide with iron, or by reducing tungsten ores with carbon and silicon. The standard grade contains 75 to 85% tungsten and has a melting point of 3200 to 3450°F. The minimum melting point of the iron-tungsten series is 2770°F, and because of the high melting point the alloy is not tapped, but the solid mass is taken from the cold furnace and broken into lumps.

**Tungsten carbide.** An iron-gray powder of minute cubical crystals, having the composition WC. The specific gravity is about 16 and the hardness is 9.8 to 9.9, or nearly that of the diamond. The melting point is about 5400°F, but if strongly heated it may decompose into  $W_2C$  and carbon, and the commercial carbide may be a mixture of WC and  $W_2C$ , with a hardness of about 9.5. Tungsten carbide is produced by carbonizing incandescent tungsten in a methane or hydrocarbon vapor, and other forms may be produced,  $W_2C$ ,  $W_3C$ , and  $W_3C_4$ . Another method of production is by heating tungsten powder and carbon in a furnace. Tungsten carbide is used as an abrasive, or is briquetted with cobalt or nickel binders into tools for the high-speed cutting of metal or for cutting hard materials.

The briquetted and sintered product is harder than any commercial steel and will scratch sapphire. Briquetting of tungsten carbide into usable form was first patented in Germany and produced by the Krupp Works under the name of Widia metal. It is made by diffusing powdered cobalt through the finely divided carbide under hydraulic pressure, and then sintering in an inert atmosphere at about 1500°C. The briquetted material is then ground to shape, and the pieces are brazed to tools. They will withstand cutting speeds from three to ten times those of high-speed steel, and will turn manganese steel with a hardness of 550 Brinell, but will not withstand shocks. However, they are used to replace diamonds in oil-well boring tools. Tungsten carbide sintered materials are sold under many trade names such as Camite, of the Cleveland Automatic Machine Co.; Dimondite, of the Firth-Sterling Steel Co.; Armide, of the Armstrong Bros. Tool Co.; Strauss metal, of the Allegheny Ludlum Steel Co. Perdurum and Hartmetall are European tungsten carbides. Haystellite tungsten carbide, of the Haynes Stellite Co., is in the form of welding rods, cast inserts, and crushed particles.

Wilcoloy is a tungsten-carbide material of the H. A. Wilson Co. used for telegraph relay contact points. Talide, of the Metal Carbides Corp., is a tungsten-carbide wear-resistant metal used for bushings, lathe centers, and gage surfaces. Borium, of the Stooddy Co., is used for facing oil-well drills. Borod, of the same company, is the material encased in a metallic tube used as a welding rod for facing wearing parts. Firthite, of the Firth-Sterling Steel Co., is a mixture of tungsten and other carbides for cutting tools. Firthaloy is a special grade for wire-drawing dies. The Firthite carbides contain from 3 to 20% of cobalt binder. The low cobalt is used for the hardest cutting tools, and the high cobalt for tough tools resistant to shock. Carboloy, of the Carboloy Co., Inc., is a material for cutting tools, drawing dies, and facing blocks, made in several grades of tungsten carbide, tantalum carbide, titanium carbide, or combinations. It has a compressive strength of 700,000 psi and transverse rupture strength up to 295,000 psi. Kennametal, of the McKenna Metals Co., is Tungsten-titanium carbide,  $WTiC_2$ , compressed with a binder metal and sintered. It is harder than tungsten carbide. Small amounts of titanium carbide are also added to tungsten carbide to give greater cutting efficiency in the tool material. Cutanit, of the Firth-Sterling Steel Co., is a mixed material of this kind.

**Tungsten steel.** Any steel containing tungsten as the alloying element imparting the chief characteristics to the steel. It is one of the oldest of the alloying elements in steel, the celebrated ancient Eastern sword steels having had tungsten in them. Tungsten increases the hardness of steel, gives it the property of red hardness, stabilizing the hard carbides at high temperatures. It also widens the hardening range of steel, and gives deep hardening. Very small quantities serve to produce a fine grain and raise the yield point. The tungsten forms a very hard carbide and an iron tungstite, and the strength of the steel is also increased, but it is brittle when the tungsten content is high. When large percentages of tungsten are used in steel, they must be supplemented by other carbide-forming elements. Tungsten steels, except the low-tungsten chromium-tungsten steels, are not suitable for construction, but tungsten steels are widely used for cutting tools, as the tungsten forms hard abrasion-resistant particles in high-carbon steels. Tungsten also increases the acid resistance and corrosion

resistance of steels. The alloys are difficult to forge, and cannot be readily welded when the tungsten exceeds 2%. Standard SAE tungsten steels, SAE 71360 and SAE 71660, contain 12 to 15 and 15 to 18% tungsten, respectively, with 3 to 4 chromium and 0.50 to 0.70 carbon. SAE 7260 contains 1.5 to 2% tungsten and 0.50 to 1 chromium.

When the tungsten content is high, particularly when the steel contains manganese also, the steel can be hardened by air cooling. These alloy steels have a close, uniform texture, and tools made from them will keep an edge even when hot. In annealing tungsten steels the hard stable carbide WC may be formed; to prevent this, chromium is used as an inhibitor. A low tungsten steel for taps and cutters contains 1.5 to 2% tungsten, 1 to 1.3 carbon, with a small amount of chromium and vanadium. Maxtack steel, of A. Milne & Co., for tack and nail dies, has 10% tungsten, 2 chromium, 2.5 manganese, 1 silicon, and 2.25 carbon. It is self-hardening. Steels with 2 to 3% tungsten have high wear resistance and impact resistance. They are used for cold-drawing dies, air hammers, and general tools. Graph-Tung, of the Timken Steel & Tube Co., has 2.6 to 3% tungsten, 0.50 molybdenum, 0.70 silicon, and 1.5 carbon. O. K. steel of William Jessop & Sons, used for chisels and punches, has 2% tungsten with only 0.40 carbon. It is hard but very shock resisting. A Firth-Sterling Steel Co. chisel steel, sold under the name of J-S steel, has 2.25% tungsten, 1.4 chromium, 0.50 carbon, and a trace of vanadium. It is also used for cutters, punches, and shear blades for hot and cold work. It will retain a good cutting edge. Buster steel, of the Columbia Steel Co., is a similar steel, but has less chromium with more vanadium. Wizard steel, of the Ziv Steel and Wire Co., used for pneumatic tools, riveter dies, and swaging dies, has 1% tungsten, 1 chromium, 0.35 carbon, and a small amount of molybdenum. At a hardness of 55 Rockwell it has great toughness and resistance to shock. A wear-resistant tool steel for finishing tools and gages, but not in the class of die steels, contains about 1.6% tungsten, 0.42 chromium, 0.20 vanadium, and varying amounts of carbon up to 1.25%. Chimo steel, of the Firth-Sterling Steel Co., used for pneumatic chisels, is an air-hardening, fatigue-resistant steel.

Steels with from 4 to 6% tungsten, 2 to 6 chromium, 0.40 to 1.80 manganese, and 0.40 carbon are used for dies for die casting, and give

long life in contact with the molten casting metals. Steels with as high as 10% tungsten and 3.5 chromium are used for die blocks for hot forging. High-carbon tungsten steels retain a high magnetism and give great coercive force, and are used for magnets.

**Turpentine.** Also called in the paint industry Oil of turpentine. An oil obtained by steam distillation of the oleoresin which exudes when various conifer trees are cut. Longleaf pine and slash pine are the main sources. It also includes oils obtained by distillation and solvent extraction from stumpwood and waste wood. Longleaf sapwood contains about 2% oleoresin, heartwood 7 to 10%, and stumpwood 25%. Most oleoresin is obtained from the sapwood of living trees, but it is not the sap of the tree. Heartwood resin is obtained only when the cut wood is treated with solvents. The oleoresin yields about 20% oil of turpentine and 80 rosin; both together are known as Naval stores.

Wood turpentine, called in the paint industry Spirits of turpentine, is obtained from waste wood, chips, or sawdust by steam extraction or by destructive distillation. Wood turpentine forms more than 10% of all American commercial turpentines. A percentage of pine oil and rosin is also obtained in the process. Wood turpentine has a peculiar characteristic sawmill odor, and the residue of distillation has a camphorlike odor different from gum turpentine. It differs very little in composition, however, from the true turpentine. Some wood turpentine is also produced as a by-product in the manufacture of cellulose. Sulphite turpentine is a black oil obtained as a by-product in the making of sulphite wood pulp from spruce. It collects on the surface of the liquor in the sulphur dioxide separator. It is purified with soda, and is used only for making toluol and thymol.

Turpentine varies in composition according to the species of pine from which it is obtained. It is produced chiefly in the United States, France, and Spain. The turpentine of India comes from the Chir pine, *Pinus longifolia*, of the southern slopes of the Himalayas, also valued for lumber, and the Khasia pine, *P. kbarya*. The gum of the chir pine is different from American gum, and the turpentine, unless carefully distilled, is slower drying and greasy. French and Spanish turpentine, or Bordeaux turpentine, is from the Maritime pine, *P. pinaster*, which is the chief source, and from Aleppo pine, *P. hale-*



*pensis*, and Corsican pine, *P. laricia*. In Portugal, the Stone pine, *P. pinea*, is the source. Venetian turpentine, or Venice turpentine, is from the Corsican pine or European larch. It produces a harder film than American turpentine. The pinene in European turpentine is levorotary while that in the American turpentine is dextro. Artificial Venice turpentine is made by mixing rosin with turpentine. The French maritime pine is also grown on plantations in Australia. Aleppo pine of Greece was the source of the naval stores of the ancients. European pines do not give as high a yield as American long-leaf and slash pines. American turpentine oil boils at  $154^{\circ}\text{C}$ , and the specific gravity is 0.860. It is a valuable drying oil for paints and varnishes, owing to its property of rapid absorption of oxygen from the atmosphere and transferring it to the linseed or other drying oil, leaving a tough and durable film of paint. Turpentine is also used in the manufacture of artificial camphor and rubber, and in linoleum, soap, and ink. Gum thus, used in artists' oil paints, is thickened turpentine, although Gum thus was originally made from olibanum. Turpentine is often adulterated with other oils of the pine or with petroleum products, and the various states have laws regulating its adulteration for paint use.

Terpene alcohol, or Methylol pinene,  $\text{C}_{11}\text{H}_{17}\text{OH}$ , is produced by condensing the beta pinene of gum turpentine with formaldehyde. Nopol, of the Glidden Co., is terpene alcohol. It has the chemical reactions of both a primary alcohol and pinene, and is used in making many chemicals. It is a water-insoluble liquid of specific gravity 0.963, boiling at  $235^{\circ}\text{C}$ . Piccolyte resin, of the Pennsylvania Industrial Chemical Corp., is a terpene thermoplastic varnish resin made from turpentine. The grades have melting points from 10 to  $125^{\circ}\text{C}$ . Myrcene is a polyolefin with three double bonds, which can be used as a substitute for butadiene or isoprene in the manufacture of synthetic rubbers, or can be reacted with maleic anhydride or dibasic acids to form synthetic resins. It is made by isomerizing the beta pinene of gum turpentine.

**Type metal.** Any metal used for making printing type, but the name generally refers to lead-antimony-tin alloys. The antimony has the property of expanding on cooling, and thus fills the mold and produces sharp, accurate type. The properties required in a type metal

are ability to make sharp, uniform castings, strength and hardness, fairly low melting point, narrow freezing range to facilitate rapid manufacture in type-making machines, and resistance to drossing. A common type metal is composed of 9 parts lead to 1 antimony, but many varieties of other mixtures are also used. The antimony content may be as high as 30%, 15 to 20% being frequent. A common monotype metal has 72% lead, 18 antimony, and 10 tin. Larger and softer types are made of other alloys, sometimes containing bismuth; the hardest small type contains 3 parts lead to 1 antimony. A low-melting-point, soft-type metal contains 22% bismuth, 50 lead, and 28 antimony. It will melt at about 310°F. Copper, up to 2%, is sometimes added to type metal to increase the hardness, but is not ordinarily used in metals employed in rapid-acting type machines. Since zinc causes drossing, it is avoided in all type metals. German and English practice employs fairly large amounts of bismuth. Standard linotype-machine metal for pressure casting has 79% lead, 16 antimony, and 5 tin. Monotype metal has 10 to 13% antimony and 2 to 5 tin. Stereotype metal, for sharp casting and hard wearing qualities, is given as 83.75% lead, 11.75 antimony, 4 tin, and 0.50 copper. Intertype metal has 11 to 14% antimony and 3 to 5 tin. The Brinell hardness of machine-molded type ranges from 17 to 23, and that of stereotype metal is up to 30. As constant remelting causes the separation of the tin and lead, and the loss of tin, or impoverishment of the metal, new metal must be constantly added to prevent deterioration of a standard metal into an inferior alloy.

**Ultramarine.** An important blue pigment, used in printing and paints. It is also used as a blue for whitening the yellow of paper, starch, sugar, and fabrics. Ultramarine was formerly obtained by grinding lapis lazuli, but is now made by calcining a mixture of aluminum silicate and sodium sulphide. Ultramarine blue is ground and is sold as a deep-blue crystalline powder of 325 mesh, insoluble in water. It may also come mixed with oil, and such a paste should contain 70% pigment and 30 linseed oil. It is a double silicate of sodium and aluminum  $\text{Na}_2\text{Al}_2\text{Si}_2\text{O}_8 \cdot \text{Na}_2\text{S}$ . Green ultramarine is obtained as an intermediate product. White, red, yellow, and violet ultramarines are obtained by various methods. Cheaper grades of ultramarine are adulterated with gypsum or other materials. Another

blue pigment is Egyptian blue, composed of a double silicate of calcium and copper,  $\text{CaOCuO}_4\text{SiO}_2$ . It resists the action of most chemical reagents. It was originally made by fusing sand, soda, and copper. It was employed by the Romans, and paintings 1,900 years old have retained the color. It is now made by fusing finely powdered quartz, chalk, copper oxide, and sodium carbonate, and washing with hydrochloric acid.

**Upholstery leather.** Very thin, finely finished leather used for upholstery, seats, and coverings for various articles. It consists of split hides, tanned to a soft, even texture, and usually dyed in colors. Chrome-tanned leather is softer and stronger than ordinary leather tanned with barks or quebracho. In splitting, the full hide thickness of about  $\frac{1}{4}$  in. can be split into three or four thicknesses. After splitting, the leather is retanned and "nourished" with cod oil. Hand buffs are top grains with the top of the grain snuffed off. The second split of  $\frac{3}{64}$  in. is called deep buff, and has an artificial grain put on. The third split is called No. 2 split. What remains is called a slab and is unsuited for upholstery leather. Splitting with four cuts gives buffing, machine buff, No. 1 split, No. 2 split, and slab. Upholstery leather is finished by japanning, by coating with lacquer, by dyeing with aniline, or by combinations of the last with either of the first two methods. Spanish leather, used for upholstery, is made by tanning in strong quebracho liquor which draws the grain and gives a slightly wrinkled appearance.

**Uraninite.** Also called Pitchblende. It is the chief source of the elements radium and uranium. The mineral is a combination of the oxides of uranium  $\text{UO}_2$  and  $\text{UO}_3$ , together with small amounts of lead, thorium, yttrium, cerium, nitrogen, helium, argon, and radium. The process of separation of radium is chemically complicated. The structure of uraninite is usually massive or in grains. The color is black, with pitchlike luster. The specific gravity is 9 to 9.7 and the hardness is 5.5. Uraninite is found with the ores of silver and lead in central Europe. In the United States it occurs in pegmatite veins, in the mica mines of North Carolina, and in the carnotite of Utah and Colorado. The richest ores come from the Belgian Congo and from near Great Bear Lake, Canada. About 370 tons of Great Bear Lake ore produce 1 gram of radium and 7,800 lb of uranium,

and also small amounts of polonium, ionium, silver, and radioactive lead. Numerous minor Uranium ores occur in many parts of the world. Black mud from the fjords off the coast of Norway contains up to 2 oz of uranium per long ton. Tuyamunite, found in Turkman, averages 1.3%  $U_3O_8$ , with radium, vanadium, and copper. Autunite, or Uranite, is a secondary mineral from the decomposition of pitchblende. The composition is approximately  $P_2O_5 \cdot 2UO_3 \cdot CaO \cdot 8H_2O$ . It is produced in Utah, Portugal, and South Australia. Torbernite, or Copper uranite,  $Cu(UO_2)_2P_2O_8 \cdot 12H_2O$ , is a radioactive mineral of specific gravity 3.22 to 3.6 and hardness 2 to 2.5. Sengierite is a copper-uranium mineral found in the Belgian Congo. It occurs in small green crystals.

**Uranium.** An elementary metal, symbol U. It never occurs free in nature but is found chiefly as an oxide in the minerals pitchblende and carnotite where it is associated with radium. The metal has a specific gravity of 18.68 and atomic weight 238.2. The melting point is about  $1860^{\circ}C$ . It is hard but malleable, resembling nickel in color, but related to chromium, tungsten, and molybdenum. It is soluble in mineral acids. The metal is alloyed with iron to make Ferrouanium, used to impart special properties to steel. It increases the elastic limit and the tensile strength of steels, and is also a more powerful deoxidizer than vanadium. It will denitrogenize steel and has also carbide-forming qualities. It has been used in high-speed steels in amounts of 0.05 to 5% to increase the strength and toughness, but its present value for atomic application prevents its use in alloys and ceramics. The Green salt used in atomic work is Uranium tetrafluoride,  $UF_4$ . Uranium hexafluoride,  $UF_6$ , is a gas used to separate uranium isotopes.

Metallic uranium is used as a cathode in photoelectric tubes responsive to ultraviolet radiation. Uranium compounds, especially the uranium oxides, were used for making glazes in the ceramic industry and also for paint pigments. It produces a yellowish-green fluorescent glass, and a beautiful red with yellowish tinge is produced on pottery glazes. Chemically, uranium has a number of isotopes, and its atomic weight varies from 234 to 239. Uranium 238 is the most plentiful, but Uranium 235, with 92 protons and 143 neutrons, is the isotope most desirable for atomic work. Uranium has the highest

atomic weight of all the materials occurring normally in nature, being 92 on the periodic scale. The transuranic elements Neptunium, symbol Np, and Plutonium, symbol Pu, elements 93 and 94, have been made from uranium of atomic weight 235, called U-235, by means of cyclotron  $\alpha$ -particle bombardment. They are highly unstable, and can be made to disintegrate with tremendous explosive violence. Plutonium was the material in the first atomic bombs. The transuranic elements numbers 95 to 96 are named Americium and Curium. They are produced by neutron bombardment. Curium is violently radioactive.

**Uranium yellow.** Also called Yellow oxide and Sodium uranate. A sodium diuranate of the composition  $\text{Na}_2\text{U}_2\text{O}_7 \cdot 6\text{H}_2\text{O}$ , obtained by reduction and treatment of the mineral pitchblende. It is used for yellow and greenish glazing enamels and for imparting an opalescent yellow to glass, which is green in reflected light. Uranium oxide is an olive-green powder of the composition  $\text{U}_3\text{O}_8$ , used as a pigment. Uranium trioxide,  $\text{UO}_3$ , is a yellow powder also used for ceramics and pigments. It is also called Uranic oxide. As a pigment in glass it produces a beautiful greenish-yellow Uranium glass; Uranous oxide,  $\text{UO}_2$ , gives glass a fine black. Sodium uranate,  $\text{Na}_2\text{UO}_4$ , is a yellow to orange powder used to produce ivory to yellow shades in pottery glazes. The uranium oxide colors give luster and iridescence, but because of the application of the metal to atomic work the uses in pigments and ceramics are no longer permitted.

**Urea.** Also called Carbamide. A colorless to white crystalline powder,  $\text{NH}_2 \cdot \text{CO} \cdot \text{NH}_2$ , made by combining ammonia and carbon dioxide under high pressure and temperature. It is the chief nitrogen constituent of urine, and was the first organic chemical ever synthesized. Its chief use is in the production of plastics, but it is also used in fertilizer mixtures, in cattle feeds, and for the chemical seasoning of lumber. The specific gravity is 1.323, melting point  $132^\circ\text{C}$ , and it is soluble in water and in alcohol. Thiourea, also called Thiocarbamide, Sulphourea, and Sulphocarbamide,  $\text{NH}_2 \cdot \text{CS} \cdot \text{NH}_2$ , is a white crystalline material of bitter taste, soluble in water, and having a specific gravity of 1.405. Solutions of thiourea are neutral and are mildly reducing. It is used in the manufacture of plastics, in the

textile and glass industries, and in medicine. For plastics manufacture, substitution on the sulphur atom in thiourea is easier than on the oxygen in urea. Thiourea changes on prolonged heating below its melting point,  $182^{\circ}\text{C}$ , to Ammonium thiocyanate, or Ammonium sulphocyanide, a white, crystalline, water-soluble powder of the composition  $\text{NH}_4\text{SCN}$ , melting at  $150^{\circ}\text{C}$ . This material is used in making plastics, as a mordant in dyeing textiles, to increase strength in weighted silks, to produce Black nickel coatings, and as a weed killer. Related to these materials also is Urethane, a white powder of the composition  $\text{NH}_2\text{COOC}_2\text{H}_5$ , used in the production of Polyurethane plastics. During the war the Germans used polyurethane for textile fibers under the name of Igamide. The fiber has good strength. Urethane oils for paints have good pigment binding qualities, and they dry quickly to a hard, resistant film.

**Urea-formaldehyde resins.** Synthetic resins used for plastic molding and for adhesives and lacquers, which belong to the group known as Amino-aldehyde resins made by the interaction of an aldehyde and an amine. The urea resins are made by the condensation of urea or thiourea with formaldehyde. An initial condensation product is obtained which is soluble in water, and is valuable for coatings and adhesives. The final condensation product is insoluble in water, alcohol, oils, or in weak acids or alkalis, and will withstand temperatures higher than the phenol plastics. Molding is done at a pressure of 2,000 psi and a temperature of  $300^{\circ}\text{F}$ , in the same manner as for other synthetic resins. The urea resins are also noted for their transparency and ability to take translucent colors. The use of thiourea improves the water resistance of the molded products. The refractive index is about the same as that of quartz. It transmits ultraviolet light, but, like quartz, is doubly refractive and is not suitable for lenses. The specific gravity of the resin is 1.44, and hardness about 3 Moh. The resins are also noted for their good adhesion, and they are used as adhesives for plywood. Small amounts of urea-formaldehyde resins are used in sizing paper to give it wet strength. Uformite 449, of the Resinous Products & Chemical Co., is a 50% water solution of urea-formaldehyde used for paper sizing. Uformite 412-A is a urea resin for laminating plywood. Uformite 580 is a urea resin in powder form for adding to foundry ore mixtures to give strength.

to the core. Urac 185, of the American Cyanamid Co., is a urea-formaldehyde resin used for bonding plywood.

Cascamite, of the Casein Co. of America, is a dry, powdered, water-soluble urea-formaldehyde resin used for making adhesives. The molding powders marketed under the name of Beetle by the American Cyanamid Co. are made from thiourea and formaldehyde. The specific gravity of the molded material is 1.49, tensile strength 5,000 to 7,000 psi, and compressive strength up to 26,000 psi. Other urea plastics are Aldur, of the Aldur Corp.; Unite, of the Unite Corp.; Plaskon, of the Plaskon Co., Inc.; Coltrock, of the Colt's Patent Fire Arms Co. Carboloid and Marboloid are Japanese urea plastics. Kaurit is a German adhesive resin made by reacting urea with 30% formalin.

**Vanadium.** An elementary metal, symbol V, found widely distributed, but in commercial quantities in only a few places, chiefly Peru, Rhodesia, Southwest Africa, and the United States. The common ores of vanadium are carnotite, patronite, roscoelite, and vanadinite. Much of the commercial vanadium comes from Peruvian patronite and shales. Some Russian vanadium comes from the mineral Tyuyamunite, a vanadate of lime and uranium, mined in Turkmen. Colorado and Utah vanadium comes from carnotite, and the Arizona ore is vanadinite. The metal is also recovered from phosphate rock in Idaho by dissolving the rock in sulphuric acid and then precipitating with nitric acid to vanadium pentoxide powder for use in making alloy steels. Vanadium is a pale-gray metal with a silvery luster. Its specific gravity is 6.02, and it melts at 3236°F. It does not oxidize in the air and is not attacked by hydrochloric or dilute sulphuric acid. It dissolves with a blue color in solutions of nitric acid. It is marketed usually in crystalline lumps in grades from 80 to 95% pure. The metal is expensive, but is available in bars and sheets of 99.8% purity for use in making springs and small parts requiring flexural rigidity and high corrosion resistance.

Vanadium is used to toughen and strengthen tool steels. It forms hard carbides which are retained at high temperatures. When chromium is present, it forms double carbides, giving hard keen-edge quality to the steel. It also refines the grain, reduces grain growth, widens the hardening range, and increases the fatigue re-

sistance and shock resistance of the steel. It is a powerful deoxidizer, but is too expensive for this purpose alone. It is used largely in special alloy steels, being added in the form of ferrovanadium. Ferrovanadium is made by reducing ferrous vanadate, calcium vanadate, or the oxides in the electric furnace. The standard grade contains 30 to 40% vanadium, with 3 to 6 carbon and 8 to 15 silicon, and the balance iron, but the alloy is also marketed with carbon not over 0.20% and silicon not over 1.5%. Vanadium metal of 99.8% purity is marketed in bars, sheet, and foil for special purposes. It machines easily, and can be subjected to severe cold working without annealing.

Vanadium salts are used to color pottery and glass and as mordants in dyeing. Red cake, or crystalline Vanadium oxide, is a reddish-brown material, containing about 85% Vanadium pentoxide,  $V_2O_5$ , and 9%  $Na_2O$ , used as a catalyst and for making vanadium compounds. Vanadium oxide is also used to produce yellow glass; the pigment known as Vanadium-tin yellow is a mixture of vanadium pentoxide and tin oxide.

**Vanadium steel.** Vanadium was originally used in steel as a cleanser, but is now employed in small amounts, 0.15 to 0.25%, especially with a small quantity of chromium, as an alloying element to make strong, tough, and hard steels. It increases the tensile strength without lowering the ductility, reduces grain growth, and increases the fatigue-resisting qualities of steels. About half of all vanadium is used in high-speed steels. Steels with 0.45 to 0.55% carbon and small amounts of vanadium are used for locomotive forgings, and cast steels for aircraft parts usually contain vanadium. In tool steels vanadium widens the hardening range, and by the formation of double carbides with chromium makes hard and keen-edge die and cutter steels. Vasco vanadium steel, of the Vanadium-Alloys Steel Co., contains 0.20% vanadium with 0.80 chromium in the various carbon grades from 0.50 to 1%. The higher carbon steels, for gages and rollers, have somewhat more chromium. All of these steels are classed as chromium-vanadium steel. The carbon-vanadium steels for forgings and castings, without chromium, have slightly higher manganese. Plain carbon-vanadium steel is regularly marketed in all standard carbon grades. It is finer grained, tougher, and keener



edged than plain carbon steel. Colonial No. 7, Red star, and Elvandi, of the Vanadium Alloys Steel Co., are steels of this type. Python steel, a shock-resistant steel of the Allegheny Ludlum Steel Co., has 0.25% vanadium, 0.90 carbon, 0.30 manganese, and 0.25 silicon. In casehardening steels the vanadium forms an integrated bonding between the case and the core which gives shock resistance to the steel.

Vanadium steels require higher quenching temperatures than ordinary steels or nickel steels. SAE 6145 steel, with 0.18% vanadium and 1 chromium, has a fine grain structure and is used for gears. It has a tensile strength of 116,000 to 292,000 psi, when heat-treated, with a Brinell hardness 248 to 566 depending on the temperature of drawing, and an elongation 26 to 7%. In cast vanadium steels it is usual to have from 0.18 to 0.25% vanadium with 0.35 to 0.45 carbon. Such castings have a tensile strength of about 80,000 psi and an elongation 22%. A nickel-vanadium cast steel, marketed by the Los Angeles Steel Casting Co. under the name of Nickeladium, has a tensile strength of 100,000 psi with elongation 20%.

**Vanilla beans.** The seed pods of a climbing plant of the orchid family of which there are more than 50 known species. It is native to Mexico, but now also grown commercially in Madagascar, Réunion, Mauritius, and Brazil. It is used for the production of the flavor Vanilla. The species grown for commercial vanilla is *Vanilla planifolia*, a tall climbing herb with yellow flowers. It grows in humid tropic climates. The flowers are pollinated by hand to produce 30 to 40 beans per plant. The green beans are cured immediately in ovens to prevent spoilage after a sweating process. During the curing the glucoside is changed by enzyme action into Vanillin which crystallizes on the surface and possesses the characteristic odor and flavor. The pods turn dark brown. The cured beans are put up in small packs in tin containers. The species *V. pompana* is more widely distributed, but is not as fragrant. The vanilla grown in Tahiti has an odor of heliotrope which must be removed. At least 15 species of vanilla grow in the Amazon and Orinoco valleys. Vanilla was used by the Aztecs for flavoring chocolate. It is now used for the same purpose, and as a flavor for ice cream, puddings, cakes, and other foodstuffs. Vanillin is also produced synthetically from eugenol

derived from clove oil. It is also made from Coniferin,  $C_{16}H_{22}O_8 \cdot 2H_2O$ , a white crystalline material of melting point  $185^\circ C$  obtained from the sapwood of the northern pine. It is produced in Wisconsin from waste liquors from pulpmaking by hydrating into sugar and another crystalline substance which is oxidized to vanillin. Ethyl vanillate,  $C_6H_5(OH)(OCH_3)(COOC_2H_5)$ , is made from Wisconsin sulphite liquor. It is used in cheese to prevent mold, and as a preservative in tomato and apple juice.

**Varnish.** A solution of a resin in drying oil, which when spread out in a thin film dries and hardens by evaporation of the volatile solvent, or by the oxidation of the oil, or both. A smooth, glossy coating is left on the surface. Varnishes do not contain pigments; when mixed with pigments, they become enamels. The most commonly used resin is ordinary rosin, and the most common drying oils are linseed and tung oils. Spirit varnishes are those in which a volatile liquid, such as alcohol or ether, is used as a solvent for the resin or oil. They dry by the evaporation of the solvent. Oleoresinous varnishes are those in which the resin is compounded with an oxidizable oil, such as linseed oil. The gums used in varnish, such as copal, dammar, and kauri, produce hardness and gloss to the film, and the Fossil resins, such as kauri, give greater hardness and luster to varnishes than do the natural resins. The oils, such as tung and linseed, make it elastic and durable.

Other important ingredients of varnishes are driers, such as manganese oxide, to hasten the action of the drying oil, and thinning agents, or reducers, such as turpentine, naphtha, and benzol. Hydrated lime is added to varnishes to neutralize the acid in the resin, and to clarify and harden the varnish to prevent it from becoming sticky in warm weather. Spar varnishes are those made to withstand weather conditions. Gloss oil is a solution of hardened rosin in benzine or in turpentine with sometimes a small amount of tung oil to give a tougher film. It gives a high gloss but is not durable. Long varnishes are those containing 20 to 100 gal of oil to 100 lb of resin; a Short varnish is one with less oil. The short varnishes are hard, more glossy, but not as flexible or durable.

Ordinarily, quick-drying varnish made with a natural resin is less durable than slow-drying; hardness and gloss are not guarantees of

good varnish. The quick-drying varnishes, made with a synthetic resin of the phenol type and tung oil, are very durable and are waterproof. Marine varnish is of this type. Opaque varnish, for signs, consists of synthetic resin varnish with graphite. Varnodag, of the Acheson Colloids Corp., is such a varnish, consisting of phenol-formaldehyde resin with colloidal graphite. Varnish is employed usually as a finish for fancy wood surfaces, but is also used as a protection against moisture on wood, paper, fiber, and other materials. Synthetic varnish of high quality is made from glycerol allyl ether.

**Vegetable fats.** When specifically used, the term refers particularly to semisolid vegetable oils that are used locally for food. Vegetable oils and fats usually contain only small quantities of the fat-soluble vitamins A, D, and E, and after refining, they are usually devoid of vitamins. Thus, they are a better food in the producing countries. Climate in which the plant is grown has an effect on the nature of the oils. Warm climates favor the development of oleic acid while colder climates favor the less palatable linolenic acid. The low-melting-point oils are more easily assimilated in the body, but when these are hydrogenated to a melting point above 45°C they become difficult to assimilate. Most of the more edible vegetable fats are tropical products. Suari fat is a hard white fat with a pleasant taste obtained from the kernels of the seeds of the *Caryocar brasiliense* and other species of tropical America. The kernels yield 60 to 70% fat of a specific gravity of 0.989, melting point 30 to 37°C, and iodine value 41 to 50. Ucuhuba tallow, used in soaps and for candles, is a fat from the seeds of the trees *Virola surinamensis* and *V. sebifera* of Brazil. Mahuba fat is a hard edible fat from the fruit of the tree *Acrodictidium mahuba* of Brazil. Gamboge butter, known locally as Gurgi and Murga, is from the seeds of the fruit of the trees *Garcinia morella*, *G. banburii*, and other species of Ceylon and India. The melting point is 34 to 37°C, specific gravity 0.90 to 0.913, and saponification value 196. It is used as a soap and food oil, and locally as an illuminant and as an ointment. From these trees also comes the gum resin Gamboge used in medicine as a cathartic, and also used as a dyestuff. It is alcohol-soluble and gives a brown color.

Sierra Leone butter, also called Kanga or Lamy, is a pale-yellow fat from the seeds of the fruit of the tree *Pentadema butyracea* of West

**Africa.** The melting point is about 40°C, specific gravity 0.857 to 0.860, and saponification value 186 to 198. It is a soap oil. *Mafura* tallow is a bitter-tasting heavy fat from the nuts of the tree *Trichilia emitica* of East Africa. It is used for soap, candles, and ointments. The specific gravity is 0.902, melting point about 40°C, and saponification value 201. Shea nut oil, also known as Shea butter, Bambuk butter, Galam butter, and by various local names as Karité, Kade, and Kedempó, is a fat obtained from the kernels of the fruit of the large tree *Bassia butyrospermum* of tropical West Africa. The kernels contain 45 to 55% fat, which when refined is white, stiffer than lard, with little odor or taste. The melting point is 33 to 42°C. It contains oleic and stearic acids and 3 to 4% lauric acid. It is used in Europe in butter substitutes, and as a substitute for cocoa butter, and also in candles. Malabar tallow, also called Dhupa fat and Pinay tallow, used in Europe for soap and candles, and in India for food, is from the kernels of the seed of the evergreen Pinne tree *Vateria indica* of south India. The tree also yields White damar or Indian copal. The seeds give about 25% of a greenish-yellow, odorless, and tasteless fat of specific gravity 0.890, melting point 40°C, and saponification value 190. The fat is extracted by grinding the roasted seed, boiling in water, and skimming off. It is bleached by exposure to the air.

Vegetable tallow, also called Bayberry tallow and Myrtle wax, used extensively in Europe for soapmaking, and in the United States for blending in candles and with waxes, is a waxy fat obtained from the outside coating of the berries of species of *Myrica* bushes of America, Europe, and Africa, by boiling the berries in water. The berries yield 15 to 25% tallow. The species *M. cerifera* and *M. carolinensis* grow in the Eastern coastal states, and the *M. mexicana* grows in Central America. The melting point of the tallow is 40 to 46°C, specific gravity 0.995, and saponification value 205 to 212. The Central American product contains about 58% myristic acid, 36 palmitic, and 1.3 oleic acid. Ocuba wax is a waxy fat, but not chemically a wax, obtained from the seeds of the fruit of the shrub *Myristica ocuba* of Brazil. The seeds yield about 20% fat with a specific gravity of 0.920 and melting point of 40°C, used in candles. The fruit nut is surrounded by a thick skin which yields a water-soluble pink dye known as Ocuba red.

Mahubarana fat is a pale-yellow solid oil of melting point 40 to

44°C obtained from the kernels of the fruit of trees of the genus *Boldoa*. The kernels contain 65% oil. It is used for soaps and candles. Mocaya butter is a fat from the kernels of the nuts of the Paraguayan palm, *Acrocomia sclerocarpa*, of tropical South America. The tree resembles a coconut palm, but the nuts grow in bunches. The pulp of the fruit contains 60% of a yellow oil similar to palm oil. The kernels yield 53 to 65% of the mocaya fat which is softer than palm kernel oil. The specific gravity is 0.865, and saponification value 240. It has the same uses as palm kernel oil.

**Vegetable oils.** An important class of oils obtained from plants, used industrially as drying oils, for lubricants, in cutting oils, for dressing leather, and for many other purposes. Many of the oils find wide usage in food products. Large tracts of land are under cultivation in all parts of the world for the production of the seeds and fruits from which the oils are obtained. Linseed, cottonseed, palm, olive, and castor beans are examples of these, and the oils are obtained by crushing. In some cases the oil-bearing material, copra or soybean, may be dehydrated before crushing, making it simpler to extract the oil, and giving a better residue meal for animal feed. The only distinction between vegetable oils and fats is a physical one, oils being fluid at ordinary temperatures. Vegetable oils can be thickened for various uses by oxidation, by blowing air through them, or they can be hydrogenated by passing hydrogen through them in the presence of a catalyst. Considerable oil is extracted from the kernels of the stones or pits of cherries, apricots, and other fruits as a by-product of the canning and drying of fruits. Cherry kernel oil is from cherry pits which contain 30 to 38% oil. The cold-pressed oil is yellow and has a pleasant flavor. It is used in salad oils and in cosmetics. The hot-pressed oil is used in soaps. The oil contains 47% oleic acid, 40 linoleic, 4 palmitic, 3 stearic, and some arachidic and myristic acids.

**Velvet.** A closely woven silk fabric with a short pile on one side formed by carrying the warp threads over wires and then cutting open the loops. Velvet is made in a great variety of qualities and weights, and may have a cotton back in the cheaper grades, or be made in wool. True velvet is all silk, but because of the number of imitations in other materials this variety is usually designated as Silk velvet. Velvet is dyed in various colors, the depth of color shown by

the pile giving it an air of richness. Its largest use is in dress goods and hangings, but it is used industrially for upholstery, fancy linings, and trim.

**Velveteen.** A variety of imitation velvet, woven of cotton. In the best grades the pile is of mercerized yarns. Velveteen is woven into two systems of filling yarns and one system of warp yarns, the pile being made with the cut filling yarns instead of the warp yarns as in velvet. It belongs to the class of Fustians which includes also Mole-skin and Corduroy. The latter is a sturdy pile fabric with heavy warp rib, dyed in the piece. It is also made in wool. The ribs run lengthwise, while Whipcord, a hard-woven worsted fabric, has fine ribs running diagonally on the face. Velveteen is used for apparel, linings for jewelry and silverware boxes, shoe uppers, artificial flowers, and covering material. It is made either plain back or twill back, the plain back having a tendency to loosen and drop the pile when subjected to abrasion.

**Vermiculite.** A foliated mineral employed in making plasters and boards for heat, cold, and sound insulation, as a filler in calking compounds, and for plastic mortars and refractory concrete. The mineral is an alteration product of biotite and other micas, and is found in Colorado, Wyoming, and Montana, and in the Transvaal. It occurs in crystalline plates, specific gravity 2.3, and hardness 1.5, measuring sometimes as much as 9 in. across and 6 in. in thickness. The color is yellowish to brown. Upon calcination at 1750°F, vermiculite expands at right angles to the cleavage into threads with a vermicular motion like a mass of small worms, hence its name. The volume increases as much as 16 times, and the color changes to a silvery or golden hue. It is ground into pellet form. Plaster made with 60% vermiculite, 30 plaster of paris, and 10 asbestos will withstand red heat without disintegrating. Therm-O-Flake brick, of the Illinois Clay Products Co., is made of granules of Exfoliated vermiculite bonded with a chemical. It is lightweight, tough, and will withstand temperatures up to 2000°F. The corklike pellets of vermiculite used for insulating fill in house walls are called Mica pellets. Zonolite, of the Zonolite Co., is an exfoliated vermiculite. A sound-absorbing building tile marketed by Johns-Manville under the name of Rock-oustile is made of exfoliated mica. An expanded vermiculite of

extremely fine mesh, under the name of Mikolite, of the Mikolite Co., is used as an extender in aluminum paint and in lubricating oils. Exfoliated mica is a name for expanded vermiculite.

**Vermilion red.** One of the oldest paint pigments. It is a brilliant red powder of the composition  $\text{HgS}$ , known chemically as Red mercury sulphide. The specific gravity is about 8.1. It is insoluble in water. Vermilion red is expensive, more than 85% of its weight being mercury, and is consequently often mixed with red lead, red ochre, or red iron oxide, or is replaced by Antimony red. It is made by heating mercury and sulphur together and grinding the product.

**Vine black.** The charred remains of partly burned vines or twigs, ground very fine and used as a pigment, especially for inks. The original vine black, or Frankfurt black, was made from grapevine twigs, but the so-called Vegetable black is made from wood pulp and is a by-product of the paper-pulp industry. The name is now also applied to the black made from fruit pits and nut shells.

**Vinyl resins.** A group of products varying from liquids to hard solids, made by the polymerization of ethylene derivatives, employed for finishes, coatings, and molding resins. In general, the term vinyl designates plastics made by polymerizing vinyl chloride, vinyl acetate, or vinylidene chloride, but may include plastics made from styrene and other chemicals. The term is generic for compounds of the basic formula  $\text{RCH:CR'CR''}$ . The simplest are the poly esters of vinyl alcohol, one of the most common being made by the reaction of vinyl chloride and vinyl acetate. Polyvinyl alcohol is a white, odorless, tasteless powder which on drying from solutions forms a colorless and tough film. It is used for adhesives, as a thickener for latex, emulsifying agent, in chewing gum, and for paper and fabric coatings. The Japanese used it for textile fibers under the name of Kuravilon. It is easily mixed with plasticizers and molded or extruded under moderate pressures and temperatures to form elastic, tough, heat-resistant products or sheets and tubing. They are also acid- and alkali-resistant. Reynolon 4000, of the Reynolds Metals Co., is a polyvinyl alcohol cast film in thickness of 0.001 in. for food packaging. It is odorless and tasteless, resistant to oils, and has a tensile strength of 8,000 psi. The polyvinyl alcohols are called

Solvares, and the polyvinyl acetates are called Gelvas. The vinyl ethers range from Vinyl methylether,  $\text{CH}_2\text{:CHOCH}_3$ , to Vinyl ethylhexylether, from soft compounds to hard resins. Vinyl ether is a liquid which polymerizes, or can be reacted with hydroxyl groups to form acetal resins. The Polyvinyl formals, Formvars, are used in molding compounds, wire coatings, and impregnating compounds. It is one of the toughest of the thermoplastics. The extrusion grade of Formvar of the Shawinigan Products Corp. produces products with high tensile strength and high abrasion resistance.

The Polyvinyl acetals, Alvars, are used in lacquers, adhesives, and phonograph records. The Polyvinyl butyrals, Butvars, are used as an interlayer in laminated glass. They are transparent and completely light-stable. Polyvinyl carbazole, under the name of Luvican, was used in Germany as a mica substitute for high-frequency insulation. It is a brown resin, softening at  $150^\circ\text{C}$ . Polyvinyl chloride is a white powder for molding or extruding. It was used by the Germans for coating fabrics to use as leather substitutes. Geon resin, of the B. F. Goodrich Chemical Co., is a polyvinyl chloride marketed as a free-flowing white powder. Dispersed in plasticizer it is used for paper and fabric coatings. Geon polyblend latex is a colloidal water dispersion of Geon and nitrile rubber. It dries to a tough, water-white, glossy film of high tear strength and good resistance to solvents. It is used for coating food-wrapping papers. Polvin is the name of polyvinyl chloride plastics of the Monsanto Chemical Co. Polyvinyl chloride plastic made by an emulsion process was used in Germany for cable insulation and coatings under the name of Igelite, and the material made by a suspension process was used for tire tubes and shoe soles under the name of Vinnol. An adhesive to replace rubber cement was made in Germany by combining Oppanol C, a high-molecular-weight polyvinyl isobutylene ether with Igovin, a low-molecular-weight polyvinyl isobutyl ether, and compounding with zinc oxide and wool grease. Marvinol VR-10, developed by the Glenn L. Martin Co., for coatings and impregnations, is produced by the reaction of acetylene and hydrogen chloride with a catalyst. It is also used for casting into films. Thermo seal, of the Artizan Engineering & Mfg. Co., is an extruded polyvinyl chloride webbing for making seating. It has a tensile strength of 3,000 psi and elongation 300%.



Vinyl acetate is a water-white mobile liquid with boiling point  $70^{\circ}\text{C}$ , usually shipped with a copper salt to prevent polymerization in transit. The composition is  $\text{CH}_3\cdot\text{COO}\cdot\text{CH}\cdot\text{CH}_2$ . It may be polymerized in benzene and marketed in solution, or in water solution for use as an extender for rubber, and for adhesives and coatings. The higher the polymerization of the resin, the higher the softening point of the resin. The formula for Polyvinyl acetate resin is given as  $(\text{CH}_2\text{:CHOOCCCH}_3)_x$ . It is a colorless, odorless thermoplastic with density of 1.189, unaffected by water, gasoline, or oils, but soluble in the lower alcohols, benzene, and chlorinated hydrocarbons. Polyvinyl acetate resins are stable to light, transparent to ultraviolet light, have high dielectric strength, and are hard and tough. They are valued for lacquers because of their high adhesion, durability, and ease of compounding with gums and resins. Saflex is the name of vinyl acetal resins of Monsanto Chemical Co.

Vynlite and Vynloid are trade names of the Carbide & Carbon Chemicals Corp. for vinyl-acetate resins. They are molded with heat and pressure like other synthetic resins, and are compounded with wood flour, asbestos, mica, and other fillers. The clear resins are light in color. Vynon, of the same company, is a polyvinyl chloride acetate fiber which is produced in various grades as fine as natural silk. It is waterproof, more elastic than natural silk, and nearly as strong. Since it is resistant to strong acids and alkalies, Vynon fiber is made into filter cloth for temperatures not above  $160^{\circ}\text{C}$ . It is also used in wool mixtures for hat felts. It is produced by the copolymerization of vinyl chloride and vinyl acetate. Vynon N is a vinyl chloride-acrylonitrile copolymer marketed as a fine, silklike textile fiber. The fiber has high strength, an elongation of 30%, and is nonflammable. It has a light yellow color and is easily dyed. Advagum, of the Advance Solvents & Chemical Corp., is a highly plasticized vinyl copolymer used as an extender in synthetic rubber. Pliovac, of the Goodyear Tire & Rubber Co., is a high-molecular-weight vinyl chloride copolymer for coatings, tiling, and extrusions. It is strong and tough, and requires little plasticizer. Victron, of the Naugatuck Chemical Co., is a vynlite resin. Mowilith is a German vynlite resin. Gelva, of the Shawinigan Products Corp., is a polyvinyl acetate resin used for lacquers. Formvar, of the Carbide & Carbon Chemicals Corp., and Formex, of the General Electric Co., are vinyl-formalde-

hyde resins used for such purposes as coating insulated wire. Butacite, of E. I. du Pont de Nemours & Co., Inc., is a polyvinyl acetal resin for laminated safety glass. It is clear and stable. Vinal is a general trade name used by the plastics industry for vinyl-butyril resins for laminated glass and other uses. Mipolam is the name of a vinyl polymer plastic used in Germany for floor coverings to replace rubber flooring. Korogel is a plasticized polyvinyl chloride for molding. Ingerin was a German polyvinyl plastic made by the polymerization of vinyl ether with a catalyst. Cosal was polymerized vinyl isobutyl ether used in adhesives and lacquers. Resistoflex is the trade name of the Resistoflex Corp. for polyvinyl alcohol plastics.

Vinylidene chloride plastics are derived from ethylene and chlorine polymerized to produce a thermoplastic with softening point of 240 to 280°F. The resins are noted for their toughness and resistance to water and chemicals. The molded resins have a specific gravity of 1.68 to 1.75, tensile strength 4,000 to 7,000 psi, and flexural strength 15,000 to 17,000 psi. Saran is the name of a Vinylidene chloride plastic of the Dow Chemical Co., extruded in the form of tubes for handling chemicals, brines, and solvents, as it is acid- and alkali-resistant and also resistant to temperatures as high as 275°F. It is also extruded into strands and woven into a box-weave material as a substitute for rattan for seating. Velon, of the Firestone Tire & Rubber Co., is this material for screens and fabrics. Saran latex, a water dispersion of the plastic, is used for coating and impregnating fabrics. For coating food-packaging papers, it is water- and grease-proof, is odorless and tasteless, and gives the papers a high gloss. Saran bristles for brushes are made by Lus-Trus Extruded Plastics, Inc., in diameters from 0.010 to 0.020 in.

**Vitamins.** Organic chemical compounds which are vital building units, coenzymes, or catalyzing agents in the growth and maintenance of animal bodies. They are produced by extraction from vegetable or animal products or made synthetically, and marketed in solid or extract form for use in foodstuffs and pharmaceuticals. Vitamin A, called Carotene because of its abundance in carrots, is an orange-yellow needle-shaped crystalline substance with a complex molecular structure having the empirical formula  $C_{40}H_{56}$ . It is soluble in fats, but poorly soluble in water. Yellow and leafy green vegetables are

rich sources of carotene-bearing pigments, and carotene accompanies the green chlorophyll coloring of all plants. The more intense the green or yellow coloring, the greater the carotene content. Cryptoxanthin, one of the four yellow carotene-carrying pigments, occurs in yellow corn, egg yolk, and green grasses. Animals convert carotene of green plants into vitamin A which is then obtained commercially from the tissues, especially from the liver. Deficiency of vitamin A in the human body causes night blindness, muscular weakness, and defective tooth structure.

Vitamin B is a complex of several vitamins, including Vitamin B<sub>1</sub> and Vitamin G. The former cannot be formed in the normal processes of the human body and must be supplied in the diet. Plants manufacture and store it in the seed. Lack of vitamin B<sub>1</sub> causes beriberi, fatigue, stiffness, headache, nervousness, and loss of appetite and, when chronic, causes enlargement of the heart, polyneuritis, and loss of coordination of the muscular movements. The crystalline vitamin B<sub>1</sub> is called Thiamin chloride, and in Europe is called Aneurin. It is water-soluble, insoluble in most fats, and is destroyed by heat in the presence of moisture. In alkaline solutions the destruction is rapid. It is essential to the health of every living cell. Greater amounts are needed when starches or carbohydrate foods are eaten in order to prevent the formation of Pyruvic acid. Riboflavin is the generally accepted name for Vitamin B<sub>2</sub>, or vitamin G. The orange-yellow needle-shaped crystals have a green fluorescence. Riboflavin, C<sub>27</sub>H<sub>20</sub>N<sub>4</sub>O<sub>6</sub>, is water-soluble. It is gradually destroyed by exposure to light, and is destroyed by many chemicals, or by high temperatures in the presence of alkalies. It is present in meats, eggs, barley malt, yeast, milk, green leafy vegetables, and grasses. Deficiency of riboflavin results in ill health, loss of hair, and dermatosis. Nicotinic acid, or Niacin, is the pellagra-preventing member of the vitamin B complex. It can be made from the nicotine of the variety of tobacco *Nicotina rustica*. Coffee contains some niacin, and meat extracts are rich in both niacin and riboflavin. Biotin, originally named Vitamin H, is also a member of the B group, and has an enzyme action on starches and sugars. It occurs widely in nature as a Phytohormone for the growth of organisms and plants. It is extracted from yeast, egg yolk, and liver by adsorbing on carbon. Vitamin B<sub>6</sub>, called Pyridoxine, is required to enable the body to

assimilate proteins. A deficiency causes nausea, muscular weakness, and anemia. Vitamin B<sub>12</sub> is a high-molecular-weight complex containing five membered nitrogen nuclei. It can replace protein and liver extract as a growth factor.

Vitamin C, C<sub>6</sub>H<sub>8</sub>O<sub>6</sub>, known also as Ascorbic acid, or Ceritamic acid, is unstable and is easily oxidized, especially in the presence of alkalies or in iron or copper vessels, so that in foods that have been long exposed to the air it loses its value. It is found in milk, fruit juices, tomato, and green vegetables. It is added to frozen or canned foods to preserve the natural color and to prevent browning of cut fruits.

Vitamin D regulates the metabolism of calcium and phosphorus in the human body. Without it the body is subject to rickets, soft bones, or ill-formed bones and teeth. It is also effective against the germ of tuberculosis. It is found in fish and fish-liver oils and in some fruits. The vitamin D concentrate of General Mills, Inc., is made by the activation of crystalline ergosterol with low-velocity electrons, in vegetable oil. Calciferol, or Vitamin D<sub>2</sub>, of the Winthrop Chemical Co., is a synthetic antirachitic marketed in crystalline form or in solution in corn oil. Its melting point is 116°C. Vitamin D is formed in the body from Cholesterol by the action of sunlight on the skin. Vitamin E is so widely distributed in foods taken by man that the effect is not well known. It is known that in certain animals deficiency causes failure of the female to give birth to living young, and that abortion is cured by it. It is found in wheat germ oil. Vitamin P is found in capsicum and in lemon peel, and is a preventive of rheumatic fever. Although proper quantities of vitamins are necessary in the human body, overdoses are often toxic and poisonous. An excess of vitamin C, for example, causes irritability, vertigo, and vomiting. An excess of vitamin D causes metastatic calcification, or deposition of calcium in the arteries and kidneys, and concentrated vitamin D is classed as a toxic drug.

**Vulcanized fiber.** A wood, paper, or other cellulose fiberboard impregnated with a gelatinizing medium. It is not vulcanized in the same sense that rubber is vulcanized. It is made by various processes, and the medium may be sulphuric acid, zinc chloride solution, or cuproammonium solution. It may also be made by impregnating the

cellulose fiber with a phenol-furfural resin dissolved in alcohol or other solvent. After dipping in the solution, the fiber is washed to remove excess alcohol, and then dipped in a zinc chloride solution which hydrolizes it, and it is then washed free of the chloride, dried, and rolled. The original vulcanized fiber, patented in 1899, and called Cellulith, was sulphite wood pulp molded into sheets or formed parts. The modern fiber in the hard grades is a tough, resilient, horn-like material in standard gray, red, and black colors. Soft flexible grades are made for washers and gaskets.

Another type of material, called Maizolith, developed by the National Bureau of Standards, is a hard, dense product made by cooking cornstalks or corncobs with caustic soda, washing out the residue, beating, and compressing. It has a tensile strength of 8,000 psi, hardness 15 to 30 Brinell, is resistant to oils, is a good insulator, and resembles vulcanized fiber.

The Hard vulcanizer fiber, produced by the Spaulding Fibre Co., Inc., is made from cotton rags softened and gelatinized in a zinc chloride solution and built up in layers. The specific gravity is from 1.1 to 1.4, the heavier thicknesses being the lightest and the softest. The shearing strength is 10,000 to 15,000 psi and compressive strength 30,000 psi. The dielectric strength is from 275 to 375 volts per mil. Sheets as thin as 0.004 in. are produced. The Diamond fiber, marketed by the Continental-Diamond Fibre Co., is made in various grades with compressive strengths up to 40,000 psi. Bone quality is a dense material with a specific gravity of 1.40, made in thicknesses from  $\frac{1}{8}$  to  $\frac{1}{2}$  in., with high machining properties. The Commercial quality is made in thicknesses from 0.004 to 2 in. The thin paper sheets are used for armature insulation. Codite is the trade name of this company for a hard, tough, vulcanized fiber tubing with dielectric strength up to 710 volts per mil. Cellulak is another tubing of the same company made of kraft paper coated with resin and laminated under heat and pressure. Flexible fiber is a grade of vulcanized fiber made to retain sufficient moisture to keep it soft. Vulcanized fibers are used for electrical insulation, gaskets, gears, rollers, handles, and for such articles as trunks, boxes, and novelties. For electrical insulation it has the disadvantage that it absorbs moisture in damp places unless impregnated with insoluble resins. The higher grades of vulcanized fibers, and those for electrical work, are all now

of the insoluble type: Victorite, of the Victor Mfg. & Gasket Co., is an impregnated Manila-rope paper, used for gaskets. Fish paper, for electrical use, may be vulcanized fiber in thicknesses from 0.005 to  $\frac{1}{16}$  in. The 0.005-in. paper will withstand 1,500 volts. Protectite, of the National Vulcanized Fibre Co., is a thin, white, vulcanized fiber sheet used for backing rubber shoe soles. Shoe fiber is sheet material in leather color used for reinforcements in shoes. It is very resilient, but can be cut with dies and nailed.

**Vulcanized oils.** Vegetable oils vulcanized with sulphur and used for compounding with rubber for rubber goods, or as a rubber substitute in erasers. Castor oil, corn oil, rapeseed oil, and soybean oil are used. Vulcanized oil is a white to brown, spongy, and odorless cake, or sticky plastic, with specific gravity of 1.04. The material was invented in France in 1847, and was known as Factice. Factice cake is solidified vulcanized oils, cut in slab form for compounding with rubber. Factice is not a mere adulterant of rubber, but may be used to give certain desirable characteristics such as softness or plasticity. It also has some elasticity. Brown factice is made by treating the oil with sulphur or sulphur chloride at 160 to 200°C. The softer grades are made with blown oils and low sulphur. The harder grades contain up to 20% sulphur. White factice is made from rapeseed oil, which is high in a characteristic acid, erucic acid, by slow addition of sulphur chloride up to 25% sulphur content. Erasing rubbers are rubber compounded with white factice or the factice alone. Black factice has mineral bitumen added to brown factice. Neophax is the trade name of the Stamford Rubber Supply Co. for brown factice, and Amberex is the name for light-tan colored factice. Factex of this company is partly vulcanized oil dispersed in water. It produces a nontacky elastic film. When mixed with rubber latex to the extent of 30%, it gives a velvety feel to the vulcanized product and does not decrease the strength greatly. Factice sheet is made from specially processed factice made by treating warm oil with sulphur and then with sulphur chloride. The strength and elasticity are higher. Mineral rubber is a name sometimes applied to vulcanized oils mixed with bitumens, especially gilsonite, but this term is also applied to petroleum asphalt when used in rubber compounding for such uses as shoe soles.

**Walnut.** A hardwood from the tree *Juglans regia*, native to Europe and Asia Minor, but now growing in many other places. The wood is firm, with a fine to coarse, open grain, and a lustrous surface. The weight is about 45 lb per cu ft. The color is dark brown to black, and it takes a beautiful polish. Walnut has great strength, toughness, and elasticity. It also has great uniformity of texture and does not split easily. It is particularly adapted for carving. Walnut is valued as a cabinet wood, for fine furniture and gunstocks. The wood from *J. regia* is called English walnut, and the beautifully figured wood from Persia is known as Circassian walnut. Black walnut, or American walnut, is from the tree *J. nigra*, of eastern United States. The color is darker, and it has a more uniform color than European walnut. It is handsomely grained and has the same general characteristics and uses as European walnut. It has a specific gravity, kiln-dried, of 0.56, a shearing strength parallel to the grain of 1,000 psi, and a compressive strength perpendicular to the grain of 1,730 psi. Butternut, from the tree *J. cinerea*, resembles closely the wood of the black walnut except for its color, which is yellowish gray. The supply of this wood is limited. East India walnut is the wood of the tree *Albizzia lebbek* of tropical Asia and Africa, used for furniture, paneling, and interior decorative work. It is hard, dense, close-grained, and has a weight of about 50 lb per cu ft. The color is dark brown with gray streaks. The logs come as large as 30 in. square and 20 ft long. The shipments may be mixed with the wood of the *A. procera*, the White siris wood of India. This wood has a brown walnut color, is lustrous, and resembles true walnut more than does the East India walnut. Mahoe, also called Blue mahoe and Majagua, is the wood of the tree *Hibiscus elatus*, of tropical America. It has been used to replace true walnut for gunstocks and in cabinetwork. The wood has a gray-blue color, an aromatic odor, and is hard with a coarse, open grain. Brazilian walnut, or Freijó, from the tree *Cordia goeldiana*, is a strong, tough, straight-grained wood used for cooperage and cabinetwork. African walnut, or Amonilla, is from the tree *Lovoa klaineana* of Nigeria. The wood is brown, has a fine texture, and an interlocking grain that shows a striped figure when quartersawed. It weighs about 40 lb per cu ft. It is used for flooring, paneling, veneers, and cabinetwork. The Brazilian wood known as Imbuia,

from the tree *Nectandra villosa*, is a close match to true walnut, and is valued for cabinetwork, flooring, and furniture. The heartwood has an olive to brown color and takes a high polish. There are as many as 50 species of *Nectandra* trees in Brazil, varying widely in characteristics. The Canela preta, from the tree *N. mollis*, is a wood with large satiny stains on a dark-yellow background. It has a silvery luster when polished, has a spicy scent, and is very durable. It more resembles bleached walnut.

Walnut oil is yellowish oil obtained by pressing the nut kernels of the common walnut. It is a good drying oil and is used especially for artists' paints. The specific gravity is 0.919 to 0.929 and iodine value 148. It is soluble in alcohol. The oil from the candlenut is also called walnut oil. Walnut-shell flour, made from the refuse shells of the walnut industry of California, is used as a filler in molded plastics and in synthetic adhesives to increase bonding strength. It contains cellulose with about 28% lignin, 5 furfural, 9 pentosans, 6 methyl hydroxylamine, and 2.5 sugars and starch. In colonial times walnut bark was used as a cathartic. It contains a Juglone, or Nucin, a complex naphthoquinone,  $C_{10}H_8O_2$ . In Russia vitamin C is extracted from the Zakatalsk nuts, which are bitter pignut walnuts.

**Walrus hide.** The skin of the walrus, a marine mammal, *Odontobenus rosmarus*, and *O. abesus*, native to the North Atlantic and Pacific oceans. The animals sometimes have a length of 16 ft, and a weight up to 2,000 lb, and the hide is obtainable in large pieces. They congregate in herds on the icebergs of the North. The skin is tanned and makes a leather with a beautiful natural grain. It is also very tough and was formerly much used for coach traces. It is now employed where a tough and ornamental leather is required. Walrus leather is imitated with embossed heavy sheepskin, and the leather is used for such things as bags and coverings.

**Water repellents.** Chemicals used for treating textiles, leather, and paper such as washable wallpaper, to make them resistant to wetting by water. They are different from waterproofing materials in that they are used where it is not desirable to make the material completely waterproof, but to permit the leather or fabric to "breathe." Water repellents must not form acids that would destroy the material, and



they must set the dyes rather than cause them to bleed on washing. They usually consist of a mineral salt over which a wax emulsion is placed; the treatment may be a one-bath process, or be by two separate treatments. Aluminum acetate is one of the most common materials for this purpose. Basic aluminum acetate is a white, amorphous powder of the composition  $\text{Al}(\text{OH})(\text{OOC}\cdot\text{CH}_3)$ . It is only slightly soluble in water but is soluble in mineral acids. Niaproof, of the Niacet Chemicals Div., U.S. Vanadium Corp., is a concentrated aluminum acetate for waterproofing textiles. Zirconium acetate, a white crystalline material of the composition  $\text{ZrOH}(\text{C}_2\text{H}_3\text{O}_2)_3$ , and also its sodium salt, are used in water-repellent compounds.

**Water softeners.** Chemical compounds used for converting the soluble scale-forming solids in boiler feed water into insoluble forms. In the latter condition they are then removed by settling or filtration. The hardness of water is due chiefly to the presence of carbonates, bicarbonates, and sulphates of calcium and magnesium. Temporary hard waters are those that can be softened by boiling; permanent hard waters are those that require chemicals to change their condition. Sodium hydroxide is used to precipitate magnesium sulphate. Caustic lime is employed to precipitate bicarbonate of magnesium, and sodium aluminate is used as an accelerator. Barium carbonate may also be used. Prepared water softeners may consist of mixtures of lime, soda ash, and sodium aluminate, the three acting together. Alum is used in settling tanks to precipitate mud, and zeolite is used extensively for filtering.

Water is also softened and purified by the ion-exchange method, using specially prepared synthetic resins. By treating the water with a hydrogen derivative of a resin the salts in the water are converted to the corresponding acids and the total solids thus reduced. The carbonates are converted to carbonic acid which goes off in the air. The water is again treated with a sodium salt of a resin which reduces the acids. Water receiving this double treatment is equal to distilled water. Zeo-Karb and D-acidite, of the Permutit Co., are Ion exchange agents of this type. These materials are also called Anion exchange agents and Cation exchange agents. Amberlite IRA-400, of Rohm & Haas, is an anion exchange resin which will split neutral salts in the water and also remove the silica. The Ger-

man Wofatit P is a sodium salt of a phenol-formaldehyde resin, and Wofatit KS is a resin made from phenol, resorcinol, formaldehyde and benzaldehyde sulphonic acid.

**Wax.** A general name for a variety of substances of animal and vegetable origin, which are fatty acids in combination with alcohols instead of with glycerin as in fats and oils. They are usually harder than fats, less greasy, and more brittle, but when used alone do not mold as well. Chemically, the waxes differ from fats and oils in being composed of high-molecular-weight fatty acids with high-molecular-weight alcohols. The most familiar wax is beeswax from the honeybee, but commercial beeswax is usually greatly mixed or adulterated. Another animal wax is spermaceti from the sperm whale. Vegetable waxes include Japan wax, jojoba oil, candelilla, and carnauba wax. Mineral waxes include paraffin wax from petroleum, ozokerite, ceresin, montan wax. The mineral waxes differ from the true waxes in chemical composition and are mixtures of saturated hydrocarbons.

The animal and vegetable waxes are not plentiful materials, and are often blended with or replaced by hydrocarbon waxes. Santowax, of the Monsanto Chemical Co., is a synthetic high-melting-point microcrystalline hydrocarbon wax derived from coal tar. The specific gravity is 1.097. It is used in polishes and coatings, and as a plasticizer in synthetic resins. Opalwax, of E. I. du Pont de Nemours & Co., Inc., is a synthetic wax produced by the hydrogenation of castor oil. It has about the same hardness as carnauba, specific gravity of 0.98, melting point of 86 to 88°C, is odorless, and of a pearl-white color, but it lacks the luster of carnauba. It is very resistant to most solvents, and is used for insulation, coatings, candles, and carbon paper. Acrawax, of the Glyco Products Co., Inc., is a somewhat similar substitute for carnauba with higher melting point. Stroba wax of this company is a synthetic wax with a base of stearic acid and lime. The melting point is 103 to 106°C. It is used in polishes, insulation, and as a flattening agent. Synthetic wax under the name of Pentawax 286, of the Heyden Chemical Corp., is a true wax in that it is a combination of fatty acids with an alcohol. It is made from the long-chain acids of vegetable oils with pentaerythritol. It has a higher melting point than carnauba, 110°F, but does not form a self-polish-

ing liquid wax like carnauba. Waxes are employed in polishes, phonograph records, leather dressings, sizings, waterproofing for paper, candles, and in varnishes. They are softer and have lower melting points than resins, are soluble in mineral spirits and in alcohol, and insoluble in water.

**Wear-resistant steel.** Many types of steel have wear-resistant properties, but the term usually refers to high-carbon, high-alloy steels used for press dies subject to abrasion and for wear-resistant castings. They are generally cast and ground to shape. They are mostly sold under trade names for specific purposes. Adamite is the trade name of the Mackintosh-Hemphill Co. for a high-carbon, nickel-chromium-iron alloy used for drawing and forming dies. The Brinell hardness ranges from 186 to 477 as cast, with tensile strengths up to 125,000 psi. The various grades contain from 0.50 to 1.50% chromium, with half this amount of nickel in each case, carbon from 1.25 to 3.50%, and silicon from 0.50 to 2%. The softest grades can be machined and then hardened, but the hard grades are finished by grinding. Castaloy, of the Detroit Alloy Steel Co., is a high-carbon, high-chromium steel for automobile-fender dies and wear-resistant castings. Martin steel, of this company, is an air-hardening steel containing 12 to 14% chromium, 0.85 to 1.25 molybdenum, 0.35 vanadium, 0.80 cobalt, and 1.4 to 1.6 carbon. It is highly resistant to abrasion. Dasco is a general trade name for steels of this company. Carbomang is another cast-to-shape steel of the same company containing 1 to 1.25% manganese, 0.45 chromium, 0.50 tungsten, 1 carbon. It can be cast to intricate shapes and is oil-hardening. Cobaltchrom is a nondeforming, wear-resistant cast steel for cutting and stamping dies. It contains 12 to 14% chromium, 0.80 cobalt, and 1.5 carbon. Krokoloy is a die steel of the 14% chromium type containing higher cobalt, and is air-hardening. Kinite, of the Kinite Corp., for blanking and forming dies, and for cams and cutters, contains 12.5 to 14.5% chromium, 1.5 carbon, 1.10 molybdenum, 0.70 cobalt, 0.55 silicon, 0.50 manganese, and 0.40 nickel. It has high compressive strength. Cristite, of the Commercial Alloys Co., contains 10% chromium, 17 tungsten, 3.5 carbon, 2.5 molybdenum, and is notable for corrosion and acid resistance. Circle L4 steel, of the Lebanon Steel Foundry, used for cams and rolls, contains 1.25 to 2% chro-

mium, 1 to 1.5 manganese, 1 molybdenum, 0.12 vanadium, and 0.8 carbon.

**Welding rods.** A name applied to metal rods and wire used for either electric or gas welding, or for building up surfaces, or hard-facing surfaces. Nonferrous rods used for welding bronzes are usually referred to as Brazing rods, as the metal to be welded is not fused when using them. Welding rods may be standard metals or special alloys, coated with a fluxing material or uncoated, and are normally in diameters from  $\frac{3}{32}$  to  $\frac{1}{4}$  in. Compositions of standard welding rods follow the specifications of the American Welding Society. Molded carbon, in sizes from  $\frac{1}{8}$  to 1 in. in diameter, is also used for arc welding. Intensarc is the trade name of the National Carbon Co., Inc., for carbon rods. Low-carbon steel rods for welding cast iron and steel contain less than 0.18% carbon. High-carbon rods produce a hard deposit that requires annealing, but these are also used for producing a hard filler. High-carbon rods, with 0.85 to 1.10% carbon, will give deposits with initial hardness of 575 Brinell, whereas high-manganese rod deposits will be below 200 Brinell but will work-harden to above 500 Brinell. Stainless-steel rods are marketed in various compositions. The Flexarc welding rods of the Westinghouse Electric Corp. comprise a range of stainless steels with either titania-lime or straight lime coatings. Stainless C, of the Lincoln Electric Co., is an 18-8 type of stainless steel having also 3.5% molybdenum. Aluminumweld, of this company, is a 5% silicon aluminum rod for welding silicon-aluminum alloys, and the Tungweld rods, for hard surfacing, are steel tubes containing fine particles of tungsten carbide. Chromang, of the Arcos Co., used for welding armor plate and high-alloy steels, is an 18-8 stainless steel modified with 2.5 to 4% manganese. In the welded condition it has a tensile strength of 80,000 to 90,000 psi with elongation 35 to 45%. Amsco welding rod, for pointing dipper teeth and for hard-facing tools, is a high-manganese steel of the American Manganese Steel Co. It is marketed in grades giving hardnesses from 500 to 700 Brinell. Toolface, of this company, is a high-speed steel rod for facing worn cutting tools. Superloy, of the Resisto-Loy Co., used for facing surfaces where extreme hardness is required, has the alloy granules in a soft-steel tube. The welded deposit has a composition of 30%

chromium, 8 cobalt, 8 molybdenum, 5 tungsten, 0.05 boron, and 0.20 carbon. Tung-Alloy, Resisto-Loy, and Isorod are other hard-facing rods of the same company. Resisto-Loy has a nonferrous content, with 35% chromium, 5 molybdenum, and 60 copper crystals in the tube.

Stoodite is a high-manganese steel in the form of rods marketed by the Stoody Co. for hard facing. Chromend 9M, of the Arcos Corp., is a rod for arc-welding hard deposits. It contains 8 to 10% chromium and 1.5 molybdenum, giving a weld with a hardness of 400 Brinell. Elkonite, of the P. R. Mallory Co., is the name of a group of welding alloys made especially for welding machines. They are, in general, sintered tungsten or molybdenum carbides combined with copper or silver, and are electrodes for spot welding rather than welding rods. They are durable and wear resistant in service. Stellite hard-facing rods, of the Haynes Stellite Co., are cobalt-base alloys that retain their hardness at red heat and are very corrosion-resistant. The grades have tensile strengths from 47,000 to 105,000 psi and Rockwell C hardness from 40 to 52. Cor-ten is a chrome copper steel rod for welding stainless steels. Murex is a 13% manganese steel rod with 1% carbon and 0.85 nickel. Racolloy is the name of Reid-Avery Co., Inc., for stainless and air-hardening welding rods. Nickel silver 828 is a brazing rod of the American Brass Co. for brazing cast iron to give a good color match. It contains 46.5% copper, 43.38 zinc, 10 nickel, 0.10 silicon, and 0.02 phosphorus. It melts at 1690°F. Nickel welding rod is also used for cast iron.

**Wetting agents.** Chemicals used in making solutions, emulsions, or compounded mixtures, such as paints, inks, cosmetics, starch pastes, oil emulsions, dentifrices, detergents, to reduce the surface tension and give greater ease of mixing and stability to the solution. In the food industries chemical wetting agents are added to the solutions for washing fruits and vegetables to produce a cleaner and bacteria-free product. Wetting agents are described in general as chemicals having a large hydrophilic group associated with a smaller hydrophobic group. Some liquids naturally wet the pigments, oils, or waxes, but others require a proportion of a wetting agent to give mordant or wetting properties. Pine oil is a common wetting agent, but many wetting agents are complex chemicals. They should be powerful enough

not to be precipitated out of solutions in the form of salts, and they should be free of odor or any characteristic that would affect the solution. Aerosol wetting agents, of the American Cyanamid Co., are in the form of liquids, waxy pellets, or free-flowing powders. Aerosol OS is a sodium salt of an alkyl naphthalene sulphonic acid. It is a yellowish-brown powder soluble in most organic solvents. This salt was called Nekal in Germany. The Dresinols of the Hercules Powder Co. are sodium or ammonium dispersions of modified rosin, with 90% of the particles below 1 micron in size.

**Whale oil.** An oil extracted by boiling and steaming the blubber of several species of whale that are found chiefly in the cold waters of the extreme North and South. Whales are mammals, and are pinnate, living on animal food. The blubber blanket of fat protects the body, and the tissues and organs also contain deposits of fat. Most whale oil is true fat, namely, the glycerides of fatty acids, but the head contains a waxy fat. In the larger animals the meat and bones yield more fat than the blubber. Both the whalebone whales and the toothed whales produce whale oil. The Bluehead whales of the south, *Silbaldus musculus*, are the largest and also yield most oil per weight. International fishing allocations are made on the basis of blue whale units averaging 20 tons of oil each. The blue whale is about 25 ft long at birth and reaches 70 ft in 2 years. This species often reaches 100 ft. A 100-ft whale will weigh about 150 tons, and will yield about 27 tons of oil. The Gray whale, or California whale, of the North Pacific, is a small 50-ft species. The Greenland whale of the north, *Balaena mysticetus*, and the Finback whale of the south, *Balaenoptera physalus*, produce much oil. The Beluga or White whale, *Delphinapterus leucas*, and the Narwhal, *Monodon monoceros*, of the North Polar seas, produce Porpoise oil. Both species of porpoise measure up to 20 ft in length.

Whale oil is sold according to grade, which depends upon its color and keeping qualities. The latter in turn depend largely upon its proper cooking at extraction. No. 0 and No. 1 grades are fine pale-yellow oils, No. 2 is amber, No. 3 is pale brown, and No. 4 is the darkest oil. The oils contain oleic, stearic, palmitic, and other acids. Grade 1 has less than 1% free fatty acids, while grade 4 has from 15 to 60% with a strong fishy odor. The specific gravity is 0.920 to

0.927, saponification value 180 to 197, and iodine value 105 to 135. Whale oil contains oleic, stearic, palmitic, and other acids in varying amounts. The average content is given as 16% di-saturated glycerides, 2.5 tri-saturated, 30 tri-unsaturated, and 50% of glycerides containing one saturated acid, one unsaturated  $H_{18}$  acid, and the other an unsaturated acid. The oil of the sperm whale has a high content of spermaceti, and the iodine and saponification values are lower than for whale oil.

Whale oils of the lower grades are used for quenching baths for heat-treating steels, and also in lubricating oils. The best oils are used in soaps and candles, or for preparing textile fibers for spinning, or for treating leather. In Europe whale oil is favored for making margarine because it requires less hydrogen than other oils for hardening, and the grouping of the 16 to 22 carbon atom acids gives the hardened product greater plasticity over a wider temperature range. Sod oil is oil recovered from the treatment of leather in which whale or other marine mammal oil was used. It contains some of the tannins and nitrogenous matter which makes it more emulsifiable and more penetrant than the original oil. Sperm oils are used for lubricating.

Whale meat is used for food in Japan and in Europe. When cured in the air, the outside is hard and black, but the inside is soft. In young animals the flesh is pale; in older animals it is dark red. It has a slight fishy flavor, but when cooked with vegetables is almost indistinguishable from beef. It contains 15 to 18% proteins. As a whale decomposes rapidly, animals intended for meat are bled in the neck, and the belly wall is slit to allow entry of sea water. Whale liver oil is used in medicine for its high vitamin A content. It also contains Kitol, which has properties similar to vitamin A but is not absorbed in all animal metabolism.

**Whalebone.** The elastic, hornlike strips in the upper jaw of the Greenland whale, *Balaena mysticetus*, and some other species. The strips are generally from 8 to 10 ft long and number up to 600. Those from the Bowhead whale of the Arctic Ocean are the longest slabs, measuring up to 13 ft in length and 10 to 12 in. wide at the bottom. Finback whalebone is less than 4 ft in length. Whalebone is light in weight, very flexible, elastic, tough, and durable. It consists of a conglomeration of hairy fibers covered with an enamellike fibrous

tissue. It is easily split and is carved easily when softened in hot water. Whalebone has a variety of uses in making whips, helmet frames, ribs, and brush fibers. Baleen is a trade name for strips of whalebone used for whips, and for products where great flexibility and elasticity are required.

**Wheat.** The edible seed grains of an annual grass of the genus *Triticum* of which there are many species and thousands of varieties. It was the basic food grain of the early civilizations of the Near East, and has remained the chief grain of the white races except in cold climates where rye grows better. The plains of the United States, Canada, Argentina, Australia, southern Russia, the Danube Valley, and northern India are the great wheat areas. The United States normally produces 15% of the wheat of the world and Canada about 10%. The types grown commercially are chiefly limited to common wheat and durum wheat. Common wheat, *T. vulgare*, is the chief source of Wheat flour. It has a stout head from which the grains can be separated easily. The hundreds of varieties are divided roughly into hard wheats and soft wheats, and red wheats and white wheats. The hard wheats usually have smaller grains, but are richer in proteins.

Spring wheat is wheat that is sown in the spring and harvested in the late summer. Winter wheat is sown in the fall to develop a root system before winter, and is then harvested in the early summer. It is more resistant and gives a higher yield. Durum wheat, *T. durum*, has a thick head with long beards, and large hard grains rich in gluten. The plant is hardy and drought-resistant, but the flour is too glutenous for American bread, and is much used for macaroni and in mixtures. Seven classes of wheat are designated in the official grain standards of the U.S. Department of Agriculture: Hard red spring wheat; Durum wheat; Red durum wheat; Hard red winter wheat; Soft red winter wheat; White winter wheat; and Mixed wheat. Each class permits mixtures of varieties. The minimum test weight of wheat is required to be 60 lb per bu. Most of the wheat production is used for making edible flour, and the average extraction of flour is taken as 71.8%. It usually requires 140 lb of wheat to produce a 100-lb sack of flour, leaving 40 lb of hull and bran which is called Offal, though this name also refers to meat-packing by-products.



Wheat is also used for making beer, and at times is employed for producing starch and alcohol. Some wheat is used for stock feed, but most of the wheat for this purpose is of lower and condemned grades. Buckwheat consists of the seed grains of the *Fagopyrum esculentum*, a plant of the same family as the rhubarb and dock. It is native to Asia and is one of the chief foods in Russia, but is used only in mixed flours in the United States. The flour is more starchy and has less protein than wheat. It is also darker in color and has a different flavor.

**Whetstone.** Stones of regular fine grains composed largely of chalcedony silica, often with minute garnet and rutile crystals. They are used as fine abrasive stones for the final sharpening of edge tools. Whetstones are also sometimes selected, fine sandstones from the grindstone quarries. The chocolate whetstone from New Hampshire is mica schist. The finest whetstones are called oilstones. A fine-grained Honestone, known as Coticule, comes from Belgium, and is used for sharpening fine-edged tools. It is compact, yellow in color, and contains minute crystals of yellow manganese garnet, with also potash mica and tourmaline. Coticule is often cut double with the blue-gray Phyllite rock adhering to and supporting it. Scythestones are made from Ohio and Indiana sandstones, and from the schist of Vermont. Rubbing stones are fine-grained Indiana sandstones.

**White brass.** A bearing metal which is actually outside of the range of the brasses, bronzes, or babbitt metals. It is used in various grades, the specification adopted by SAE being tin, 65%; zinc, 28 to 30; and copper, 3 to 6. It is used for automobile bearings, and is close-grained, hard, and tough. It also casts well. A different alloy is known under the name of white brass in the cheap jewelry and novelty trade. It has no tin, small proportions of copper, and the remainder zinc. It is a high-zinc brass, and varies in color from silvery white to yellow depending upon the copper content. An old alloy formerly used for casting buttons, known as Birmingham platina, or Platina, contained 75% zinc and 25 copper. It has a white color but is very brittle. A yellowish metal, known as Bath metal, once widely used for casting buttons, candlesticks, and other articles, was a brass containing 55% copper and 45 zinc. White nickel brass is a grade of nickel silver. The White brass used for castings where a white color

is desired may contain up to 30% nickel. The 60-20-20 alloy is used for white plaque castings for buildings. The high-nickel brasses do not cast well unless they also contain lead. Those with 15 to 20% nickel and 2 lead are used for casting hardware and valves. White nickel alloy is a cupronickel containing some aluminum. White copper is a name sometimes used for cupronickel or nickel brass.

**White gold.** The name of a class of jewelers' white alloys used as substitutes for platinum. The name gives no idea of the relative value of the different grades, which vary widely. Gold and platinum may be alloyed together to make a white gold, but the usual alloys consist of from 20 to 50% nickel, with the balance gold. Nickel and zinc with gold may also be used for white golds. The best commercial grades of white gold are made by melting the gold with a white alloy prepared for the purpose. This alloy contains nickel, silver, palladium, and zinc. The 14-carat white gold contains 14 parts pure gold and 10 white alloy. A superior class of white gold is made of 90% gold and 10 palladium. High-strength white gold contains copper, nickel, and zinc, with the gold. Such an alloy, containing 37.5% gold, 28 copper, 17.5 nickel, and 17 zinc, when aged by heat-treatment, has a tensile strength of about 100,000 psi and an elongation 35%. It is used for making jewelry, has a fine, white color, and is easily worked into intricate shapes. White-gold solder is made in many grades containing up to 12% nickel, up to 15 zinc, with usually also copper and silver, and from 30 to 80 gold. The melting points of eight grades marketed by Handy & Harman are from 695 to 845°C.

**White metals.** Although a great variety of combinations can be made with numerous metals to produce white, or silvery, alloys, the name usually refers to the lead-antimony-tin alloys employed for machine bearings, packings, and linings, to the low-melting-point alloys used for toys, ornaments, and fusible metals, and to the type metals. Slush castings, for ornamental articles and hollow parts, are made in a wide variety of soft white alloys, usually varying proportions of lead, tin, zinc, and antimony, depending on cost and the accuracy and finish desired. These castings are made by pouring the molten metal into a metal mold without a core, and immediately pouring out again, a thin shell of the alloy solidifying against the

metal of the mold and forming a hollow product. A number of white metals are specified by the ASTM for bearing use. These vary in a wide range from 2 to 91% tin, 4.5 to 15 antimony, up to 90 lead, and up to 8 copper. The alloy containing 75% tin, 12 antimony, 10 lead, and 3 copper, melts at 184°C, is poured at about 375°C, has an ultimate compressive strength of 16,150 psi, and a Brinell hardness of 24. The alloy containing 10% tin, 15 antimony, and 75 lead melts at 240°C, has a compressive strength of 15,650 psi and a Brinell hardness 22. The first of these two alloys contains copper-tin crystals; the second contains tin-antimony crystals. A white bearing metal produced by the American Smelting & Refining Co., under the name of Asarcology, is composed of cadmium with 1.3% nickel. It contains NiCd<sub>7</sub> crystals, and is harder and has higher compressive strength than babbitt, and a low coefficient of friction. It has a melting point of 604°F. One of the oldest of the American antifriction lead-base bearing metals is Magnolia metal, marketed by the Magnolia Metal Co. It contains as high as 80% lead. The standard grade has a tensile strength of 17,500 psi, Brinell hardness 21.8, and coefficient of friction about one-third that of regular babbitt metal. The pouring range is 825 to 900°F. A Bismuth-lead alloy containing 58% bismuth and 42 lead melts at 123.5°C. It casts to exact size without shrinkage or expansion, and is used for master patterns and for sealing.

Various high-tin or reverse bronzes have been used as corrosion-resistant metals, especially before the advent of the chromium, nickel, and aluminum alloys for this purpose. Trabuk was a corrosion-resistant, high-tin bronze with about 5% nickel. Fahry's alloy was a Reverse bronze containing 90% tin and 10 copper, used as a bearing metal, and the Jacoby metal used for machine parts had 85% tin, 10 antimony, and 5 copper. The scarcity and high cost of tin have made these alloys obsolete. The bearing alloy known in England as Motor bronze is a babbitt with about double the amount of copper of a standard babbitt. One analysis gives tin, 84%; antimony, 7.5; copper, 7.5; and bismuth, 1. An old alloy, used in India for utensils, and known as Bidery metal, contained 31 parts zinc, 2 lead, and 2 copper, fluxed with resins. It was finished with a velvety-black color by treating with a solution of copper sulphate. An alloy used for dies for casting plastics contains 48% bismuth, 28.5 lead, 14.5

tin, and 9 antimony. It is nonshrinking and has good resistance to compression.

**Willow.** The wood of the trees *Salix coerulea* and *S. alba*, native to Europe, but grown in many other places. It is best known as a material for cricket bats made in England. The American willows are known as Black willow, from the tree *S. nigra*, and Western black willow from the tree *S. lasiandra*. The wood is also employed for making artificial limbs, and for articles where toughness and nonshrinking qualities are valued. The wood is brownish yellow in color, has a fine, open grain, and weighs about 30 lb per cu ft. It is of the approximate hardness of cherry and birch. Japanese willow is from the tree *S. urbaniana*. It has a closer and finer texture, and has a browner color. Black willow has a maximum crushing strength parallel to the grain of about 1,500 psi. Salicin, also called Salicoside and Saligenin, is a glucoside extracted from several species of willow bark of England and also from the American aspen. It is a colorless, crystalline material of the composition  $(\text{OH})_4\text{C}_6\text{H}_7\cdot\text{OO}\cdot\text{C}_6\text{H}_4\text{CH}_2\text{-OH}$ , decomposing at  $201^\circ\text{C}$ , and soluble in water and in alcohol. It is used in medicine as an antipyretic and tonic, and as a reagent for nitric acid. It hydrolyzes to glucose and salicyl alcohol, and the latter is oxidized to Salicylic acid,  $\text{C}_6\text{H}_4(\text{OH})\text{COOH}$ .

**Wire cloth.** Stiff fabrics made of fine wire woven with plain loose weave, used for screens to protect windows, for guards, and for sieves and filters. Steel and iron wire may be used, either plain, painted, galvanized, or rustproofed, or various nonferrous metal wires are employed. It is usually put up in rolls in widths from 18 to 48 in. Screen cloth is usually 12, 14, 16, and 18 mesh, but wire cloth in copper, brass, or monel metal is made regularly in meshes from 4 to 100. The size of wire is usually from 0.009 to 0.065 in. in diameter. Wire cloth for fine filtering is made in very fine meshes. Mesh indicates the number of openings per inch, and has no reference to the diameter of wire. A 200-mesh cloth has 200 openings each way on a square inch, or 40,000 openings per square inch. Wire cloth as fine as 400 mesh, or 160,000 openings per square inch, is made by the Newark Wire Cloth Co., by wedge-shaped weaving, although 250 wires of the size of 0.004 in. when placed parallel and in contact will fill the space of 1 in. Very fine-mesh wire cloth must

be woven at an angle since the globular nature of most liquids will not permit passage of the liquid through microscopic square openings. The wire screen cloth of the Michigan Wire Cloth Co., for filtering and screening, has elongated openings. One way the 0.0055-in. wire count is 200 per in., while the other way the 0.007-in. warp wire is 40 per in. Where accuracy of sizing is not important, the wire fabric is made with oblong or rectangular openings instead of squares to give faster screening. High-manganese steel wire is used for rock screens. For window screening in tropical climates or in corrosive atmospheres plastic filaments are sometimes substituted for the standard copper or steel wire. Lumite screen cloth, of the Chicopee Mfg. Co., is woven of vinylidene chloride monofilament 0.015 in. in diameter in 18 and 20 mesh. The impact strength of the plastic cloth is higher than that of metal wire cloth, but it cannot be used for screening very hot materials. Lektromesh, of the C. O. Jelliff Corp., is copper or nickel screen cloth of 40 to 200 mesh made in one piece by electrodeposition. It can be drawn or formed more readily than wire screen, and circular or other shapes can be made with an integral selvage edge.

**Wire glass.** A variety of glass used in building construction for windows, doors, floors, and skylights, and having woven wire mesh embedded in the center of the plate. It does not splinter or fly apart like common glass when subjected to fire or shock, and has higher strength than common glass. It is made in standard thicknesses from  $\frac{1}{8}$  to  $\frac{3}{8}$  in., and in plates 60 by 110 in. and 61 by 140 in. Underwriters' specifications call for a minimum thickness of  $\frac{1}{4}$  in. Wire glass is made with plain, rough, or polished surfaces, or with ribbed or cobweb surface on one side for diffusing the light and for decorative purposes. It is also obtainable in corrugated sheets, usually  $27\frac{3}{4}$  in. wide. Wire glass  $\frac{1}{4}$  in. thick weighs 2.25 lb per sq ft. Plastic-coated wire mesh may be used to replace wire glass for hothouses or skylights where less weight and fuller penetration of light rays are desired. Cel-O-Glass, of E. I. du Pont de Nemours & Co., Inc., is a plastic-coated wire mesh in sheet form.

**Wolframite.** The chief ore of the metal tungsten. Its composition is  $(\text{FeMn})\text{WO}_3$ . When the manganese tungstate is low, the ore is called Ferberite; when the iron tungstate is low, it is called Hübnerite.

The ore is concentrated by gravity methods to a concentrate containing 60 to 65% tungstic oxide,  $\text{WO}_3$ . To extract pure  $\text{WO}_3$  from the concentrate it is fused with sodium carbonate,  $\text{Na}_2\text{CO}_3$ , to form sodium tungstate,  $\text{Na}_2\text{WO}_3$ , which is dissolved in water. When an acid is added to the solution, the  $\text{WO}_3$  precipitates out as a yellow powder. The metallic tungsten is obtained by reducing, and is then pressed into bars and sintered. Wolframite occurs usually bladed or columnar in form. It has a specific gravity of 7.2 to 7.5, a hardness of 5, a black color, and a submetallic luster. It is found in the Mountain states, Alaska, China, and Argentina, but is also widely distributed in various parts of the world in small quantities. Chinese wolfram concentrates contain 65% tungstic oxide; the Arizona concentrates contain an average of 67%. California and Nevada concentrates are scheelite containing from 60 to 67% tungstic oxide. A variety containing zinc, found in Argentina, is called Sanmartinitite.

**Wollaston wire.** Any wire made by the Wollaston process of fine wire drawing. It consists in inserting a length of bare drawn wire into a close-fitting tube of another metal, the tube and core then being treated as a single rod and drawn through dies down to the required size. The outside jacket of metal is then dissolved away by an acid that does not affect the core metal. Platinum wire as fine as 0.00005 in. in diameter is made commercially by this method, and gold wire as fine as 0.00001 in. in diameter is also drawn. Wires of this fineness are employed only in instruments. They are marketed as composite wires, the user dissolving off the jacket.

**Wood.** A general name applied to the cut material derived from trees. Timber, in general, refers to standing trees, while Lumber is the sawed wood used for construction purposes. In construction work the word timber is often applied to large pieces of lumber used as beams. Wood is an organic chemical compound composed of approximately 49% carbon, 44 oxygen, 6 hydrogen, and 1 ash. It is largely cellulose and lignin. The wood of white pine is about 50% cellulose, 25 lignin, and the remainder sugars, resin, acetic acid, and other materials. Wood is produced in most trees by a progressive growth from the outside. In the spring when sap flows rapidly a rapid formation of large cells takes place, followed by a slower growth of hard and close cells in the summer. In some woods, such

as oak, there is a considerable difference in quality and appearance between the spring and summer woods. In some long-lived trees, such as Douglas fir, there is a difference in the strength between the outside wood with narrow rings and the wide-ringed wood of the interior or young fast-growing trees. Heartwood is the dark center of the tree which has become set, and through which the sap has ceased to flow. Sapwood is the outer, live wood of the tree; unless treated, it has low decay resistance. The grain of sawed lumber results from sawing across the annual growth rings, varied to produce different grains.

Wood is seasoned either by exposing to the air to dry, or by kiln drying. The former method is considered to give superior quality, but requires more time, is expensive, and is indefinite. Numerous tests made at the U.S. Forest Products Laboratory did not reveal any superiority in air-dried wood when kiln drying was well done. Seasoned wood, when dry, is several times stronger than unseasoned wood. The safe working stresses of the common construction woods in compression perpendicular to the grain are 900 to 1,300 psi. In the United States the distinction between Hardwoods and Softwoods is made arbitrarily by the class of tree, the evergreens being softwoods without reference to the actual hardness of the wood. Wood decays easily when subjected to alternate wetting and drying, unless treated with creosote or zinc chloride.

Lumber is graded from A Select, which is practically free from defects, to D Select, which contains more defects than other selects but none detracting from a finished appearance. The common grades run from No. 1 Common, with only few and tight knots, to No. 5 Common, with coarse defects such as decay, holes, and wane. The term Log designates the tree trunk with the branches removed. Balk is a roughly squared log; Plank is a piece cut to rectangular section 11 in. wide; Deal is one 9 in. wide; and Batten is one 7 in. wide. Board is a thin piece of any width less than 2 in. thick. Flitch is half a balk cut in two lengthwise. Scantling is a piece sawed on all sides. Shakes are longitudinal splits or cracks in the wood due to shrinkage or decay. Some woods, such as fir, are obtainable in immense quantities, and can thus be used for general construction. Other woods are available only in small quantities and are used for their special characteristics. Limewood, for example, from the lime

tree, *Tilia cordata*, has a fine, close grain, cutting well in all directions, and is used for carving. Some wood for special purposes comes from roots or from bushes. The Briar used for tobacco pipes is from the root of the white heath, *Erica arborea*, of North Africa. Substitutes for briar are the burls of the laurel and rhododendron.

**Wood flour.** Finely ground dried wood employed as a filler and reinforcing material in molding plastics, in linoleum, and as an absorbent for nitroglycerin. It is made largely from light-colored softwoods, chiefly pine and spruce, but maple and ash flours are preferred where no resin content is desired. Woods containing essential oils, such as cedar, are not suitable. Wood flour is produced from sawdust and shavings by grinding in burr mills. It has the appearance of wheat flour. The sizes commonly used are 40, 60, and 80 mesh; the finest is 140 mesh. Grade 1, used as a filler in rubber and plastics, has a particle size of 60 mesh and a specific gravity of 1.25, but 80 and 100 mesh are also used for plastic filler. Since wood flour absorbs the resin or gums when mixed in molding plastics, and sets hard, it is sometimes mixed with mineral powders to vary the hardness and toughness of the molded product. Vast quantities of Sawdust are obtained in the woodworking mills. Besides being burned as a fuel, it is also used for packing glassware, for distilling to obtain resins, and in tumbling machines for finishing metal products. For the latter use it may be specially prepared and graded. Kube-Kut, of Michael Wood Products, Inc., is a maple sawdust cut in fine cubical particles.

**Wool.** The fine, soft, curly hair or fleece of the sheep, alpaca, vicuña, certain goats, and a few other animals. The specific designation wool always means the wool of sheep. Sheep's wool is one of the most important commercial fibers. It is used for the production of a great variety of Woolens, or wool fabrics under general trade names such as Flannel, Cheviot, Serge, Broadcloth, and Tweed. Worsteds are wool fabrics made from combed-wool yarn, usually from long, smooth wool. Wool is also employed for packings and for insulation, either loose or felted. The weaving grades are called Apparel wool.

Wool quality is by fineness, softness, length, and scaliness. Fiber diameters vary from 0.0025 to 0.005 in. Long wools are generally heavy. Fibers below 3 in. in length are known as Clothing wool, and



those from 3 to 7 in. are called Combing wools. Long wools are fibers longer than 7 in. Fleece wool is the unscoured fiber. It may contain as high as 65% of grease and dirt, but this is the form in which wool is normally shipped because it then has the protection of the wool fat until it is manufactured. Wool is very absorbent to moisture and will take up about 33% of its weight of water. Carpet wools are usually long nonresilient fibers from sheep bred in severe climates, such as the Mongolian wool. The only breed of sheep developed for wool alone is the Merino. In Australia the Corriedale and the Polworth sheep are dual-purpose animals for wool and meat.

Wool differs from hair in fineness and in its felting and spinning properties. The latter are due to the fine scales on the wool fibers. The finest short-staple wool has as many as 4,000 scales to the inch. The average on long-staple wool is about 2,000 scales per inch. These scales give to the wool the cohesive qualities. Some animals have both wool and hair, while others have wool only when young. There is no sharp dividing line between wool and hair. The finest of the sheep wools comes from the Merino sheep, but these vary according to the age and breeding of the animal. The Lincoln sheep produces the longest fiber. It is lustrous but very coarse. Luster of wool depends upon the size and smoothness of the scales. Crimpiness in wool is due to the open formation of the scales. A fine merino will have 24 crimps per inch; a coarse crossbred will have only 6 per inch. Strength of wool fibers often depends upon the health of the animal and the feeding. One quarter of the world production of wool is in Australia. Argentina ranks second in production, with the United States third. But the United States is a lamb-eating nation, and a large proportion of the animals are slaughtered when 4 to 8 months old, and most of the others are kept only one season for one crop of wool. New Zealand, Uruguay, Russia, and England are also important producers. England is the center of wool-sheep breeding, with more varieties than any other country. In general, warm climates produce fine wools, and hot climates produce thin, wiry wools, but the fundamental differences come from the type of animal and the feeding. The Reused wool from old cloth was originally called Shoddy, but the name has an opprobrious signification in the United States, and is not used by manufacturers to designate the fabrics made from shoddy. It is used in mixtures with new wool for clothing and

other fabrics. Extract wool is shoddy that is recovered by dissolving out the cotton fibers of the old cloth with sulphuric acid. Short fibers of shoddy, less than  $\frac{1}{2}$  in., are known as Mungo fibers. They are used in woolen blends to obtain a napped effect. Reprocessed wool is fiber obtained from waste fabric which has not been used. Noils are short fibers produced in the combing of wool tops for making worsteds. They are used for woolen goods and felt.

**Wormseed oil.** An essential oil from the seeds and leafy parts of the annual plant *Chenopodium anthelminticum*, native to the West Indies but grown chiefly in Maryland and the Central states. The oil is also known as Baltimore oil. It is used in medicine for treating intestinal worms. The active constituent is Ascaridole of which the oil contains 65%. USP oil has a specific gravity of 0.955 to 0.977. An ancient drug of this class which is still important is Santonin, an alkaloid extracted from the unopened flower heads of the Levant wormseed, *Artemisia cina* of Turkestan and the Near East. It is used as a specific for worms for human and animal treatment. Wormwood oil is obtained by distillation from the dried leaves and tops of the perennial herb *A. absinthium*, native to the Mediterranean countries and grown in the North Central states. It is used in medicinal preparations for fevers but is a dangerous drug. It is also used for flavoring the liqueur Absinthe, but its use is forbidden in many countries.

**Wrought iron.** The commercially pure iron resulting from the reduction of the carbon in cast iron. It is obtained by melting white cast iron and passing an oxidizing flame over it. The iron is left in a pasty condition full of holes, and is then rolled or hammered to unite it into one mass. Wrought iron as thus made has a fibrous structure, with fibers of slag extending through the iron in the direction of rolling. The commercial rolled iron has an average elastic limit of 30,000 psi, ultimate strength 50,000 psi, elongation 35%, and Brinell hardness 100. Merchant bar iron is an old name of bars or rods of wrought iron which were made by the faggoting and forging process. Wrought iron has less than 0.12% carbon, usually 0.08%. Wrought iron is also produced by the Aston process of shotting bessemer iron into a ladle of molten slag. The sudden cooling breaks the iron up into small globules and the slag absorbs the gases, thus

replacing the expensive puddling process. The shotted ball is rolled similarly to hand-puddled iron.

The quality grades of wrought iron refer to the amount of working that the metal has received. When the word iron is used alone, it generally refers to wrought iron. Wrought iron is chiefly for rivets, staybolts, water pipes, tank plates, and general forged work. For other uses it is now largely replaced by ingot iron or steels containing only slight percentages of carbon, because of the greater uniformity and freedom from slag cracks.

Iron fibered steel is a name of the Edgar Allen Steel Co., Inc., for rolled soft steel toughened with fine iron wire worked into it. Staybolt iron is an old name for tough and ductile iron made from charcoal iron or from carefully puddled iron, and used for forgings. Lewis iron, of Joseph T. Ryerson & Son, Inc., for staybolts and structural parts, is a highly refined, hand-puddled iron with a tensile strength up to 52,000 psi and elongation 30%. Swedish wrought iron, sometimes still called Norway iron because it was brought to America in Norwegian ships, is a charcoal iron made from high-grade ore, and it has great ductility and toughness. It contains 0.02 to 0.06% carbon, 0.02 to 0.04 silicon, 0.04 to 0.07 phosphorus, 0.005 to 0.01 sulphur, and a trace of manganese. Swedelec, of the A. Milne Co., is a Swedish charcoal puddled iron produced in a Lancashire hearth and rolled into a soft product. It is ductile and has high magnetic permeability and low hysteresis loss, and thus is suitable for transformer cores. Swedish Lancashire iron has a fibrous structure, a tensile strength of 40,000 psi and elongation 33%.

**Ylang ylang.** Called Cananga oil in the East Indies. An essential oil distilled from the flowers of the *Canangium odorata*, a tree cultivated in the East Indies, Madagascar, and the Philippines. The oil contains linalol and geraniol, and is used in soaps and in perfumery. From 125 to 150 lb of flowers are obtained from a tree, and about 400 lb are required to produce 1 lb of oil. Another famous perfume oil that rivals ylang ylang in fragrance is Champaca, distilled from the flowers of the large tree *Michelia champaca*, of southern Asia.

**Yucca fiber.** The fiber obtained from the leaves of a number of desert plants of the genus *Yucca* of the lily family native to southwestern United States and northern Mexico. The fiber is similar to

fibers from agave plants and is often confused with them and with istle. The heavier fibers are used for brushes, and the lighter fibers are employed for cordage and burlap fabrics. In Mexico the word Palma designates yucca fibers and grades of istle as well as palm-leaf fibers. Palma samandoca is fiber from the plant *Samuela carnerosana*, the Date yucca. It is also called Palma istle. Palmilla fiber is from the *Y. elata*. Palma pita is a fiber from the *Y. treculeana*. Pita fiber used for coffee bags in Colombia and Central America is from a different plant. Other yucca fibers come from the plants *Y. glauca*, *Y. baccata*, and *Y. gloriosa*. Some varieties of the *Y. baccata* yield also edible fruits. The roots of species of yucca yield saponin which is also obtained as a by-product in extracting the yucca fiber.

**Zinc.** A bluish-white metal, symbol Zn. When cast into slabs it is often called spelter. It is obtained chiefly from the mineral sphalerite. Zinc is hard and brittle, and has a highly crystalline structure when broken. It melts at 787°F and boils at 1661°F. The specific gravity is 7.1. At about 250°F it is ductile and can be rolled into thin sheets. The tensile strength cast is 9,000 psi, with elongation 1%; the rolled metal has a strength of 24,000 psi, with elongation 35%. The coefficient of expansion is 0.0000183. Zinc casts readily. On exposure to the air the metal becomes coated with a film of carbonate, and is then very resistant to corrosion. Zinc is employed for galvanizing iron and steel, and in electric batteries. It is also used in sheet or corrugated-sheet form for roofing and siding in building construction. For this use it is hardened with a small amount of copper or other element. Zilloy, of the New Jersey Zinc Co., is the name of a zinc alloy in the form of corrugated sheets, for roofing and siding, and for drawn and formed parts. It has higher strength than rolled zinc. The alloy contains 1% copper and minute quantities of cadmium and magnesium. The Zinc wire used in Germany for woven brake linings contains 1.1% copper, 0.8 aluminum, and traces of iron, lead, and chromium. It has high tensile strength. Rolled zinc, for making sheet-metal parts, comes in standard gage thicknesses of pure zinc. Zinc sheet is widely used for stamping decorative articles, especially in the form of prefinished metal. As zinc and zinc-base alloys are self-annealing, they require no annealing between difficult bendings. Zinc is an important metal for alloying with copper

in making brasses. Zinc dust, zinc sulphide, and zinc oxide are used for paint making.

Spelter is an old name for slab zinc. Metallic zinc was first introduced into Europe from China and was called by the Dutch traders spialter, which was Anglicized to spelter. The first spelter, or metallic zinc, to be produced in the United States was made in 1838 at Washington, D.C., from zincite ore from Franklin, N.J. Sterling spelter was a grade 99.5% pure.

The highest grade of commercial zinc is 99.99%. This grade is used in making die castings and for some brass making. Grade A, or high-grade zinc, however, usually runs 99.8% pure, and grade B, or intermediate, is 99.35% pure. Brass special is 98.7% pure. Zinc for brass making does not contain more than 0.60% lead and 0.03 iron. Larger amounts of lead cause cracking. The grade D, or prime western zinc, contains 98% zinc with lead up to 1.60% as the chief impurity. It is the grade used in galvanizing. Bunker Hill zinc, of the Sullivan Mining Co., is an electrolytic zinc of very high purity. Zinc comes in slabs of about 50 lb each, rolled sheets, plates, and in ribbon with the grain in one direction. Mossy zinc, used in the making of face brick to obtain various color effects, is a disintegrated metallic zinc made by pouring the molten metal into water. The grade known as Feathered zinc is of small grain size.

**Zinc-base alloys.** This term now refers usually to alloys of about 92% zinc with aluminum, copper, and other elements, used for die castings. Small amounts of secondary alloying elements may have important effects on the metal, as little as 0.05% lithium making zinc castings fine-grained. One of the earliest die-casting alloys, known as Salge's bronze, contained 84% zinc, 10 tin, 4 copper, 1 lead, and 1 antimony. Sorel's alloy, which was early used for casting small statues and novelties, was high in zinc with only a small amount of copper and about 1% iron. It was prepared by adding zinc and iron to brass. The old Fontainemoreau bronze, or Reverse brass, widely used before the use of aluminum alloys and before the development of the modern zinc-base alloys with less copper, was an alloy with 90 to 92% zinc, 7 to 8 copper, and sometimes lead and iron. The older die-casting alloys with considerable tin have been replaced by those with aluminum and copper, as the tin alloys had very low

strength and were brittle. The alloys produced by the New Jersey Zinc Co. under the name of Zamak are in three grades containing 4.1% aluminum. Zamak 2 has 2.7% copper and 0.03 magnesium, Zamak 3 has no copper and 0.04% magnesium, and Zamak 5 has 1% copper and 0.03 magnesium. The iron is less than 0.075%, the lead and cadmium below 0.003%, and the tin below 0.001%. Zamak 2 is noted for hardness and tensile strength; Zamak 3 for impact strength and retention of dimensions; and Zamak 2 and 5 are noted for resistance to corrosion. The tensile strengths range from 40,000 to 48,000 psi, with elongation 3 to 5%, and hardness 74 to 83 Brinell. The specific gravity is from 6.6 to 6.7, and melting points 715 to 718°F. Apex zinc alloy, of the Apex Smelting Co., has about the same composition. The zinc-base alloys are now fairly closely standardized, but may vary in small proportions of elements, and are sold under many trade names in the cast articles, such as Miller metal, used by the Miller Co. for casting lamp and ornamental parts. Di-Metal No. 3, of the American Smelting & Refining Co., has 96% zinc and 4 aluminum. It has good impact strength and dimensional stability, but when high tensile strength and hardness are needed grade No. 2 is used. It contains 93% zinc, 4 aluminum, and 3 copper. The Zn-Cu-Be alloy, of the General Electric Co., is a wrought alloy used to replace brass for formed and drawn parts. It contains 2 to 2.6% copper, 0.08 to 0.15 beryllium, and the balance zinc. The tensile strength of the rolled sheet across the grain is 55,000 psi, with elongation 15%. It is corrosion-resistant.

Zinc-base alloys are also used for bearings. They have lower anti-friction properties, but have high compressive strength and are less expensive than tin alloys. An alloy produced by the Lumen Bronze Co., containing 86% zinc, 10 copper, and 4 aluminum, has a compressive strength of 75,000 psi, Brinell hardness 116, and low coefficient of friction. Ehrhard's bearing metal has 2.5% aluminum, a small amount of tin to form copper-tin crystals, about 1% lead and 10 copper, with the balance zinc. An alloy known as Fenton's alloy contains 80% zinc, 14 tin, and 6 copper. It is used for high-speed bearings with low pressure. Binding metal, for wire-rope slings, is a hardened zinc alloy. A binding metal used by the Pennsylvania Railroad has 93.5% zinc, 2.8 tin, and 3.7 antimony.

The War bronze used for bearings to replace bronze when copper

was scarce was a zinc alloy containing 5% copper and 2 aluminum, with sometimes a very small amount of tin. A substitute low-aluminum alloy for the standard 4% aluminum zinc-base alloy contains 1.5% aluminum, 1 copper, and 0.03 magnesium. It has a tensile strength of 40,000 psi, and elongation 6% as cast. Leddel alloy is a bearing metal containing 90% zinc, 5 copper, and 5 aluminum. Hartzink is a German alloy hardened with 5% iron and 2 to 3 lead. Iron forms chemical compounds with zinc such as  $\text{FeZn}_7$  and  $\text{Fe}_3\text{Zn}_{10}$ . Even small amounts of iron in zinc will reduce malleability. Alloys containing more than 1% iron are brittle, but the brittleness is not so marked when the copper content is high. Germania bearing bronze, with about 1% iron, has 80% zinc, about 10 tin, and slightly less than 5% each of copper and lead. Pattern metal, for casting gates of small patterns, may be any brass made with a high percentage of zinc and some lead.

Manganese-zinc alloys are high-strength brasses containing a high percentage of manganese. An alloy containing 60% zinc, 15 copper, and 25 manganese has a tensile strength of 100,000 psi. It can be extruded readily. It has a bright silver color very resistant to tarnishing.

A zinc alloy of another class is Eraydo, of the Illinois Zinc Co. It is a patented material composed of zinc, copper, and silver, and is used for radio shields and condenser frames. It has the property of cutting off induction of stray currents from coils and tubes. The tensile strength is 50,000 psi, and it is about 20% lighter in weight than copper. Zam metal is an alloy of zinc with aluminum and mercury produced by the Hanson-Van Winkle-Munning Co. for zinc-plating anodes. It has the property of being free from acid attack until the electric current passes through it.

**Zinc chloride.** Also called Butter of zinc, and originally known as Spirits of salts. A white, crystalline, poisonous substance of the composition  $\text{ZnCl}_2$ , used as a soldering flux, for wood preserving, in dry-cell batteries, and in vulcanizing fibers. It has a specific gravity of 2.91 and melts at 262°C. It is soluble in water and in alcohol. It is made by the action of hydrochloric acid on zinc. Copperized CZC, of the Koppers Co., Inc., is Copperized chromated zinc chloride used as a wood preservative against rot and termites. It is a compound salt

containing 75% zinc chloride, 20 sodium bichromate, and 7 cupric chloride. The softwood crossties treated with zinc chloride, used on the first transcontinental railroad, were called Burnettized wood.

**Zinc chromate.** Also called Zinc yellow and Buttercup yellow. A yellow pigment stable to light and sulphur fumes, but with lower tinting strength than chrome yellow. It is a crystalline powder of the composition  $4\text{ZnO} \cdot 4\text{CrO}_3 \cdot \text{K}_2\text{O} \cdot 3\text{H}_2\text{O}$  and specific gravity 3.4 to 3.7. It is used for mixing with Prussian blue to form greens, and the paler shades are used as fine color pigments in printing inks. Zinc bichromate,  $\text{ZnCr}_2\text{O}_7$ , is an orange-yellow powder used as a pigment. Zinc chromates are made by reacting zinc oxide with chromate solutions.

**Zinc ores.** The metal zinc is obtained from a large number of ores, but the average zinc content of the ores in the United States is only about 3%, so that they are concentrated to contain 35 to 65% before treatment. The sulphide ores are marketed on the basis of 60% zinc content, and the oxide ores on the basis of 40% zinc content. Sphalerite, or Zinc blende, is the most important ore and is found in quantities in Missouri and surrounding states, and in Europe. Sphalerite is a zinc sulphide,  $\text{ZnS}$ , containing theoretically 67% zinc. It has a massive crystalline or granular structure and hardness of about 4. When pure, its color is white; it colors yellow, brown, green, to black with impurities. The ores from New York state are ground and concentrated by flotation to an average of 58% zinc and 32 sulphur, which is then concentrated by roasting to 68% zinc and 1 sulphur. It is then sintered to remove lead and cadmium, and finally smelted with coke and the zinc vapor condensed. The Silesian zinc blende, known as Wurtzite, contains 15% zinc, 2 lead, and some cadmium. Calamine is found in New Jersey, Pennsylvania, Missouri, and in Europe. It is the ore that was formerly mixed directly with copper for making brass. The ore usually contains only about 3% zinc, and is concentrated to 35 to 45%, and then roasted and distilled. Calamine is Zinc silicate,  $2\text{ZnO} \cdot \text{SiO}_2 \cdot \text{H}_2\text{O}$ . It is a mineral occurring in crystal groups of a vitreous luster, and may be white, greenish, yellow, or brown. The specific gravity is 3.4 and hardness 4.5 to 5. It occurs in Arkansas with Smithsonite, a zinc carbonate ore,  $\text{ZnCO}_3$ . Franklinite is an ore of both the metals zinc and manganese. Its



approximate composition is  $(\text{FeZnMo})\text{O} \cdot (\text{FeMn})_2\text{O}_3$ , but it shows wide variation in the proportions of the different elements. It is found in the zinc deposits of New Jersey. The zinc is converted into zinc white, and the residue is smelted to form spiegeleisen. The mineral franklinite occurs in massive granular structure with a metallic luster and an iron-black color.

The ore Zincite is used chiefly for the production of the zinc oxide known as zinc white employed as a pigment. Zincite has the composition  $\text{ZnO}$ , containing theoretically 80.3% zinc. The mineral has usually a massive granular structure with a deep-red to orange streaked color. It may be translucent or almost opaque. Deep-red specimens from the workings at Franklin, N.J., are cut into gem stones for costume jewelry. Willemite is a zinc orthosilicate,  $\text{Zn}_2\text{SiO}_4$ , containing theoretically 58.6% zinc. Manganese often replaces part of the zinc, and it is then called Troostite. Its structure is massive or granular, and it has a vitreous luster. The color is white, yellowish green, or blue when pure, but with manganese it becomes apple green, red, or brown. It may be transparent or opaque. The hardness is about 5.5, and the specific gravity about 4. Willemite is found in various places in the United States. The crushed ore is used in fluorescent glass.

**Zinc powder.** Also known as Zinc dust, although zinc dust is more specifically only the powder produced by the redistillation of zinc drosses. A finely divided gray metallic zinc powder used in paints for the protection of iron and steel against corrosion, in synthetic rubber, in lubricants, and in the chemical industry. It is also used for coating metals by the Sherardizing process. For paints it may be mixed with 10 to 25% zinc oxide, to aid in keeping the powder in suspension, to harden the film, and to brighten the color. Zinc powder is a condensed zinc vapor, or an atomized zinc, and is of such fineness that 90 to 95% should pass through a 325-mesh screen. Standard zinc dust contains 96% metallic zinc and the balance zinc oxide. Zinc powder is easily wetted by oils or lacquers, and does not have to be ground in a paint mill. The specific gravity is 7.06. The paints made with the powder are resistant to weathering. Merrillite is a zinc dust of high purity of the Alloys Co. used to precipitate gold and silver by the cyanide process.

**Zinc sulphide.** A white powder of the composition  $\text{ZnS} \cdot \text{H}_2\text{O}$  and specific gravity 3.92, used as a paint pigment, for whitening rubber products and for opacity in paper. About 55% in rubber makes an ivory-colored rubber. Cryptone is a trade name of the New Jersey Zinc Co. for various types of zinc sulphide pigments, varying from 98% pure zinc sulphide to mixtures with barium sulphate, calcium sulphide, or titanium dioxide.

**Zinc white.** The common name of Zinc oxide,  $\text{ZnO}$ , used as a paint pigment and as an activator and a whitener in rubber. In automobile tires it aids in reinforcing and preventing tread cracking. It also aids heat dissipation. It is also called Chinese white. It is made directly from the ore, the mineral zincite, by reducing it in a special furnace with coal and an excess of air. It is also made from metallic zinc by vaporizing and burning the zinc in the air. This method is called the French process. Zinc white is a water-insoluble white powder, having a specific gravity of 5.66. As a pigment it is unaffected by the action of sulphides, and is used as an Inside white in paints and enamels. It is also employed in paints for exterior use, as it resists the action of ultraviolet rays and retains its whiteness, although it is not as whitening as lithopone. Zinc oxide has high electrical resistance, and is used in insulating cable compounds. It is also used to give color, opacity, and finish to papers. Leaded zinc oxide is a pigment consisting of zinc oxide and basic lead sulphate. It may contain from 3 to 25% lead, but the oxide for use in rubber must be lead-free, as the lead combines with the sulphur. Zinc-white paste should contain 90% pigment and 10 linseed oil. Another white zinc compound, used for flatting paints, is Zinc stearate. It has the composition  $\text{Zn}(\text{C}_{18}\text{H}_{35}\text{O}_2)_2$ , and is a white, agglutinating powder, marketed in 300 and 325 mesh. It is also used as a filler in rubber. A USP grade of 325 mesh is used in cosmetics in face powders. Aquazinc, of the Beacon Co., is a water dispersion of zinc stearate used for spraying on rubber products. Zinc peroxide is a white powder of the composition  $\text{ZnO}_2$  used in medicine and dental pastes. It contains 8.5% active oxygen which is released in contact with body tissue.

**Zirconia.** Zirconium oxide, a white crystalline powder having the composition  $\text{ZrO}_2$ , a specific gravity of 5.75, hardness 6.5, and refractive index 2.2. Its chief source is from the mineral Baddeleyite,

which comes from Brazil. The melting point is 5350°F when pure, and it is the most heat-resistant of the commercial refractories. The melting point of the commercial material is usually given as about 5000°F. It is used as a refractory and in some quartz ware, as an opacifier in ceramics, and for crucibles for melting aluminum, platinum, and other nonferrous metals for temperatures up to 3500°F. Tamco zirconium oxide refractories, of the Titanium Alloy Mfg. Co., are for temperatures up to 2300°C. Zirconia is also used as a pigment in plastics. It has high ultraviolet repelling quality. Its high melting point, chemical stability, and hardness are valuable properties for a refractory, but zirconia bricks are subject to structural disintegration by cracking by alterations in the crystals unless other metallic oxides are added. These lower the softening point somewhat. Since molten aluminum does not wet zirconia and does not react with it, zirconia bricks are much used to line aluminum furnaces. Zirconia is also the chief source of the metal zirconium.

The type of baddeleyite of Brazil known as Brazilite contains 80% zirconia; the mineral known as Zirkelite, or Zirconium sand, which is a Zirconium silicate, contains up to 50%. Zircon from the beach sands of Florida is Zirconium silicate, or Zironite.  $\text{ZrO}_2 \cdot \text{SiO}_2$  is used as a refractory for firebricks and crucibles, and as an opacifier in ceramic glazes. The melting point is 4622°C, specific gravity 4.65, hardness 7.5, and it has a white color. The white Zircon sand from India contains less than 1% iron, with a zirconium dioxide content of 62%. The naturally concentrated beach sands of New South Wales average 74% zircon. The black sands of the Oregon coast are rich in zircon with chromite.

When zirconia is used as a refractory with other material as a binder, the melting point is lowered. But zirconia may be bonded with itself by grinding 20% of the material to 200 mesh. This ground ore becomes colloidal with water. Stabilized zirconia refractories may be used to 2400°C, and will withstand high loads at elevated temperatures, but in contact with carbon they decompose at 2200°C to form carbides. The coefficient of expansion of zirconia is very low, and dishes made of it can be plunged white hot into cold water without breaking. The material is also resistant to acids and alkalis. The coefficient of refined zircon is 0.0000045 in. per in. per deg C up to 1400°C compared with 0.0000124 for chrome brick.

**Zircon** has good heat-shock resistance and is also a good electrical insulator at high temperatures. It is thus valued for electrical heater units, but its resistivity lowers at very high temperatures so that it is not used for resistor furnaces. Zircon is also used in mold facings, and as an abrasive. High purity zircon is marketed as a powder of 325 mesh. Clear zircon crystals are valued as gem stones because they have the greatest brilliance next to the diamond. The colorless stones are called Matura diamonds, and the yellow-red are known as Jacinth. By heating zirconia with carbon a Zirconium carbide,  $ZrC_2$ , is formed, which is a very hard abrasive. Zirconium oxychloride,  $ZrOCl_2 \cdot 8H_2O$ , is a cream-colored powder soluble in water used as a catalyst, in the manufacture of color lakes, and in textile coatings.

**Zirconium.** An elementary metal, symbol Zr, silvery white in color, having a specific gravity of 6.4 and melting point about  $3000^{\circ}F$ . It occurs chiefly in the minerals zircon and baddeleyite. It is more abundant than nickel, but is difficult to reduce to metallic form, as it readily combines with oxygen, nitrogen, carbon, and silicon. Because of its great affinity for oxygen, it is used as an oxygen getter in electric bulbs, and as a corrosion inhibitor in mercury boilers. Molten zirconium at high temperatures gives a brilliant white light, and is used in arc lights for open-air projection photography. Because of the difficulty of extraction, zirconium metal is costly, but it is marketed in the form of bars, wire, sheet, foil, and fine powder. Zirconium cold-rolled sheet with a 60% cold reduction has a tensile strength of 93,000 psi and a Rockwell B hardness 98. It will hold its strength at high temperatures. The metal is not attacked by nitric or sulphuric acid, but is dissolved by hydrofluoric acid. It has been alloyed with nickel for cutting tools and in copper alloys. It does not make copper sluggish as does titanium, and bronze containing zirconium can be poured with ease. Small amounts of zirconium in copper give age-hardening, 1% of zirconium giving a tensile strength of 70,000 psi without appreciably lowering the electrical conductivity of the copper. Zirconium copper is a master alloy used to deoxidize and give hardness and strength to brasses and bronzes. It is marketed in two grades, with 12.5 and 35% zirconium, in bars and lumps. Nickel zirconium is a master alloy used for deoxidizing and adding zirconium to nonferrous alloys, and for degasifying nickel. A nickel-zirconium of the Electro Metallurgical Co. has 40 to 50% nickel, 25 to 30 zir-

conium, 10 aluminum, and a maximum of 10 silicon and 5 iron. Zirconium is also added to steel, and has a powerful deoxidizing action. It also combines with the sulphur and reduces hot-shortness in the steel, and also carries off the nitrogen, making a more ductile steel. Steels can be produced without manganese by the use of zirconium. Zirconium steels with small amounts of residual zirconium have a uniform grain, are ductile, shock-resistant, and fatigue-resistant. When zirconium is present in steel in amounts above 0.15%, it forms zirconium sulphide and aids the rolling. This compound also aids machinability in stainless steels.

Zirconium powder is very reactive, and is stored and shipped in moist condition to be dried just before use. It is also marketed as Zirconium hydride powder of 300 mesh. This powder,  $ZrH_2$ , contains 1.5 to 2% of combined hydrogen which is driven off before use by heating the powder to 300°C. For making sintered metals, alloy powders are used. Zirconium copper, containing 35% Zr, Zirconium nickel, containing 35 to 50% Zr, and Zirconium cobalt, containing 50% Zr, are marketed by the Metal Hydrides, Inc., as alloy powders of 200 and 300 mesh for making sintered parts. Zirconium nickel and Zirconium cobalt are used for making magnet alloys. Zirconium sulphate, a crystalline material containing 30.5%  $ZrO_2$ , has been used for tanning leather to produce very white leathers.

**Zirconium-ferrosilicon.** An alloy of zirconium with iron and silicon, employed for adding zirconium to steel and to special irons. A typical analysis, as given by the Electro Metallurgical Sales Corp., is 9 to 12% zirconium, 40 to 47 silicon, 40 to 45 iron, and 0.20 max carbon. Zirconium deoxidizes the steel, carries off much of the sulphur and nitrogen, and makes a more uniform steel capable of withstanding shocks. When it is desired to add considerable amounts of zirconium without an excessive increase of silicon, a Silicon-zirconium alloy, containing higher percentages of zirconium, is used. These alloys contain from 35 to 40% zirconium, and about 50 silicon, with less than 10 iron. SMZ alloy, of the Electro Metallurgical Co., is a Silicon-manganese-zirconium master alloy used for making high-strength cast iron and reducing chill effects in the iron without leaving residual zirconium in the cast iron. Grade 1 has 72 to 78% silicon, 6 to 8 manganese, 6 to 8 zirconium, and 5 iron. Grade 2 has less alloying elements and 20% iron.

## PART II

### *Elements of Materials Economics*

#### INTRODUCTION

Materials economics, or the procurement and utilization of the raw materials of the world, is a profession, that is, a deductive art. It is a profession founded on positive science, and does not embrace the compromises, expediences, and charlatanisms of social and political economics. Like the true professions, such as medicine, materials economics seeks to eliminate personal opinions and requires basic knowledge of the sciences upon which it depends. The scope of the contributing sciences is wider than for many other professions, and includes mineralogy, botany, metallurgy, agriculture, chemistry, physics, zoology, forestry, and geography. But the materials economist need not be a specialist in any of these any more than the medical doctor need be a chemist. But he must be able to finger the basic elements of all of these as the player learns to finger instinctively the keys of an instrument, to give his best attention to the broader scope of the art.

Behind materials economics in our modern industries, with the thousands of raw materials interlocked in their uses in hundreds of varied industries, there is a host of variables, all of which must be fingered automatically before the engineer or the procurement official can be an artist in his judgments of the broad applications. Industrial materials come from every corner of the world, from minerals and earths, from plant leaves, stems, bark, roots, and from every part of a varied animal life, from the diverse life of the seas, from the air, and from the artificial or synthetic combination of any or all of these.

The materials economist must have an elemental knowledge of science to see why materials act as they do. He must fix in his mind the value of certain physical characteristics because everything is relative and no characteristic will have a tangible meaning unless it compares in his mind with a known characteristic. He must actually handle materials of different kinds, knowing the characteristics by sight and touch. He must know something of the important industries in order to form judgments of the relative values of the materials in use. He must have the economic geography of the world so implanted in his mind that he knows the relative positions of the materials and the trade routes. He must know the important characteristics of the nations that produce and market materials, and the background upon which the supply of their materials depends.

**GEOPHYSICS OF MATERIALS****Formation of Earth Materials**

It is estimated that it took at least 100 billion years for the earth to cool from the time it left the sun to a point where life could be supported. The core of the earth, called the Centrosphere, is still a dense plastic mass, probably largely nickel and iron just as the cores of the meteors that reach the earth are nickel-iron with the other materials burned off in penetrating the atmosphere at high speed. The crust of the earth, called the Lithosphere, and the surface of the water, called the Hydrosphere, are taken arbitrarily as 10 miles thick, and contain 93% solid matter and 7 sea water. The sedimentary rocks and soil are only within the space of a thin veneer, igneous rocks forming at least 95%.

The height of the Atmosphere surrounding the lithosphere and hydrosphere is more than 200 miles above sea level as proved by the phenomena of the aurora borealis and of meteors, but the barometer proves that more than half of the air, by weight, reaches not more than 3.4 miles above sea level. As the distance from the earth increases, the air becomes colder, and because of the swift rotation of the earth the heavier colder air is thrown out in a ring around the equator. Animal and plant life are near the bottom of an atmospheric ocean with the pressure of the air at sea level 14.7 psi. Plant life derives its carbon, and animal life its oxygen, largely from the atmosphere, some of which is again returned to the air. Anaerobe bacteria release oxygen from solid materials. A balance of carbon in the air is maintained partly from volcanoes. The amount of carbon dioxide fixed at all times in the cellulose of plant life is about half the amount in the atmosphere. A considerable amount of metallic and nonmetallic elements falls continuously on the earth in the form of dust from meteorites. About one meteorite per 100 sq mi per year strikes the earth, most of its elements being diffused as hot gases in the air.

The oceans cover 70% of the surface of the earth with an average depth of about 2 miles. The greatest depth is 34,219 ft, in the Pacific Ocean east of the Philippines, at which depth the pressure is more than 7.5 tons per sq in. Water on the land areas sinks to a water table, seeping toward the seas. A few points on the land surface are below sea level, and here any water evaporates. Below the water tables the water gradually disappears until the deep mines are dry and dusty. The water in and on the land areas of the earth, not counting the seas, is equivalent to a sheet of water 225 ft in depth over the continental areas. There is a third as much water underground as there is in all the oceans,

so that a simultaneous cessation of rain on all parts of the earth for even a relatively short period would cause such a rise in the surface of the oceans as to cover all port cities. Actually, because of a balance of precipitation over the land surfaces, the changes in ocean levels have been slight. The volume of common salt in sea water is sufficient to cover the whole surface of the land to a depth of 110 ft.

Temperatures increase below the ground surface at a little more than  $1^{\circ}\text{C}$  for each 100 ft. At 9,000 ft the temperature is theoretically the boiling point of water, but varies at different places. In the gold mines at Bendigo, Australia, the rock temperature at 4,600 ft is  $112^{\circ}\text{F}$  and the water is  $114^{\circ}\text{F}$ . Pressure increases at increasing depths in the earth. At 11 miles it is 70,000 psi, with a temperature of more than  $550^{\circ}\text{C}$ , and at increasing depths the rock is plastic. Through faults in the surface, eruptions can occur at any time, so that relatively new dikes of metal ores may be found in very old formations.

The sway or tipping of the earth in its annual path about the sun, which brings the direct rays of the sun to a point  $23\frac{1}{2}^{\circ}$  north of the equator in June and  $23\frac{1}{2}^{\circ}$  south in December, is responsible for the seasonal climates. These are relatively uniform, because the larger oscillation of the earth which causes the advance and retreat of polar ice is too slow to make perceptible differences, this movement being complete in about 40,000 years. The latest ice age in Europe and North America reached its peak, with an advance of ice to about the latitude of New York City, about 10,000 B.C. The accelerated melting of ice and the migration of forests into England were about 7000 B.C. The slowing of the earth in its rotation is likewise too slow to cause perceptible differences. This slowing is about 15 min every 1,000 years.

### Composition of the Atmosphere <sup>1</sup>

Per cent (by volume)

|                      |          |
|----------------------|----------|
| Nitrogen .....       | 78.03    |
| Oxygen .....         | 20.99    |
| Argon .....          | 0.94     |
| Carbon dioxide ..... | 0.03     |
| Hydrogen .....       | 0.01     |
| Neon .....           | 0.00123  |
| Helium .....         | 0.0004   |
| Krypton .....        | 0.00005  |
| Xenon .....          | 0.000006 |

<sup>1</sup> U.S. Geological Survey.

In addition, the atmosphere is always diluted with varying amounts of water vapor, dust, and smoke.



Relative World Production of Metals<sup>1</sup>

Previous to the World War

| Metal                            | Metric tons, 1938 |
|----------------------------------|-------------------|
| Steel (ingots and castings)..... | 107,000,000       |
| Pig iron and ferroalloys.....    | 92,000,000        |
| Manganese.....                   | 2,500,000         |
| Copper.....                      | 1,984,000         |
| Lead.....                        | 1,704,000         |
| Zinc.....                        | 1,590,000         |
| Aluminum.....                    | 583,000           |
| Chromium.....                    | 350,000           |
| Tin.....                         | 149,000           |
| Nickel.....                      | 110,000           |
| Titanium.....                    | 100,000           |
| Antimony.....                    | 30,000            |
| Magnesium.....                   | 25,000            |
| Tungsten.....                    | 17,500            |
| Molybdenum.....                  | 16,000            |
| Silver.....                      | 9,000             |
| Quicksilver.....                 | 5,200             |
| Zirconium.....                   | 5,000             |
| Cadmium.....                     | 4,000             |
| Vanadium.....                    | 3,150             |
| Cobalt.....                      | 3,000             |
| Gold.....                        | 1,100             |
| Bismuth.....                     | 1,000             |

<sup>1</sup> *Mining and Metallurgy*, September, 1940.

## Average Percentage of Metals in Igneous Rocks

| Metal         | Percentage | Metal                    | Percentage |
|---------------|------------|--------------------------|------------|
| Silicon.....  | .. 27.72   | Rare earths.....         | 0.015      |
| Aluminum...   | .. 8.13    | Copper.....              | 0.010      |
| Iron.....     | .. 5.01    | Tungsten.....            | 0.005      |
| Calcium.....  | .. 3.63    | Lithium.....             | 0.004      |
| Sodium.....   | .. 2.85    | Zinc.....                | 0.004      |
| Potassium...  | .. 2.60    | Columbium, Tantalum..... | 0.003      |
| Titanium..... | .. 0.63    | Hafnium.....             | 0.003      |
| Manganese..   | .. 0.10    | Thorium.....             | 0.002      |
| Barium.....   | .. 0.05    | Lead.....                | 0.002—     |
| Chromium...   | .. 0.037   | Cobalt.....              | 0.001      |
| Zirconium...  | .. 0.026   | Beryllium.....           | 0.001      |
| Nickel.....   | .. 0.020   | Strontium.....           | 0.001—     |
| Vanadium..... | 0.017      | Uranium.....             | 0.001—     |

**Relative Amounts of Engineering Materials<sup>1</sup>**

|                |       |             |    |
|----------------|-------|-------------|----|
| Aluminum.....  | 4,000 | Nickel..... | 10 |
| Iron.....      | 2,200 | Copper..... | 1  |
| Magnesium..... | 1,200 |             |    |

<sup>1</sup> Data from U.S. Geological Survey.**Occurrence of the Elements in the Earth's Crust<sup>1</sup>**

| Element        | Percentage | Element            | Percentage |
|----------------|------------|--------------------|------------|
| Oxygen.....    | 47.0       | Carbon.....        | 0.2        |
| Silicon.....   | 28.0       | Phosphorus.....    | 0.1        |
| Aluminum.....  | 8.0        | Sulphur.....       | 0.1        |
| Iron.....      | 4.5        | Nickel.....        | 0.02       |
| Calcium.....   | 3.5        | Copper.....        | 0.002      |
| Magnesium..... | 2.5        | Lead and Zinc..... | 0.0001     |
| Sodium.....    | 2.5        | Tin.....           | 0.00001    |
| Potassium..... | 2.5        | Silver.....        | 0.000001   |
| Titanium.....  | 0.4        | All others.....    | 0.48       |
| Hydrogen.....  | 0.2        | Total.....         | 100.00     |

<sup>1</sup> Data from U.S. Geological Survey.**Composition of the Sea Water<sup>1</sup>**

The average salt content of the sea is 3.5%, with the salts divided as follows:

|                                      |                |
|--------------------------------------|----------------|
| NaCl .....                           | 77.76 per cent |
| MgCl <sub>2</sub> .....              | 10.88          |
| MgSO <sub>4</sub> .....              | 4.74           |
| CaSO <sub>4</sub> .....              | 3.60           |
| K <sub>2</sub> SO <sub>4</sub> ..... | 2.46           |
| MgBr <sub>2</sub> .....              | 0.22           |
| CaCO <sub>3</sub> .....              | 0.34           |

<sup>1</sup> U.S. Geological Survey.

In addition, sea water carries perceptible quantities of the following: iodine, fluorine, arsenic, gold, silver, rubidium, copper, barium, phosphorus, manganese, lithium, lead, iron, strontium, and zinc. Ammonia is also usually present, together with free oxygen, nitrogen, and other gases, and in some seas hydrogen sulphide is also present. This does not include the mineral and organic materials carried in suspension by the water especially near the mouths of great rivers.

## ELEMENTARY NUCLEAR PHYSICS

### Formation of the Elements

The tangible elementary materials of the earth number 92, ranging from the light gas hydrogen, Atomic No. 1, to the heavy metal uranium, Atomic No. 92, with atomic weights from 1 to 238. These are the same materials that pervade the whole universe, the solar system, stars, and nebulae.

The formation of the elements probably took place simultaneously rather than one by one, that is, within a short period compared with the length of formation of the universe. The enormity of this time can be judged from the fact that our own nebula, the Milky Way, a great wheel-shaped swarm of millions of stars to which our sun and earth belong, takes 240 million years to make one turn, and hundreds of thousands of turns were necessary in order to form the stars and planetary systems as they now exist within it. The enormous distances in space can be seen from the fact that there are millions of these wheel-shaped galaxies similar to the Milky Way, but many larger, within the relatively short space of the reach of a 100-in. telescope, or 500 million light years, one light year being 186,000 times 60 times 60 times 24 times 365 miles. It was estimated that at least 11 billion galaxies come within the reach of the 200-in. telescope. These galaxies are not isolated units, but form super-galaxy units similar to the molecular structure of materials. Our Milky Way, the two Magellanic Star Clouds, the Andromeda group, the Messier galaxy, with others, form one of these super-galaxies, or astronomical molecules.

The fixation, or freezing, of the elements began with the heaviest because the extremely large energy requirement to weld together the nuclei of the atoms of high molecular weight were gradually expended and lessened in the universe. At some distant point of time the universe was contained within a relatively small space with a density billions of times that of water and a temperature billions of times greater than normal earth temperatures. Under these conditions thermonuclear reactions of sufficient energy were possible to produce the atoms of those elements of highest atomic weight, the radioactive elements. At this point of element creation the original massive sphere of extreme density and temperature was expanding at the speed of light and was cooling. As the density and temperature decreased from the birth of uranium, the element of highest atomic weight reasonably stable at present conditions, the elements of lower atomic weights requiring less energy of formation were fixed or frozen. At about the region of nuclear freezing for the element silver, the physical conditions were critical for the freezing of all the elements of atomic weight lower than silver. The temperature at this point has

been calculated as about 6 billion degrees centigrade, and the density perhaps 10 billion times that of water.

Since that time, myriads of millions of years ago, the universe has continued to expand into the incomprehensible limits of space. Hydrogen remains as the element of lowest atomic weight. Any elements below hydrogen would be relatively intangible under present conditions in the universe. All of the elements of atomic weight above uranium are very unstable at present conditions in the universe, and uranium itself and the other radioactive elements are relatively unstable and are slowly breaking down. The original energy of formation of the elements, estimated in uranium to be 5 million volts, remains pent up in the nuclear formation of the atoms. The artificial breaking of the atoms releases this energy. The artificial creation of transuranic elements, or elements with atomic weights above uranium, by the expenditure of energy on the uranium atom to increase its atomic weight, produces elements that are very unstable in the present conditions of the universe. Thus, plutonium, Atomic No. 94, made from uranium by cyclotron electronic bombardment, disintegrates relatively slowly, or can be made to disintegrate instantaneously with tremendous violence. Elements above plutonium are still more unstable.

### Elementary Structural Units of Materials

All **Material** is built up from four fundamental particles: the **Proton**, the **Neutron**, and the negative and positive **Electron**. There is apparently also another particle, the little neutron, or **Neutrino**, which is supposed to be the original tangible building unit. These particles are originally built up from the various **Rays** given off by all materials and reassembled into materials under given conditions and passing back and forth, to and from materials, at all times, and in all space. The **Photon** is a particle assumed in the theory of light. Its mass is a constant times the frequency of the light. When the energy of the photon is high it is designated as a  $\gamma$  ray (gamma ray).

The units used in the chemical assembly of material are as follows:

**Element.** A substance composed of molecules with atoms all alike.

**Compound.** A substance with molecules alike but atoms dissimilar.

**Mixture.** A material with dissimilar molecules not chemically combined.

**Solution.** A mixture, either liquid or solid, which is homogeneous.

**Molecule.** Two or more atoms united to form a material dissimilar to the original atoms.

**Atom.** The smallest particles of an element still retaining the characteristics of the element, which cannot be broken up by chemical means.

**Ion.** A part of a molecule bearing one or more electric charges.

## The Elements

| Name       | Atomic<br>number | Symbol | Atomic<br>weight<br>O = 16.0000 | Melting<br>point,<br>deg. C. |
|------------|------------------|--------|---------------------------------|------------------------------|
| Actinium   | 89               | Ac     | .....                           | 1800                         |
| Alabamine  | 85               | Am     | .....                           | 470                          |
| Aluminum   | 13               | Al     | 26.97                           | 660.0                        |
| Antimony   | 51               | Sb     | 121.76                          | 630.5                        |
| Argon      | 18               | A      | 39.944                          | -189.3                       |
| Arsenic    | 33               | As     | 74.91                           | 814                          |
| Barium     | 56               | Ba     | 137.36                          | 704                          |
| Beryllium  | 4                | Be     | 9.02                            | 1280                         |
| Bismuth    | 83               | Bi     | 209.00                          | 271.3                        |
| Boron      | 5                | B      | 10.82                           | 2300                         |
| Bromine    | 35               | Br     | 79.916                          | -7.2                         |
| Cadmium    | 48               | Cd     | 112.41                          | 320.9                        |
| Calcium    | 20               | Ca     | 40.08                           | 850                          |
| Carbon     | 6                | C      | 12.00                           | 3700                         |
| Cerium     | 58               | Ce     | 140.13                          | 600                          |
| Cesium     | 55               | Cs     | 132.91                          | 28                           |
| Chlorine   | 17               | Cl     | 35.457                          | -101                         |
| Chromium   | 24               | Cr     | 52.01                           | 1800                         |
| Cobalt     | 27               | Co     | 58.94                           | 1490                         |
| Columbium  | 41               | Cb     | 92.91                           | 2000                         |
| Copper     | 29               | Cu     | 63.57                           | 1083.0                       |
| Dysprosium | 66               | Dy     | 162.46                          |                              |
| Erbium     | 68               | Er     | 167.64                          |                              |
| Europium   | 63               | Eu     | 152.0                           |                              |
| Fluorine   | 9                | Fl     | 19.00                           | -223                         |
| Gadolinium | 64               | Gd     | 157.3                           |                              |
| Gallium    | 31               | Ga     | 69.72                           | 29.78                        |
| Germanium  | 32               | Ge     | 72.60                           | 958                          |
| Gold       | 79               | Au     | 197.2                           | 1063.0                       |
| Hafnium    | 72               | Hf     | 178.6                           | 1700                         |
| Helium     | 2                | He     | 4.002                           | -271.4                       |
| Holmium    | 67               | Ho     | 163.5                           |                              |
| Hydrogen   | 1                | H      | 1.0078                          | -259.2                       |
| Illinium   | 61               | Il     | 140.0                           |                              |
| Indium     | 49               | In     | 114.76                          | 156.4                        |
| Iodine     | 53               | I      | 126.92                          | 114                          |
| Iridium    | 77               | Ir     | 193.1                           | 2454                         |
| Iron       | 26               | Fe     | 55.84                           | 1535                         |
| Krypton    | 36               | Kr     | 83.7                            | -157                         |
| Lanthanum  | 57               | La     | 138.92                          | 826                          |
| Lead       | 82               | Pb     | 207.22                          | 327.4                        |
| Lithium    | 3                | Li     | 6.940                           | 186                          |
| Lutecium   | 71               | Lu     | 175.0                           |                              |
| Magnesium  | 12               | Mg     | 24.32                           | 650                          |
| Manganese  | 25               | Mn     | 54.93                           | 1260                         |
| Masurium   | 43               | Ma     | 97.8                            | 2300                         |
| Mercury    | 80               | Hg     | 200.61                          | -38.87                       |
| Molybdenum | 42               | Mo     | 96.0                            | 2625                         |
| Neodymium  | 60               | Nd     | 144.27                          | 840                          |
| Neon       | 10               | Ne     | 20.183                          | -248.6                       |

## The Elements.—(Continued)

| Name          | Atomic<br>number | Symbol | Atomic<br>weight<br>O = 16.0000 | Melting<br>point,<br>deg. C. |
|---------------|------------------|--------|---------------------------------|------------------------------|
| Nickel        | 28               | Ni     | 58.69                           | 1455                         |
| Nitrogen      | 7                | N      | 14.008                          | -210.0                       |
| Osmium        | 76               | Os     | 191.5                           | 2700                         |
| Oxygen        | 8                | O      | 16.0000                         | -218.8                       |
| Palladium     | 46               | Pd     | 106.7                           | 1554                         |
| Phosphorus    | 15               | P      | 31.02                           | 44.1                         |
| Platinum      | 78               | Pt     | 195.23                          | 1773.5                       |
| Polonium      | 84               | Po     |                                 | 1800                         |
| Potassium     | 19               | K      | 39.096                          | 63                           |
| Praseodymium  | 59               | Pr     | 140.92                          | 940                          |
| Protoactinium | 91               | Pa     | 231                             |                              |
| Radium        | 88               | Ra     | 226.05                          | 700                          |
| Radon         | 86               | Rn     | 222                             | -71                          |
| Rhenium       | 75               | Re     | 186.31                          | 3000                         |
| Rhodium       | 45               | Rh     | 102.91                          | 1966                         |
| Rubidium      | 37               | Rb     | 84.44                           | 39                           |
| Ruthenium     | 44               | Ru     | 101.7                           | 2450                         |
| Samarium      | 62               | Sm     | 150.43                          | 1300                         |
| Scandium      | 21               | Sc     | 45.10                           | 1200                         |
| Selenium      | 34               | Se     | 78.96                           | 220                          |
| Silicon       | 14               | Si     | 28.06                           | 1430                         |
| Silver        | 47               | Ag     | 107.880                         | 960.5                        |
| Sodium        | 11               | Na     | 22.997                          | 97.7                         |
| Strontium     | 38               | Sr     | 87.63                           | 770                          |
| Sulphur       | 16               | S      | 32.06                           | 119.2                        |
| Tantalum      | 73               | Ta     | 180.88                          | 3000                         |
| Tellurium     | 52               | Te     | 127.61                          | 450                          |
| Terbium       | 65               | Tb     | 159.2                           | 327                          |
| Thallium      | 81               | Tl     | 204.39                          | 300                          |
| Thorium       | 90               | Th     | 232.12                          | 1700                         |
| Thulium       | 69               | Tm     | 169.4                           |                              |
| Tin           | 50               | Sn     | 118.70                          | 231.9                        |
| Titanium      | 22               | Ti     | 47.90                           | 1820                         |
| Tungsten      | 74               | W      | 184.0                           | 3410                         |
| Uranium       | 92               | U      | 238.14                          | 1850                         |
| Vanadium      | 23               | V      | 50.95                           | 1735                         |
| Virginium     | 87               | Vi     |                                 |                              |
| Xenon         | 54               | Xe     | 131.3                           | -112                         |
| Ytterbium     | 70               | Yb     | 173.04                          | 1500                         |
| Yttrium       | 39               | Y      | 88.92                           | 1490                         |
| Zinc          | 30               | Zn     | 65.38                           | 419.5                        |
| Zirconium     | 40               | Zr     | 91.22                           | 1700                         |

The new names proposed for the elements Alabamine, Masurium, and Virginium by the scientists who first synthesized them by cyclotronic bombardment of adjacent elements are: Astatine, Technetium, and Francium, respectively.

## ELEMENTARY GEOLOGY OF MATERIALS

### Formation and Location of Minerals

Geology and mineralogy are the sciences in which is tabulated the fundamental knowledge of the history and resources of the minerals of the earth. The two billion years represented in the five geologic eras are only a small part of the life span of the earth. It does not extend back to the time when the earth was molten, but only includes the time when the earth was not significantly different in material structure than at present, that is, to little beyond the point when there appeared the first traces of life, which point is well within the period of the fixing of the present elemental materials.

A geologist is a historian whose archives and written documents are the rocks and formations of the earth. The mineralogist is one who tabulates the elemental materials that are in the rocks and earths, and designates those which are ores, or from which materials may be extracted commercially. But to a geologist a rock or earth formation is a page from the earth's autobiography. The changes which took place, and the approximate length of time during which changes occurred, are determined by study of the types of formations and their relative size and positions, the animal and plant life as seen in fossil remains, and by the disintegration by erosions and by radioactive elements in the rocks. Geology is thus not an academic science, as the practical geologist can trace the probable location of metallic ores, petroleum, coals, and nonmetallic minerals.

There are three main types of rocks: igneous, sedimentary, and metamorphic. The igneous are the mother rocks which have carried all non-organic mineral products from the original molten condition in the depths of the earth. Sedimentary rocks are the deposits from erosion of older rocks and from the deposits of organic matter. Metamorphic rocks are both igneous and sedimentary rocks which have been changed by intense heat and pressure within geologic times. They include the different chemical and physical changes caused by the upheavals in the earth's crust.

Compared to the amount of rock which makes up the crust of the earth, the percentage of mineral deposits that are rated as metallic ores is small. These deposits are found near large igneous intrusions, where they have formed from the molten rock as it cooled and crystallized, or from hot gases or hot aqueous solutions that came from the magma, and also at points of contact with other rocks into which the hot magma forced its way. Deposits may also be found in sedimentary rocks where they came from precipitates from the seas and from beds of decayed plant life.

The elements have played an important role in the concentration of minerals. These elements include the periods of high humidity and violent rainfall and of periodic advance and regression of polar ice, as well as the normal erosion through the ages. During erosion, water may enrich natural deposits by dissolving out and carrying away soluble impurities, or it may form new ore veins by depositing mineral matter in the cracks of rocks as it seeps through. It may carry nonsoluble minerals, such as gold or gemstones, to placer deposits freeing them of all soluble content. Air has oxidized some materials near the surface, changing them to the alteration ores. Winds have formed some deposits of heavier materials by sifting out the softer ingredients.

Geology thus determines that mineral deposits of one type are likely to occur in rocks of one age or in deposits of certain types. It traces placers back to the original deposit. From the geologic formation it determines the probable size and depth of a deposit. From the folds of the strata it may determine where a continuation of the deposit is likely to occur in another area.

### Definitions Relating to Minerals

**Amorphous.** Without definite structure.

**Alluvium.** Fine material or sediment deposited by streams.

**Breccia.** Fragmental rock with angular components.

**Calcareous.** Containing sufficient calcium carbonate to effervesce visibly when treated with hydrochloric acid.

**Caliche.** Cemented deposits of calcium carbonate materials.

**Colloid.** Small particle size and high surface area per unit of mass. Colloid solutions are dispersed in particle state, not in molecular state like true solutions.

**Concretions.** Local concentrations of minerals in other minerals.

**Detritus.** Heterogeneous mass of fragments of stone.

**Friable.** Easily crumbled in the fingers.

**Ferruginous.** Iron-bearing materials usually containing iron oxides.

**Igneous.** Rocks produced by the cooling of melted material. Those solidified beneath the surface are Intrusive rocks, or Magma. Those which flowed out and cooled on the surface are Extrusive rocks. Volcanic rocks are recent extrusive rocks, but may be similar to ancient igneous rocks.

**Marl.** Earthy crumbly deposit, chiefly of calcium carbonate and clay.

**Tufa.** A porous rock formed as a deposit from springs or streams.

**Tuff.** Rock composed of the finer kinds of volcanic detritus.



Two Billion Years of Earth History<sup>1</sup>

| Geologic time |               | Events                                                                                                                                                                         | Rocks and economic products                                                                                                                                                                                                                                                                                                                     | Life                                                    |
|---------------|---------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------|
| Archeozoic    | Pre-Cambrian  | Erosion and deposition. Vulcanism, folding of land                                                                                                                             | Conglomerates, shales, limestone, aqueous iron ore granites (for building), graphite (Canada), garnets (New Eng.)                                                                                                                                                                                                                               | No evid. of life                                        |
|               |               | Erosion and shallow seas. Vulcanism, glaciers, retreat of ice and uplift of lands                                                                                              | Sandstones (quartzite), limestone (marble) for building, black shale (carbonaceous slate and graphite), igneous rocks—cobalt, nickel, iron, copper, silver, gold ores—Sweden, Brazil, and Great Lakes area. Gold from Australia                                                                                                                 | First trace of life—marine                              |
| Paleozoic Era | Cambrian      | Erosion, spread of shallow seas, uplift of land                                                                                                                                | Conglomerates, sandstones (quartz schist)—No. Central Am. shales (slate), limestone (marble), barite—So. and S.E. America                                                                                                                                                                                                                       | Much sea life                                           |
|               | Ordovician    | Submergence of No. America. Vulcanism in N.W. Europe, So. America, China, Australia. Rise of mts. in E. No. America and W. Europe                                              | Sandstones and shales with zinc and lead ores, oil and gas in W. and Central U.S.A.; limestones, dolomite, manganese, calcium phosphate in E. and Central U.S.A. Shales, sandstones, and igneous rocks in Europe                                                                                                                                | Invertebrates                                           |
|               | Silurian      | Highlands eroded, clear seas and evaporation, volcanoes and folding—No. Europe to No. Africa, Greenland to No. America                                                         | Conglomerates, sandstone, shale with iron ore, oil, gas in East Interior U.S.A.; limestone, rock salt, gypsum in Central U.S.A., limestone in Europe. Igneous rocks and metamorphism                                                                                                                                                            | Fishes, early plants                                    |
|               | Devonian      | Worldwide erosion and seas. Vulcanism in Asia, So. America, Europe. Uplift in East No. Am. and West Europe at close                                                            | Limestones, sandstones with oil and gas in Ontario, Texas, Penn., and N.Y.S.; black shale—black phosphates in Tenn. Igneous intrusions in sediments give ores of iron, tin, copper in England and Europe                                                                                                                                        | Amphibians, ferns, forests                              |
|               | Mississippian | Wide, clear seas in No. Am. Swamps in Europe; waters evaporate. Erosion of highlands in Europe and America                                                                     | Limestones—zinc, lead ores—Interior U.S.A., sandstones and shales—iron ores, oil, gas in Appalachian lowlands, sediments with coal beds—Moscow, Donets areas, Ural Mts. Gypsum, salt, sulphur, bromine—Central U.S.A., Europe                                                                                                                   |                                                         |
|               | Pennsylvanian | Slight worldwide uplift. Swamps and shallow seas in Europe, Asia, and No. America. First rise of Appalachian and Hercynian Mts.                                                | Alternating shales, sandstones, limestones with barite, iron ore, and coal beds in Asia, West Europe, E. No. America, So. Brazil, Africa. Red sandstones with oil and gas in Central U.S.A. Limestone in Russia                                                                                                                                 | Many plants, early reptiles                             |
|               | Permian       | Continued seas in Asia. Oscillating and evaporating seas in Eur. & No. Am. Swamps in Australia. Final rise of Appal. and Hercynian Mts. glaciation                             | Dolomite limestone in Russia. Black shale with copper ore, barite in Germany. Coal beds in Australia. Red sandstone and limestone, gypsum, salt, magnesium, and potassium salts, potash in Central U.S.A. and W. Eur. Igneous and metamorphic rocks—ore veins and deposits                                                                      | Many reptiles, cold ends most life                      |
|               | Triassic      | Retreat of ice and erosion. Vulcanism in East No. Am. Shallow seas, salt lakes, and deserts, evaporating waters in Europe and No. America                                      | Igneous rocks in red sandstones, metamorphism of shales and sandstones—feldspar, mica, copper, and iron ores. Source of diamonds in Africa. Oil and gas and copper ores in Rky. Mt. area. Salt, gypsum in Eng. and West No. Am. Limestone and coal—Sweden, So. Am., and U.S.A.                                                                  | Early mammals, insects                                  |
|               | Jurassic      | Sea invades Europe, Asia, and West America. Volcanoes in No. America. Initial uplift of mts. on W. Am. coasts                                                                  | Limestones in Texas, Mexico, England. Lithographic stone in Germany. Brown sandstones for building in East U.S.A. Coal in Hungary, Caucasus, Persia, Far East. Igneous and metamorphic rocks—ore veins—West U.S.A.                                                                                                                              | Reptiles dominant, first birds                          |
|               | Cretaceous    | Erosion of land, swamps, and flooding in No. America. Worldwide spread of seas. Worldwide uplift of land. Intense vulcanism and rise of Rocky Mts., Andes. No glacier          | Sandstones—coal, oil, gas—Mid. and West U.S.A. and Canada. Clays in New Jersey, England, Belgium, Germany. Lignite, iron ore, potassium iron silicate on E. coast Am. Chalk in England, No. France, West U.S.A. Phosphates, lead, and zinc ores from limestones in Mex., Africa, Asia, So. Eur. Gold, copper, and silver ores in West Am.       | Flowering plants, modern insects, end of large reptiles |
| Cenozoic Era  | Tertiary      | Shallow coast seas in Am. Erosion, swamps, volcanoes in Central No. Am. Seas in Eur., Asia, and Africa. Lands rise, Alps, Himalayas, Caucasus, Pacific coast ranges of America | Clays, sands, lignite—East Am. coast. Phosphates of Florida. Oil, coal in N.W. Am. and Alaska. Salt and gypsum in U.S.A. and Paris basin. Limestones in Europe, Sahara, W. Indies. Igneous and metamorphic rocks—gold, silver, copper, arsenic, tellurium, antimony, borates, lead zinc ores, mercury—West U.S.A., Hungary, Mexico, New Zealand | Grasses, fruits, Anthropoids, height of large mammals   |
|               | Quaternary    | Greatest glaciation. Land rises with retreat of ice. Present geography—erosion                                                                                                 | Loess—carbonates, silicates, magnetite, quartz in Missouri River Basin, Asia. Gypsum in Interior U.S.A.                                                                                                                                                                                                                                         | End of large mammals. Man                               |

<sup>1</sup> From J. B. Moulton.

## FUNDAMENTALS IN THE PRODUCTION OF PLANT AND ANIMAL MATERIALS

### Determining Factors in the Production

About 55% of the land area of the earth is less than 1,500 ft above sea level, and another 18% is between 1,500 and 3,000 ft. The remaining area consists of mountains above 3,000 ft. The lands below 3,000 ft are in general the most productive in agricultural, forestal, and animal products because of the climate and better soil. But large areas of the low flatlands are in the colder climates of northern Canada and Russia with short growing seasons, or in the sandy or alkaline deserts of Asia, Arabia, Africa, Australia, and Patagonia, where production is low and restricted.

Climatic temperatures and humidity, that is, the amount of moisture in the air, are important elements in the productivity of a region. Climate in the various zones of the earth may be considered as relatively uniform as far as the earth's movement is concerned. But climates vary because of drifting air masses, and gradual to-and-fro shifting of great ocean currents. The normally fertile plains of the United States, for example, may be subjected to heavy rain precipitation when moist tropical air from the Gulf of Mexico collides with dry polar air from the western Canadian plains, or there may be periods as long as four months with no rain. Little tabulated data are yet available on the shift of ocean currents. It is believed that the to-and-fro shift of the Gulf Stream in the Atlantic Ocean makes a cycle of about a century with a notable effect on the climate of the Eastern states in that time.

Soil is a most important element of productivity. Although soils of great alkalinity are useful for producing some plants, they are a detriment to others. Acid soils will not produce some crops well, such as corn. Lack of various minerals in the soil will retard or stunt the growth of plants. Phosphorus, calcium, sulphur, boron, and other minerals must be added to the soils to produce the plants that need them. The absence of one mineral in the soil may sometimes prevent normal growth of a plant. Phosphorus, for example, is required for the production of the double sugar molecule in beets and cane. Even when the soil conditions are right, plants grown in an atmosphere deficient in carbon dioxide will be deficient in starch. The structure and color of plants, and of the animals that feed on them, may be altered if the soil lacks iron, copper, or other essential minerals. The rarer elements, such as rubidium, are sometimes required to produce some plants. Average land of good farming quality contains, per acre in 7 in. of surface, about 1 ton of nitrogen, 1 ton phosphoric acid, 10 to 20

tons potash, 5 to 10 tons lime, 4 to 5 tons magnesia, and  $\frac{1}{4}$  ton sulphur. If not covered with grass this plant food is washed out by erosions.

Temperature has an important effect upon the growth of plants and animals, and equality of tabulated mean annual temperatures is not always an indication of equality of climate. Thus, corn does not grow well if the nights are cold during a part of the growing season, though the average temperature may be the same as in the corn belt. The same species of fish will be less oily and yield less oil in warm waters than in cold waters. Oil seeds grown in hot climates tend to have more of the saturated fatty acids while those of cooler climates have increased contents of the unsaturated fatty acids such as linolenic.

While the climate and soil set limits to what can be cultivated, the characteristics of the people who inhabit the region affect the use of the land. On the subhumid fertile neutral soils of India the natives raise cotton, while on similar areas in Africa the Buganda natives raise cattle, and on the same type of soil and with similar climatic conditions the white inhabitants of Northeastern Australia raise wheat. Another diversion from the climatic pattern is the availability of markets. In a belt across lower Brazil and Paraguay citrous fruits grow to the highest quality in superabundance with little or no effort and vast tonnages go to waste, while these fruits are cultivated with difficulty within areas in the United States not ideal for a tropic plant because a ready market is available.

Vegetable and animal materials can normally be produced most economically where soil and climatic conditions suit their development, but they are often produced in less economic regions because of nearness of markets or for political reasons. Sometimes high tariffs are imposed to bring the cost of the foreign material to a point as high as the cost of the material produced in the less economic region.

Forests cover about 22% of the land area of the earth. Of this  $71\frac{1}{2}$  billion acres, 28% is in Asia, 28 in South America, 19.3 in North America, 10.6 in Africa, 10.3 in Europe, and 3.8 in Australia and Oceania. In the United States nearly 25% of the land is in forest, compared with 5.4 in Great Britain, 18 in France, and 27 in Germany where rigid laws have protected the forests. Wooded areas act as windbreaks, and also serve to balance atmospheric conditions and retain moisture in the soils. The ideal condition is not extensive wild forests, but well-proportioned forest areas on farms and plantations.

The conifers, or so-called softwoods, comprise 35.4% of the total forest area. Tropical hardwood forests cover about the same percentage of area. Most of the conifers are in the North Temperate Zone. About 27% of the land area of North America is forest, of which 72% is

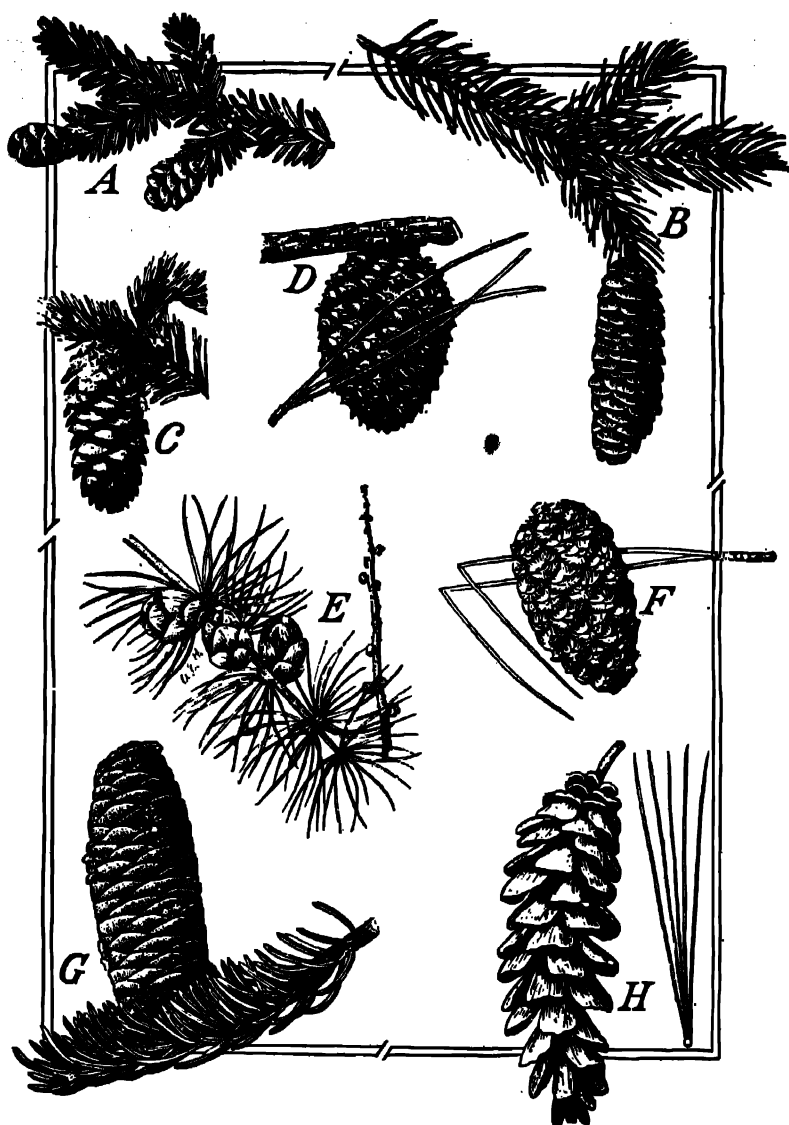
composed of conifers. In the United States 62% of the forest is coniferous and nearly 38% temperate climate hardwoods. The northern part of the continent is predominantly coniferous with evergreen trees from Newfoundland to Alaska bordering the treeless Arctic tundra. The United States has the greatest variety of commercial woods of any of the temperate areas of the world, with more than 100 species of considerable commercial importance compared with less than 15 in Europe.

Although the breed or type of animal normally distinguishes the nature of the product derived from it, animal products also vary with the climate and the local feed available. Goats feeding in the semiarid regions of north-central Argentina furnish skins that make firmer and stronger leather than that produced from skins of the same type of goat feeding on the rich pampas. Some breeds of sheep yield soft wool while others yield wiry wool, and some breeds yield more and better meats, but climate and feeding may vary all of these. Cattle grown on semiarid ranges may be shifted at a certain age to richer grasslands for development before marketing. The overfed hogs of the prairies of the United States and Argentina yield more than twice the amount of lard obtained from the hogs grown in Canada for bacon. The semiwild hogs of the cold and impoverished districts of North China are notable for heavy bristles and for tough skins for leather.

### Classification and Naming of Plants

**Species** is a unit of classification, but is not a single plant type. It is a concept of a group of individual plants having certain essential characters in common. Thus, all oaks recognized as white oak constitute the species *Quercus alba*. In plant cultivation species are subdivided into smaller groups known as Varieties, and these into Subvarieties, Forms, and Strains, which may differ only in minor characteristics such as color of the flower.

**Genus**, plural Genera, is a group of related species. Thus, the plants recognized as constituting species of white oak, red oak, etc., belong to the genus *Quercus*. The chief structure of a genus is the flower and some other organs of the plant. **Family** is a group of similar and related genera. Thus, the oak genus *Quercus*, the chestnut genus *Castanea*, and the beech genus *Fagus* constitute the family *Fagaceae*. **Order** is a group of related families. Thus, the oak and the beech and the hazel constitute the order known as *Fagales*. **Class** is a group of related orders having several outstanding characteristics in common. **Subdivision** is a group of related classes resembling each other in some characteristics. **Division** is the highest general grouping of the Kingdom of plants, each division having a common general similarity such as seed plants, mosses, and fungi.



Softwood trees of the Northern Forest Region, characteristic cones and leaves.

A. Eastern hemlock

B. White spruce

C. Red spruce

D. Pitch pine

E. Tamarack

F. Red pine, Norway pine

G. Balsam fir

H. Northern white pine

From U.S. Department of Agriculture.

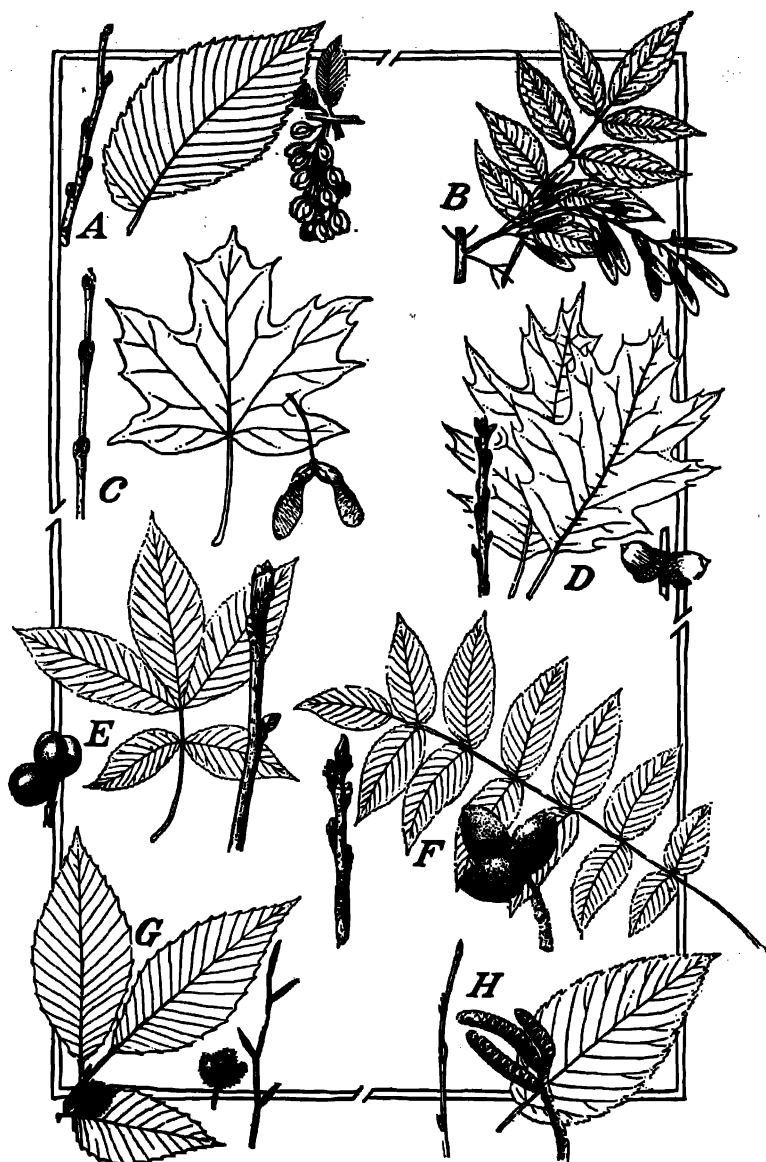


Softwood trees of the Southern Forest Region, characteristic cones and leaves.

- A. Spruce pine
- B. Southern cypress
- C. Southern white cedar
- D. Longleaf pine

- E. Loblolly pine
- F. Shortleaf pine
- G. Slash pine
- H. Pond pine

From U.S. Department of Agriculture.



Hardwood trees of the Northern Forest Region, characteristic leaves, fruit, and twigs.

A. American elm

B. White ash

C. Sugar maple

D. Northern red oak

E. Pignut hickory

F. Butternut

G. Beech

H. Black birch, Sweet birch

From U.S. Department of Agriculture.



Hardwood trees of the Southern Forest Region, characteristic leaves, fruit, or flowers.

- A. Water oak
- B. Live oak
- C. Winged elm
- D. Red gum

- E. Swamp cottonwood
- F. Swamp black gum
- G. Tupelo gum
- H. Overcup oak

From U.S. Department of Agriculture.



### Relative Percentages of Vegetable and Animal Oils and Fats Used in the United States

Total annual use, 10,000,000 short tons

| Fat or oil                    | Per cent | Fat or oil           | Per cent |
|-------------------------------|----------|----------------------|----------|
| Butter.....                   | 23.6     | Tung oil.....        | 1.1      |
| Lard.....                     | 16.9     | Olive oil.....       | 1.1      |
| Cottonseed oil.....           | 14.4     | Whale oil.....       | 0.9      |
| Tallow.....                   | 9.8      | Peanut oil.....      | 0.8      |
| Coconut oil.....              | 6.2      | Castor oil.....      | 0.8      |
| Linseed oil.....              | 5.7      | Babassu oil.....     | 0.7      |
| Soybean oil.....              | 4.5      | Perilla oil.....     | 0.5      |
| Grease.....                   | 3.8      | Oiticica oil.....    | 0.2      |
| Palm oil.....                 | 3.2      | Palm kernel oil..... | 0.1      |
| Fish and fish-liver oils..... | 2.6      | Wool grease.....     | 0.1      |
| Corn oil.....                 | 1.6      | Sesame oil.....      | 0.1      |
| Oleo and oleo stearin.....    | 1.1      | Rape oil.....        | 0.1      |
|                               |          | Teaseed oil.....     | 0.1      |

Less than 0.1 per cent each: Neatsfoot oil, Hempseed oil, Vegetable tallow, Kapok oil, Sunflower oil, Grapeseed oil, Candlenut oil, Walnut oil, Butea oil.

### World Production of Some Non-Mineral Materials \*

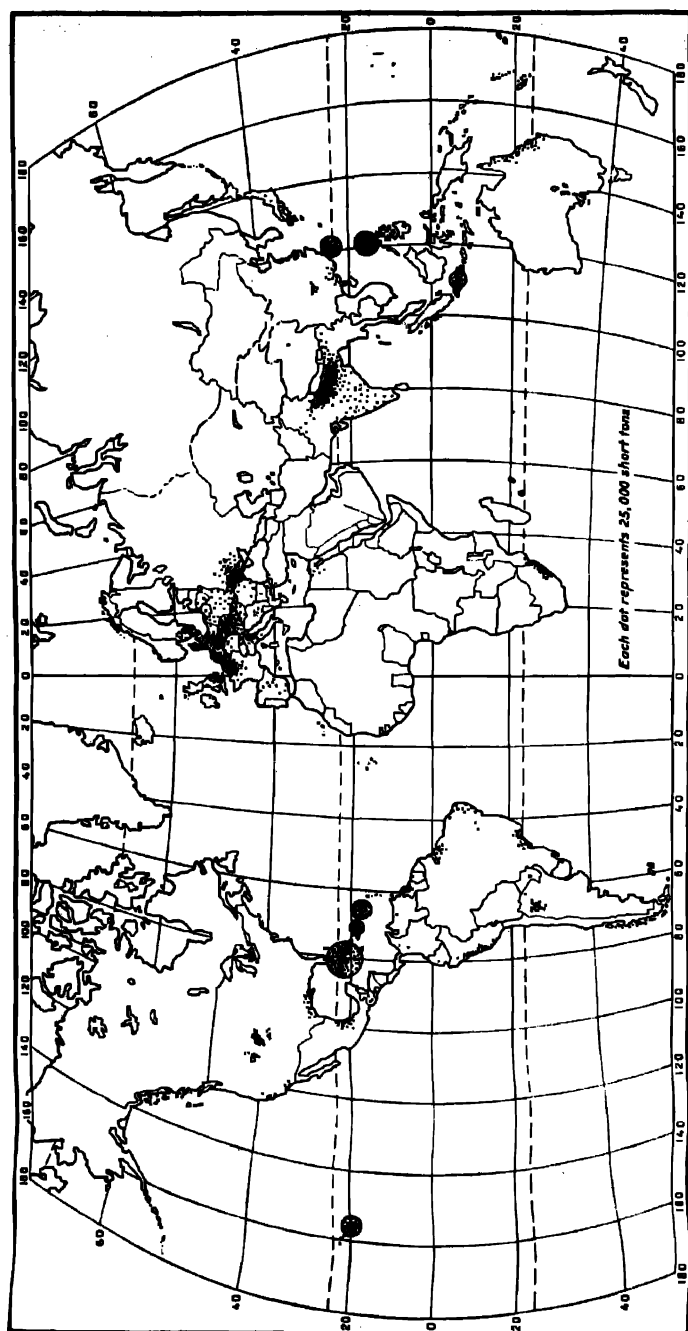
Prewar 1937-1939 annual average except as otherwise noted

| Commodity           | Amount                    | Per cent produced in U.S. |
|---------------------|---------------------------|---------------------------|
| Corn.....           | 5,020,000,000 bu. (1940)  | 49                        |
| Barley.....         | 2,149,400,000 bu.         | 16.3                      |
| Linseed.....        | 8,500,000,000 lb. (1940)  | 20.6                      |
| Oats.....           | 4,810,000,000 bu. (1942)  | 28.2                      |
| Cocoa beans.....    | 1,599,400,000 lb.         | none                      |
| Coffee.....         | 3,560,000,000 lb. (1941)  | none                      |
| Coconut oil.....    | 1,855,800,000 lb.         | 15 †                      |
| Tung oil.....       | 301,000,000 lb. (1940)    | 1.7                       |
| Hog bristles.....   | 12,000,000 lb.            | 0.01                      |
| Cascia.....         | 165,347,000 lb. (1939)    | 24.7                      |
| Lard.....           | 4,400,000,000 lb. (1938)  | 39.3                      |
| Manila fiber.....   | 339,000,000 lb.           | none                      |
| Cattle hides.....   | 98,260,000 units (1941)   | 18.2                      |
| Carnauba wax.....   | 14,000,000 lb.            | none                      |
| Jute.....           | 1,615,000 lg. tons (1942) | none                      |
| Mahogany.....       | 28,675,000 bd. ft.        | none                      |
| Cottonseed oil..... | 4,256,000,000 lb. (1940)  | 29.9                      |
| Corn oil.....       | 325,555,000 lb. (1939)    | 46.2                      |

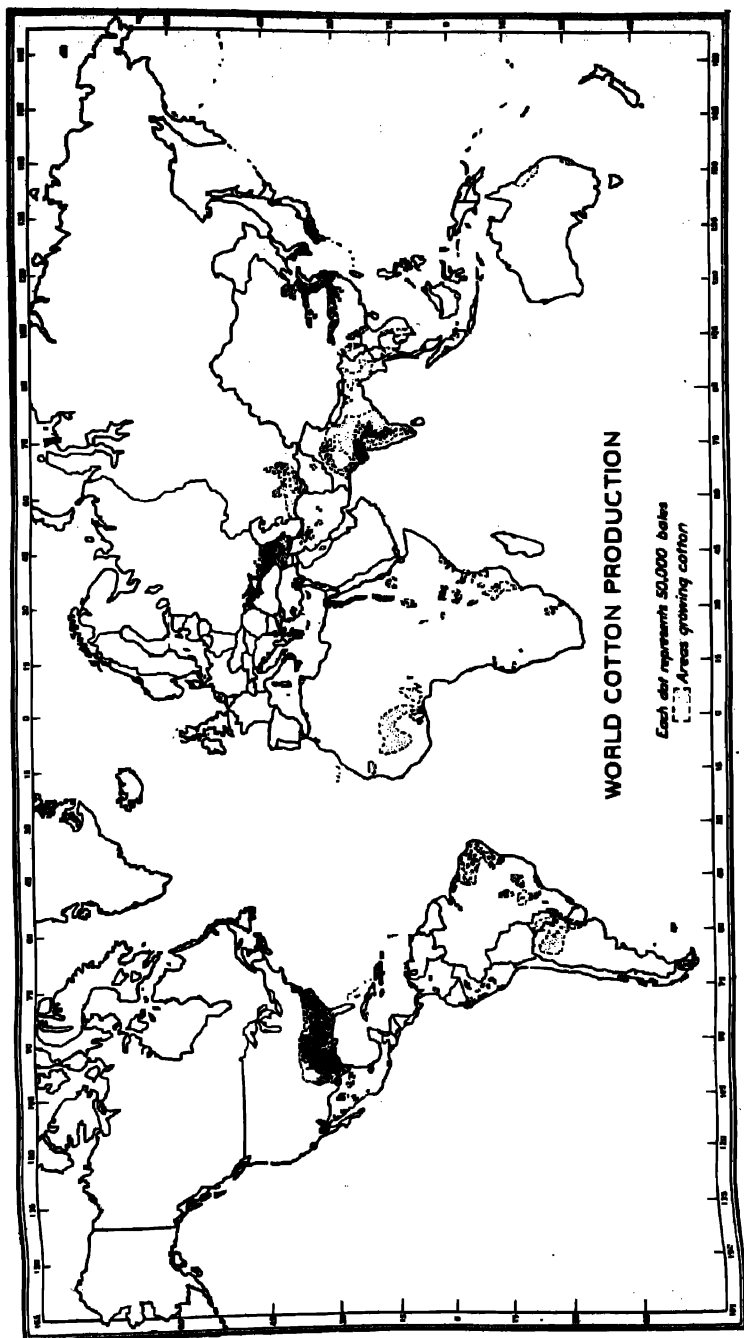
\* All figures from U.S. Department of Commerce.

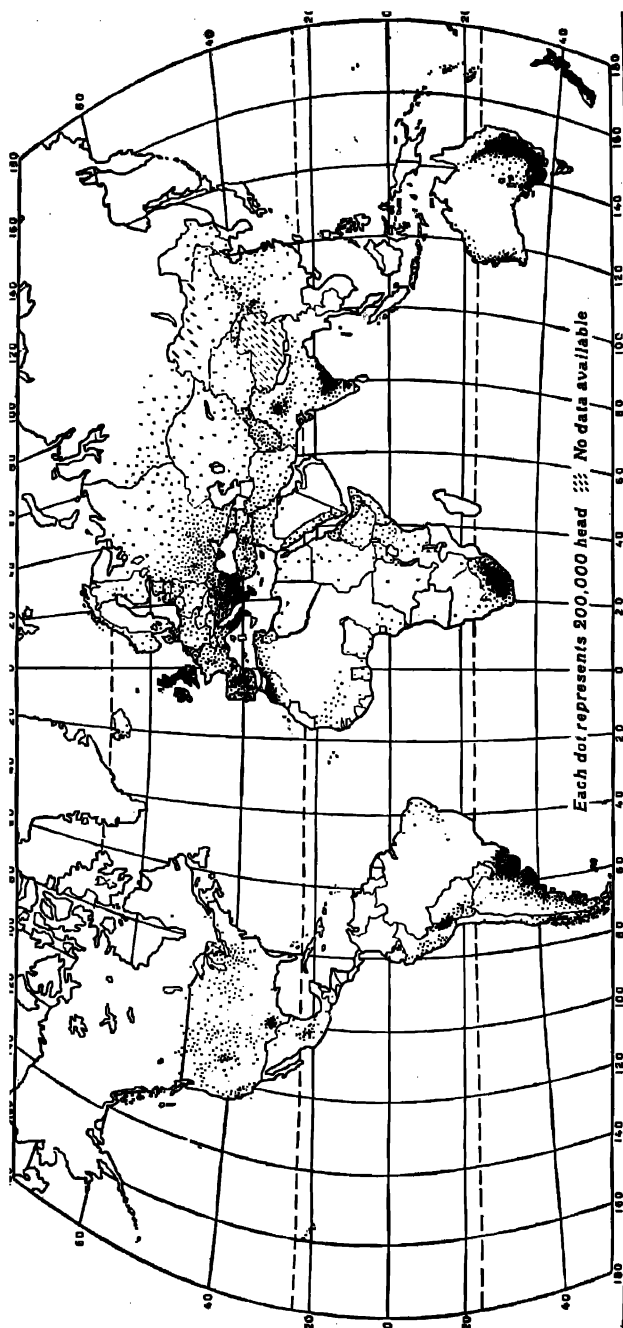
† From foreign copra.



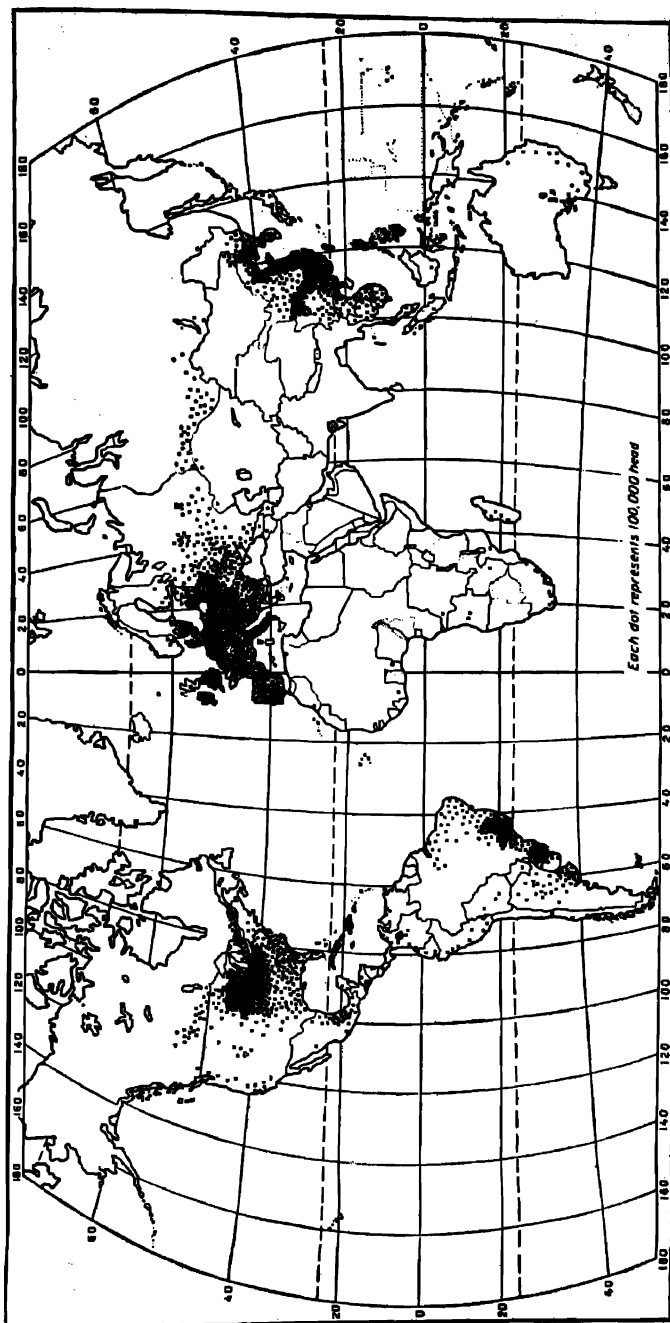


World sugar-producing areas. Products: edible sugar, edible molasses, industrial molasses, ethyl alcohol, rum, bagasse, beer pulp.

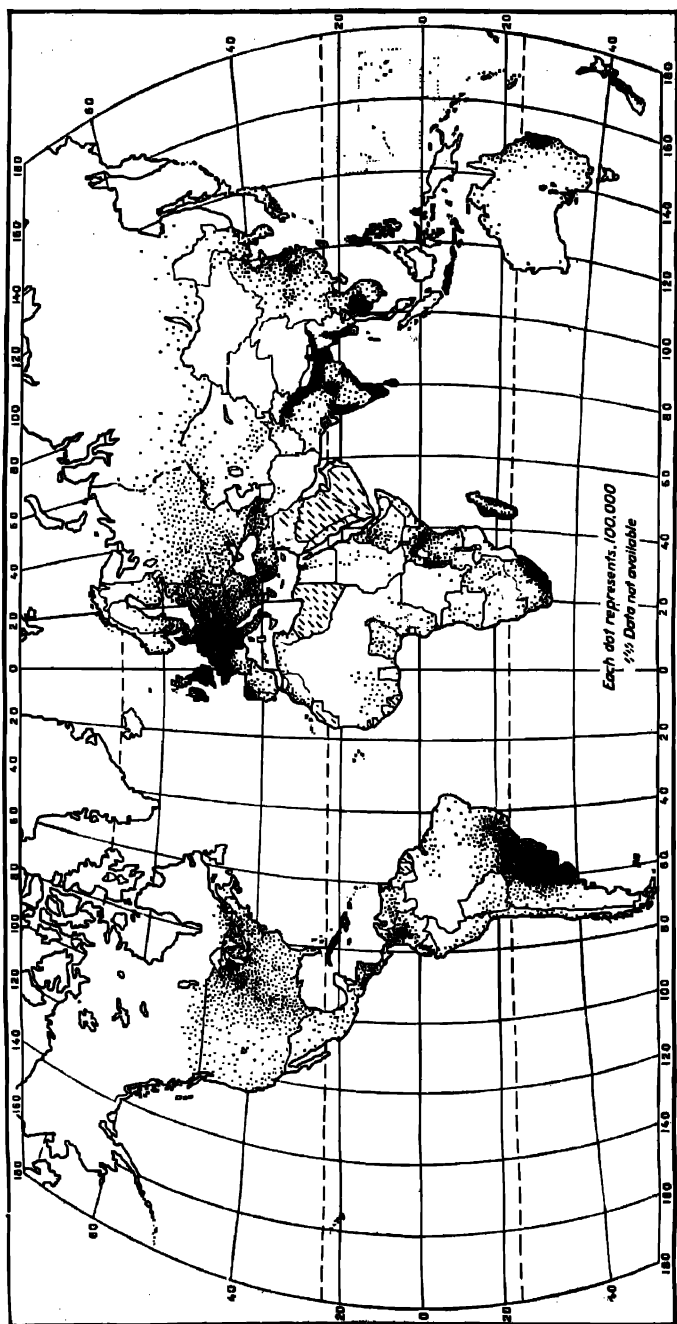




World sheep-producing areas. Products: mutton and lamb meats, wool, sheepskins, lambskins, grease, lanolin, bones.



World hog-producing areas. Products: pork meats, ham, bacon, lard, pigskins, bristles, gelatin, bones.



World cattle-producing areas. Products: frozen and chilled beef, canned beef, beef extract, hides, calfskins, hair, horns, bones, oleo oils, tallow, gelatin, neatfoot oil, glue.

## WAVES AND COLORS AS MATERIAL ELEMENTS

### Electromagnetic Radiations

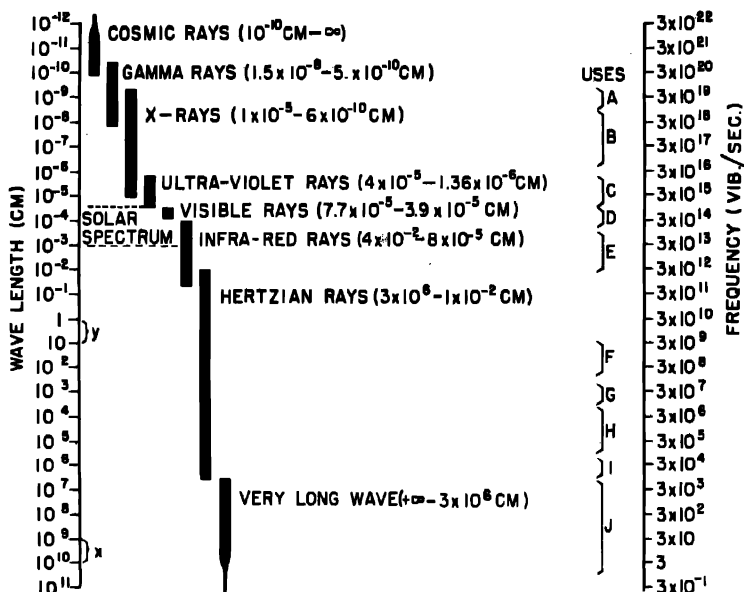
Tangible materials and radiations have a common energy origin, and thus bear a cosmic relation, but radiation is not matter in the ordinary sense of the term. Radiation is caused by vibrations, and is measured in wave length and not in mass as is matter. Waves of high frequency and short wave length result from the vibration of extremely small particles such as electrons of the material atom, while those of low frequency and long wave length arise from slow vibrations such as those from a coil in a magnetic field.

Radiations are produced when materials are broken down or changed to another form, and there is then an actual loss of mass equal to the amount of energy emitted. In reverse, matter is produced when energy in the form of radiation is directed upon matter, and an actual increase in the mass of the matter results. All materials in nature are being constantly bombarded with various radiations, but it requires such an extremely large amount of energy to produce the most minute quantities of matter that the continuous changes in most materials are not noticeable in any historic period of time.

The spectrum of electromagnetic radiations extends from wave lengths of many hundred-millionths of a centimeter (1 cm equals 0.3937 in.), or infinitely small, to wave lengths of many miles, or infinitely large. The velocity of these waves is the same for all lengths of wave, 186,000 mi per sec. In the spectrum, the light waves which make objects visible to the human eye form only a small part. All animals do not see with the same wave lengths, and some animals do not have normal eyes but receive vibrations through special receiving parts of the body. The human eye can see through only such materials as these light waves will penetrate. But electrical eyes can be made to operate in other wave lengths and record vision not seen by the human eye. Different materials transmit, absorb, or reflect radiations differently. Quartz and glass, normally called transparent, transmit only a small band of light and heat waves, but will not pass very short radiations. By changing the composition of the glass the heat waves can be blocked, or some of the very short waves can be passed through. Some materials, like lead, will block the very short waves, and can be used for X-ray shields. Other materials, like beryllium, will pass only very short waves, and can be used for windows for radio tubes.



## Wave Lengths and Frequencies



## SPECTRUM OF ELECTROMAGNETIC RADIATIONS

USES:

A-RADIOLOGY,RADIOTHERAPY,X-RAY  
DIAGNOSIS

B-PHYSICAL AND CHEMICAL ANALYSIS  
OF MATTER

C-THERAPEUTIC APPLICATIONS

D-LIGHT

E-HEATING,INDUSTRIAL BAKING

F-FM,RADAR,TELEVISION,SONAR

G-SHORT WAVE RADIO

H-WIRELESS

I-LONG WAVE RADIO

J-ELECTRIC POWER,ALTERNATING  
CURRENT

EXPLANATION:

THE CHART IS LOGARITHMIC, THE DISTANCE X, FROM  $10^9$  TO  $10^{10}$  BEING A BILLION TIMES THE DISTANCE y, FROM 1 TO 10

$10^1 = 10$   
 $10^2 = 100$

$10^3 = 1000$   
 $10^4 = 10000$

$10^{-1} = 0.1$   
 $10^{-2} = 0.01$

$10^{-3} = 0.001$   
 $10^{-4} = 0.0001$

From J. F. Moulton, Jr.

### **Light Measurement and Balancing**

Visible light waves, like all other electromagnetic radiations, travel through space at a speed of 186,000 mi per sec. This speed is cut down perceptibly when light travels through materials. The speed through silica glass is only 122,000 mi per sec, with a bending of the light beam and a scattering of the colors. The speed through a fluoride optical glass is 146,000 mi per sec, with less color scattering than with silica glass.

The longest visible wave length is about 0.00008 in., and the shortest is about half that length. The unit of length is the angstrom unit, designated as Å and equal to 0.00000001 cm. The millimicron is 10 Å.

The longest wave lengths are the reds, and the shortest are the violets. A low-intensity electric current gives a light with a yellow tint because the color composition has high percentages of red and orange-yellow. A very high-intensity current gives a higher proportion of violet, blue, and green. Adjustment of the intensity of the electric current, and incorporation of metallic elements of the proper flame color at incandescence can flatten out the color percentage balances to give the whiteness and brilliancy desired for any particular use.

### **Element Colors at Incandescence**

Flame colorations caused by heating materials to incandescence indicate the presence of certain elements, as the light from each element in burning has a predominance of rays or wave lengths that are characteristic of that particular element. Some elements, such as sodium, show a distinct bright color because of a predominance of wave lengths within that color range in the visible spectrum, while others show pale or intermediate colors difficult to distinguish, usually because the rays have no predominating wave length within the visible spectrum but are mixtures of many wave lengths. Other elements, such as iron, have a predominance of rays that are not in the visible band, with wave lengths shorter or longer than those visible to the eye. Flame coloration is used in metallurgical laboratories to determine the content of alloys by burning small pieces and studying the light with a refractive prism. This property of the elements is also utilized in making carbon electrodes for electric-arc lights to give the full white light of sunshine, or short waves for therapy or industrial use, or long wave lengths for heat. For example, carbon alone gives a predominance of short wave lengths with the visible rays predominantly on the red side of the spectrum. By blending cerium metals with the carbon the visible light is balanced with the blue-violet to give a more even white light. By blending the carbon with iron, nickel, and aluminum, which are all on the low-wave side of the spectrum, lower zone ultraviolet rays are obtained.

## Predominant Flame Colors of Materials

| Element         | Color         | Element        | Color         |
|-----------------|---------------|----------------|---------------|
| Lithium.....    | Deep red      | Antimony.....  | Blue-green    |
| Strontium.....  | Crimson       | Copper.....    | Green-blue    |
| Calcium.....    | Yellow-red    | Arsenic.....   | Light blue    |
| Sodium.....     | Bright yellow | Lead.....      | Light blue    |
| Barium.....     | Yellow-green  | Selenium.....  | Blue          |
| Molybdenum..... | Green-yellow  | Indium.....    | Deep blue     |
| Zinc.....       | Light green   | Potassium..... | Purple-red    |
| Boron.....      | Green         | Rubidium.....  | Violet        |
| Tellurium.....  | Deep green    | Cesium.....    | Bluish purple |
| Thallium.....   | Greenish blue |                |               |

## Reflecting Powers of Various Metal Surfaces

|                            | White light<br>directly<br>reflected,<br>per cent | Color<br>Silver = 0 |
|----------------------------|---------------------------------------------------|---------------------|
| Silver.....                | 90                                                | 0                   |
| Chromium.....              | 61                                                | Blue-green 12 units |
| Nickel.....                | 50                                                | Red 16 units        |
| Stainless steel.....       | 49                                                | Blue-green 3 units  |
| White bronze speculum..... | 70                                                | Red 1 unit          |

## Reflecting Power of Various Colors in Paints

| Color              | Light reflection,<br>per cent | Color             | Light reflection,<br>per cent |
|--------------------|-------------------------------|-------------------|-------------------------------|
| Flat white.....    | 85-89                         | Sky blue.....     | 58                            |
| Bone white.....    | 69-70                         | Light orchid..... | 57                            |
| Canary yellow..... | 68-72                         | Buff.....         | 47                            |
| Light ivory.....   | 70                            | Pea green.....    | 40                            |
| Aluminum.....      | 70                            | Tan.....          | 34                            |
| Cream.....         | 65-69                         | Peacock blue..... | 34                            |
| Light green.....   | 66                            | Steel gray.....   | 30                            |
| Ivory.....         | 61-63                         | Brown.....        | 9                             |
| Peach.....         | 58-59                         |                   |                               |

### Metal Melting Range and Color Scale

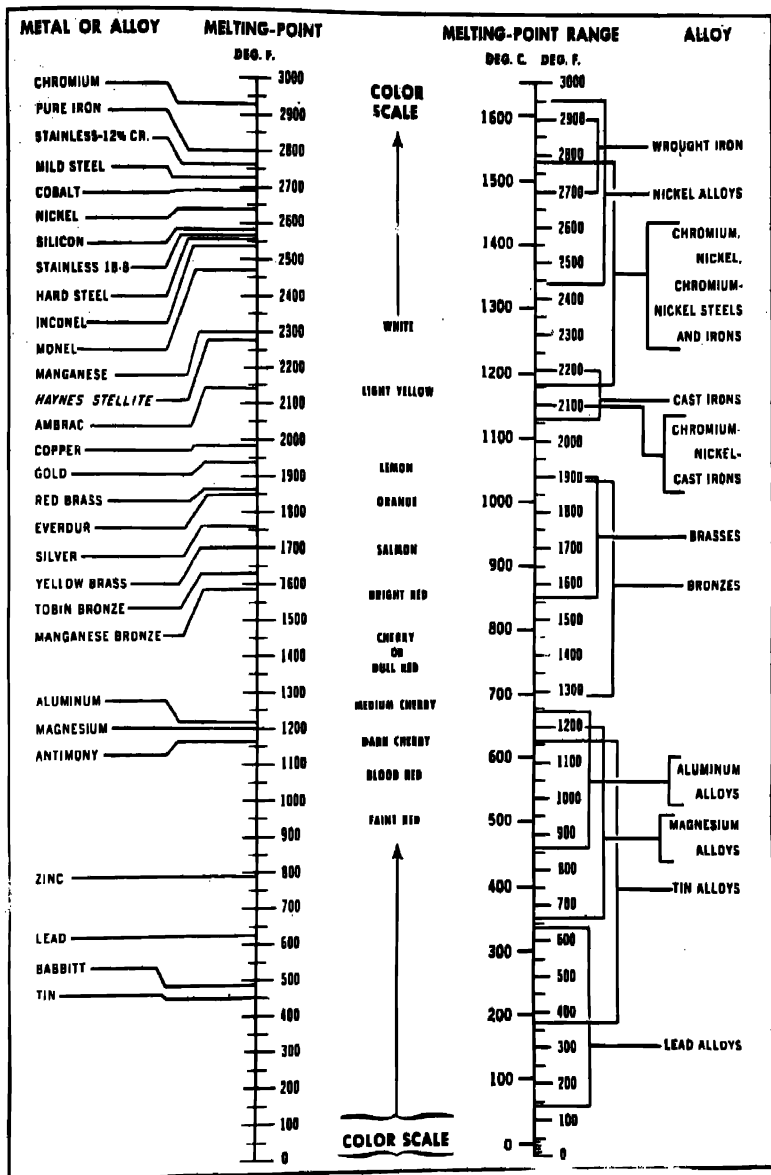
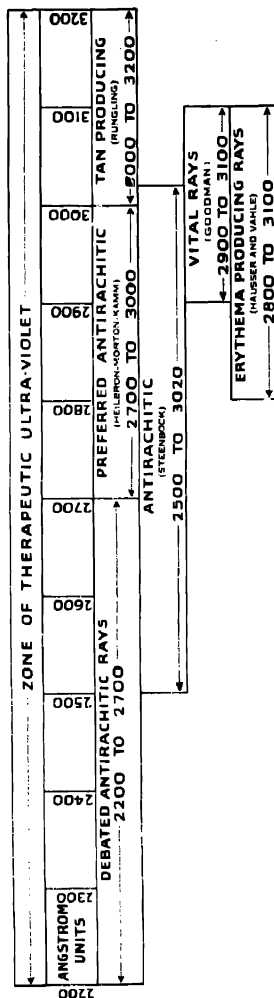
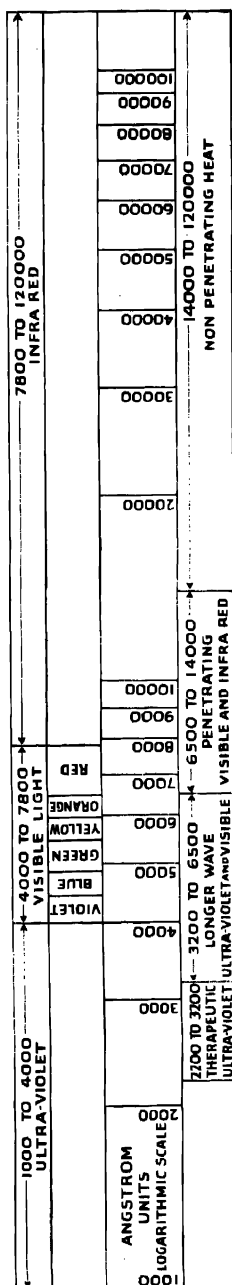


Chart from the Linde Air Products Co

## Heat and Light Rays from the Carbon Arc



### Terms Used in Material Color Designation

**Hue** is the predominant light-wave length reflected by the coloring material, and determines the Color designation.

**Brightness** or **Value**, or **Chroma**, is the percentage of light reflected. A brilliant white approaches 100%, and a jet black approaches 0%. Black is the absence of light waves; White is a combination of all the various wave lengths. White light is broken down by refraction into separate wave bands, or hues.

**Saturation**, or **Intensity**, is the percentage of reflected light which is colored, and determines the **Tint**. A color, or hue, is tinted by its mixture with white.

The color circle is composed of 12 colors spaced at equal intervals: yellow, orange, red, violet, blue, green, and an intermediate between each. Pigment colors are obtained usually by Subtractive mixing; for example, when blue and yellow are mixed the blue absorbs the red, orange, and yellow rays, and the yellow absorbs the blue and violet rays, giving green.

Under proper illumination it is possible to detect with the eye exceedingly slight color differences, the number of distinguishable colors being estimated (U.S. Bureau of Standards) at 10,000,000.

Colors or hues vary slightly with different batches of paints, dyes, etc. For this reason products that must be matched exactly in hue are usually finished from the same batch or lot.

Visibility at a distance varies with different colors. Red can be seen and recognized at long distances while blue can be seen at only short distances. The comparative visibility of colors at a distance are red, green, white, yellow, blue. Legibility, however, varies also with the background. Black on yellow is more legible than black on white. Green, or red, or blue on white is more legible than black on white. Visibility and legibility are important in signs, packages, or products that must be distinguished easily.

**Harmony** of color or **Tone design** is a complicated art. It comprises the color relationship to convey pleasing emotional reaction, and includes various terms. A Rich color is a hue at its fullest intensity. A Warm color is one in which the red-orange predominates. A Cool color is one in which the blue-green predominates. In general, warm colors are pleasing or exciting, while cool colors are not so pleasing or are restful to the senses. A Receding color is one giving the illusion of withdrawing into distance by a gradation toward another tone or hue. Color, from the standpoint of harmony and design, is a sensation effect. It is not inherent in the pigments, dyes, or other materials, but is the sensation effect from those light rays reflected to the eye by the material.

### PROPERTY OF FLAVOR IN MATERIALS

The quality of many materials is judged by the flavor. Flavor is the resultant of three senses: taste, smell, and feeling. Some materials, such as salt and quinine, may be detected by taste alone. Some, such as coffee and butter, depend largely upon smell. Flower perfumes are detected by smell alone. The flavor of fruits depends upon both taste and smell, and without smell would be only sour or sweet. Pepper has little or no taste, but is detected by the aroma and by the sense of feeling. Ginger also registers feeling through the nerves, and odor.

The four standard components of taste are: sweet, sour, salty, and bitter. Taste buds are located in the tongue. The tip, back, and edges of the tongue can detect all four sensations, but the center of the tongue can detect only a sour taste, and the surrounding area can detect only salty and sour. Sour taste is caused by hydrogen ions, and salty taste is due to cations from the alkali metals, accented when anions from the halogens are present. Sweetness and bitterness may or may not be from ions, and the stimuli are more complex. But all taste is electrochemical, translated to the nerves as sensations. Some materials when injected into the blood can be tasted when the blood stream reaches the underside of the tongue.

Odor detection is electrochemical but not entirely so, since molecules which have the same shape may have the same odor though unrelated chemically. The sense of smell is due to oscillations of the valance electrons in the molecules of the substance. The molecules of substances inhaled stimulate the tiny olfactory hairs high in the nasal cavity, and the effect is translated to the nerves as impressions or sensations. The sense of taste usually requires considerable material to register the sensation, but only the most minute molecular quantities are required to register smell. A normal person can detect a vast variety of odors, but for convenience the four fundamental odors have been designated as fragrant, acid, burnt, and caprylic. A material is then designated with a four-digit number to indicate the degree of each odor, each odor thus having ten degrees or variations, thus giving 9,999 variants. Various materials are taken as standards for the numbers, or 40 standards. The sense of smell is so discriminating that it can detect separate odors in highly complicated mixtures. Most odors are mixtures, and the art involved in the perfumery industry is to form harmonies that give a resultant pleasant sensation.

Flavors that affect the touch sensation are described as pungent, sharp, acrid, and cool. These are caused by actual pain as the biting of an acid or the cooling effect of deoxidation. Greasiness and oiliness are sensations of feel that affect taste but are not a part of it. Texture also is a

feeling sense and not a part of flavor. The sensation of puckery of the tannin of some fruits is a definite constriction of membrane and is not taste. All of these have an effect upon the desirability of the material as a food, but in a manner apart from flavor. Too much sweetness, or sourness, or saltiness will clog the taste buds, and they must be then rested before a true flavor can be detected, but the recovery is rapid. Temperature also has an effect, and true flavors are detected only at about the temperature of the body. The judgment and grading of coffee, tea, butter, and many other products are done solely by the senses of experts in comparison with standards.

### FUNDAMENTALS OF BIOTIC MATERIALS

The Biotics constitute an extensive group of organic materials that are simple, living microorganisms and cannot be expressed as chemical formulas. All of these minute bits of living matter are of plant and animal origin and may be considered as chemical factories. It is the chemicals that certain species secrete under certain conditions that make them industrially and medicinally useful. The chemical secretions are enzymatic and catalytic in character and thus enable various chemicals to react on contact. In industry they are used as chemical activating agents, ferments, leavening agents, and in various processing. In medicine they are known as Antibiotics and are used to destroy the biotics, or bacteria, of diseases which locate themselves in the human body.

Biotics are found everywhere in myriad quantities. A cubic centimeter of raw earth may contain as many as 50,000 fungi, or microphytes, 500 million bacteria, and 250 million actinomycetes, the latter being living organisms that may be ascribed, with reservations, to either the plant or to the animal kingdom, and are distinguished by their mass of long silky filaments. All of these organisms lead a junglelike type of existence, attacking everything, decomposing plant debris to make humus, liberating nitrogen from proteins, liberating oxygen from rocks, liberating carbon dioxide and water from organic acids in plants and soil, and also preying on each other like jungle animals. Without these organisms the life cycles of all living things could not be maintained. It is this same teeming population that also furnishes the individual types or organisms that aid man in medicine and industry.

The number of species of these microorganisms is innumerable. Each species has at least one enemy species that it destroys on contact or by which it is itself destroyed. Each, apparently, has a certain definite range of activity, beyond the bounds of which it is useless. Where one biotic



is used in the manufacture of a certain product, a similar but different species used under the same conditions produces an entirely different product, or may affect the quantitative yield of the product desired. The formation of ethyl alcohol by the fermentation of starch or sugar is caused by a biotic which is then itself killed when the alcohol produced has arrived at a certain concentration. Other biotics may be killed by the heat that their own work produces, as at the "crisis" point of certain fevers. In general, biotics can withstand excessive cold but are usually killed by relatively low heats.

Besides the use of biotics for medicinal and industrial applications as are now known, there are also believed to be enormous possibilities for their use in large-scale chemical processing in the future. But the isolation of microorganisms is tedious laboratory work involving the extraction of a pure strain from cultures containing many species, and once separated, the proper conditions to promote rapid multiplication must be discovered. Even at this stage, a biotic found to be useful in the manufacture of a certain product may simultaneously manufacture another unwanted product, difficult and costly to separate from the desired one. But from each biotic some kind of chemical is secreted, and it is that chemical which is the ultimate end of biotic research.

Out of the many thousands of possibilities for the production of these microorganism, or biotic, chemicals, very few have as yet been isolated and put to use. In medicine, Penicillin, the sodium or calcium salt of the chemical extracted from the mold fungus *Penicillium notatum*, is an example, while in industry, there is the chemical secreted from the yeast plant *Saccharomyces cerevisiae*, which causes fermentation to ethyl alcohol. Biotics from the bacterial genus *Clostridium* have been used to produce butyl and isopropyl alcohols. The mold *Oidium lactis* was used by the Germans to produce fats from straw and oat hulls, and the *Fusarium candida* was used to produce proteins. A yield of 5 tons of fat and 10 tons of high-protein feed is obtained from 100 tons of crude straw. The fat as produced during the war was inedible, but can be purified. A microorganism of the genus *Desulfovibrio*, isolated by the Scripps Institution of Oceanography, lives in strong salt brine without light or air, and has been used for aiding the release of oil in deep wells. It generates acid, dissolving limestone, enlarging flow channels, and generating carbon dioxide to aid pressure. It also feeds on sulphur and cracks large molecules of the oil.

Lactic acid has been produced from dextrose by a *Lactobacillus* culture with powdered limestone as the culture. The biotic produces lactic acid, and the acetic acid is converted to calcium lactate by the limestone to

prevent the bacteria from destroying themselves by the concentration of acid. An antibiotic used in medicine is Streptomycin, which is obtained from *actinomyces*, a class of molds midway between the fungi and bacteria. The antibiotic Aureomycin, used in medicine, is from a fungus *mycin*, and is named aureo from its golden color. The secretions of biotics are true chemicals that can be expressed as formulas. For medicinal use, as antibiotics, the chemicals are usually sought. Industrial applications have usually been as live biotics. For industrial uses proper cultures for the growth and operation of the biotics must also be determined.

## INDUSTRY TERMS

All industries have names and units peculiar to the particular industry. The two groupings that follow are illustrative.

### Terms Used in the Textile Industry

A **Fiber** is the basic individual filament of raw material from which threads, cordage, or fabrics are made.

**Carding** consists in cleaning the particles of leaf or foreign matter from the fiber. Originally a "card" was used which was a rectangular piece of wood with wire teeth. Carding by machine lays the cotton or wool in a continuous strand. **Drawing** consists in feeding card slivers of fibers between two pairs of rolls, the second revolving faster than the first to stretch the sliver and reduce the diameter. The first drawn slivers with slight twist are called **Rovings**. A **Yarn** is the product of **Spinning** the loose rovings into a continuous tight string, by running from one spool to another. The more twists to the inch the stronger the yarn.

**Combing** is a continuation of carding to eliminate short fibers, to give more evenness, and to free the fibers of all foreign matter. The finest yarns are combed. The eliminated short fibers are called **Noils**. At this point the yarns are dyed for yarn-dyed fabrics.

**Cloth** or **Fabric** is made by weaving, knitting, or felting. Weaving is the interlacing of two sets of yarns at right angles. Knitting is the looping of yarn to form rows, one row of loops being caught into the previous row. Felting is the mass interlocking of fibers by pressure.

**Cotton yarns** are designated by numbers, or **Counts**. The standard count of cotton is 840 yd to the pound. Number 10 yarn is therefore 8,400 yd to the pound. A No. 80 sewing cotton is  $80 \times 840$ , or 67,200 yd to the pound.

**Linen yarns** are designated by the **Lea** of 300 yd. A 10-count linen yarn is  $10 \times 300$ , or 3,000 yd per lb.

The size or count of spun **Rayon yarns** is on the same basis as cotton yarn. The size or count of rayon filament yarn is on the basis of the **Denier**, the rayon denier being 450 meters weighing 5 centigrams. If 450 meters (492.12 yd) of yarn weigh 5 centigrams it has a count of 1 denier. If it weighs 10 centigrams it is No. 2 denier. Rayon yarns run from 15 denier, the finest, to 1,200 denier, the coarsest.

Reeled **Silk yarn** counts are designated in deniers. The International Denier for reeled silk is 500 meters of yarn weighing 0.05 gram. If 500 meters weigh 1 gram, the denier is No. 20. Spun silk count under the English system is the same as the cotton count. Under the French system the count is designated by the number of Skeins weighing a kilogram. The Skein of silk is 1,000 meters.

A **Ply yarn** is one that has two or more yarns twisted together. A two-ply yarn has two separate yarns twisted together. The separate yarns may be of different materials, as cotton and rayon. A six-ply yarn has six separate yarns. A ply yarn may have the different plies of different twists to give different effects. Ply yarns are stronger than single yarns of the same diameter. Tightly twisted yarns make strong, hard fabrics. Linen yarns are not twisted as tightly as cotton because the flax fiber is longer, stronger, and not as fuzzy as the cotton. **Filament rayon yarn** is yarn made from long, continuous rayon fibers, and it requires only slight twist. Fabrics made from filament yarn are called Twalle. Spun rayon yarn is yarn made from **Staple fiber**, which is rayon filament cut into standard short lengths.

The difference between **Thread** and yarn is one of more equal twist. In thread the plies are balanced in twist so that the finished thread approximates a perfect circle. In thread the plies are called Cords; a six-ply thread is designated as Six-cord. Cotton thread comes in counts from 8 to 100, coarse to fine.

The **Tex system** is the standard system of cotton yarn count in Spanish countries. It is a direct system, the lower the count, the finer the yarn. One thousand meters of one-tex yarn weigh 1 gram. One thousand meters of two-tex yarn weigh 2 grams.

**Group Terms Used for Drug Materials**

**Analgesic.** A material that diminishes the conductivity of the nerve fibers and thus relieves pain, as wintergreen.

**Anodyne.** A drug that relieves pain, as opium, menthol

**Anthelmintic.** A drug that causes expulsion of intestinal worms.

**Antibiotic.** A substance that destroys fungi, microbes, and other microorganisms. Usually living organisms, and not expressed by chemical formulas.

**Anticatarhal.** A drug that reduces or controls inflammation of mucous membranes of the nose or throat, as buchu.

**Antiseptic.** A material that opposes or kills the microorganisms of decay, as thymol or alcohol.

**Antipyretic.** A drug that reduces fever, as quinine or atabrine.

**Antipyrotic.** A drug that relieves burns, as tannic acid.

**Antispasmodic.** A drug that relieves convulsions or spasms, as valerian.

**Antitoxin.** A chemical produced by the body, or injected into the body, which reacts with and alters poisons so that they are no longer poisonous.

**Carminative.** A drug promoting the expulsion of gas to relieve colic.

**Demulcent.** An oily or mucilaginous material that softens and soothes an inflamed part of the body.

**Diaphoretic.** A drug that stimulates the sweat glands and causes perspiration, as aconite.

**Dilatant.** A chemical that expands the muscles of the eye or other parts of the body, as belladonna.

**Diuretic.** A drug that increases the renal excretions and produces increased discharge of urine, as caffeine, citrates.

**Emetic.** A drug that causes vomiting to eject poisons, as zinc sulphate.

**Emollient.** A drug applied externally to soften and soothe irritated or tense tissues, as zinc stearate for the skin and glycerin for throat tissues.

**Expectorant.** A drug that promotes secretion of mucus from the respiratory tract, as ipecac.

**Febrifuge.** A drug that reduces fever or prevents fever, as quinine.

**Hemolytic.** A material that causes destruction of the red blood corpuscles, as spider poison.

**Hypnotic.** A drug that produces sleep, as chloral.

**Lachrymator.** A chemical that causes a copious or blinding flow of tears, as chloropicrin.

**Narcotic.** A drug that produces stupor. There are three classes: those that produce deep sleep, as opium; those that produce illusions and sleep, as cannabis; those that produce exhilaration and sleep, as alcohol.

**Nutrient.** A material that can be injected to nourish the blood or a body organism, as glucose.

**Peristaltic.** A drug that increases intestinal movements, as cascara.

**Prophylactic.** A material given in advance to prevent disease, as quinine.

**Sedative.** A material that counteracts stimulation or irritation and has a calming effect, as bromides or henbane.

**Sternutator.** A chemical that causes sneezing, as diphenyl chloroarsene.

**Stomachic.** A drug that increases gastric secretions and stimulates appetite, as gentian or pepper.

**Vasodilator.** A material that lowers the blood pressure by dilating the arteries, as nitroglycerin or aconitine.

**Vermicide. Vermifuge.** A material that expels intestinal parasites.

**Vesicant.** A chemical that causes blistering of the skin, as mustard gas.

### VISUAL AIDS

Motion-picture films are available illustrating and explaining the processes in the extraction and preparation of raw materials. Those from commercial companies producing raw materials are often sent out on a loan basis to schools and to industrial companies conducting educational courses for employees. A few typical examples follow:

*Copper Smelting* (Phelps Dodge Refining Corp., 15 min, 16mm sd). Shows the crushing, roasting, and smelting to convert ores and concentrates into metallic copper; shows converters and anode furnaces; shows casting of copper. Another 34-min, 16-mm sound film of this company, entitled *Story of Copper*, shows open-pit and underground mining of copper ores.

*Aluminum: Mine to Metal* (Aluminum Company of America, 30 min, 16mm sd). Shows the mining and purifying of bauxite, and the uses of aluminum in building and in industry.

*10,000 Feet Deep* (Shell Oil Co., Inc., 20 min, 16mm sd). Shows modern methods of oil exploration and oil drilling.

*Synthetic Rubber* (Goodyear Tire & Rubber Co., Inc., 40 min, 16mm sd). Shows the various steps in the making of chemicals into rubber.

*How Steel Is Made* (Bethlehem Steel Co., 40 min, 16mm sd). Shows blast, bessemer, and open-hearth furnaces; animated drawings of what takes place in the furnace; rolling operations; hammer forges and press forges; cupola furnaces in the foundry.

*Mountains of Marble* (Vermont Marble Co., 22 min, 16mm sd). Shows the quarrying of marble, and the cutting and finishing of the stones.

*Story of Leather* (Tanners Council of America, 25 min, 16 and 35mm si). Shows the process involved in the making of leather from the roundup of cattle to the finished product. Sound films are also available.

**AGENCIES OF THE U.S. GOVERNMENT  
DEALING WITH  
TECHNICAL ASPECTS OF MATERIALS RESOURCES**

*Department of the Interior.* Charged by law with advancing the domestic interests of the people of the United States, which includes utilization and conservation of national resources.

*General Land Office* supervises the survey, management, and disposition of public lands and the resources thereon. It conducts scientific and professional investigations in the fields of land and mineral economics.

*Geological Survey* prepares and publishes reports upon the geology and mineral and water resources. Supervises technical phases of mineral leasing on public lands.

*Bureau of Mines* conducts scientific, technological, and economic investigations on the development, mining, preparation, treatment, and utilization of ores to determine and develop new domestic sources of supply. Is empowered to make inspections and investigations of mines to curb accidents and preserve the health of miners. Operates pilot plants to demonstrate methods.

*Fish and Wildlife Service* carries on programs for the perpetuation and restoration of renewable resources, bird life, fish, fur and other land mammals, seals, whale, lobster. Administers the conservation laws.

*Department of Agriculture.* Charged by law to acquire and diffuse useful information on agricultural subjects for the common benefit, farm products, soils, human nutrition, markets.

*Bureau of Animal Husbandry* deals with eradication and control of animal diseases and parasites and seeks to protect and develop the livestock, meat, poultry, and related industries.

*Bureau of Dairy Industry* investigates the breeding and management of dairy cattle. Records production. Develops sanitary methods on farm, in transit, and in dairy plants.

*Bureau of Agricultural and Industrial Chemistry* conducts investigations and experiments into the sciences relating to agricultural products and into the development of new and wider uses of agricultural products.

*Bureau of Entomology and Plant Quarantine* studies insects and pests injurious to agriculture and forestry and develops insecticides. Enforces the plant quarantine laws.

*Bureau of Human Nutrition and Home Economics* conducts research on foods essential to living and factors affecting foods and clothing for proper utilization and reduction of waste.

*Forest Service* promotes the conservation and best use of the forest lands of the nation. Operates forest and range experiment stations. Administers the forests.

*Soil Conservation Service* promotes the conservation and usage of soil and water through technical, material, and equipment aids. Conducts research into character, cause, and effect of erosion and depletion, and develops methods of conservation.

*Bureau of Agricultural Economics* is the central statistical and economic research office of the department. It collects, analyzes, and publishes facts on agriculture, production, demand and supply, consumption, prices, costs, income, markets, farm management, standards of living and rural population matters. Issues crop reports.

*Office of Foreign Agricultural Relations* collects, analyzes, and disseminates information on foreign competition and demand for farm products, and on foreign agricultural policies.

*Department of Commerce.* Charged by law to conduct all censuses, promote foreign and domestic commerce, conduct coastal and geodetic surveys, establish weights and measures standards, supervise patents and trade-marks, establish and maintain aids to air navigation, supervise and issue weather forecasts and warnings for agriculture, commerce, and navigation, develop inland water transportation.

*Bureau of the Census* is the major fact-finding and statistical service of the government. Conducts various censuses, tabulates and disseminates periodic data. Promotes the adoption of uniform and improved standards for registering vital statistics by the states.

*Bureau of Foreign and Domestic Commerce* is charged with the duty to foster, promote, and develop the foreign and domestic commerce of the United States. Makes investigations of requirements, sources of supply, production capacity, procurement, and problems of commodity supply. Issues reports on conditions of trade, statistics, tariffs, and all matters affecting commerce. Maintains officials in foreign business centers, but most of the statutory functions have been assumed by the Department of State.

*National Bureau of Standards* develops and has custody of the working standards for measurement, quality, performance, and practice used in science, industry, and commerce. Is the central reference for all standards and specifications used in the United States.

## UNITS OF MEASURE

## Useful Conversion Factors

- 1 acre = 43,560 square feet = 0.40469 hectare
- 1 angstrom unit = 0.003937 millionths of an inch
- 1 ardeb (Egypt) = 5.44 bushels
- 1 arshin (Russian) = 28 inches
- 1 barrel (U.S.A.), cement = 376 pounds
- 1 barrel, oils = 42 gallons
- 1 berkovets (Russia) = 361.13 pounds
- 1 board foot = 144 cubic inches
- 1 bolt, cloth = 40 yards = 36.576 meters
- 1 buncal (East Indies) = 1.49 troy ounces
- 1 bushel = 2,150.4 cubic inches
- 1 bushel, imperial (British) = 1.0315 U.S. bushels
- 1 candy (India) = 784 pounds
- 1 carat, metric = 0.200 gram
- 1 carat (U.S.A.) = 0.2056 gram
- 1 chittak (India) = 900 grains
- 1 circular mil = 0.0000007854 square inch
- 1 cuartello (Mexico), liquid = 0.482 liquid quarts
- 1 cuarteron (Spain), oil = 0.133 liquid quart
- 1 cubic foot = 1,728 cubic inches
- 1 cuffisco (Sicily), oil = 5.6 gallons
- 1 dram = 1.7718 grams
- 1 dinero (Spain) = 18.5 grains
- 1 dönüm (Palestine) = 0.25 acre
- 1 drachma (Turkey) = 49.5 grains
- 1 feddan (Egypt) = 1.038 acres
- 1 firkin = 9 U.S. gallons = 34.068 liters
- 1 flask, mercury = 75 pounds = 34.02 kilograms
- 1 foot = 12 inches = 0.3048 meter
- 1 gallon = 231 cubic inches
- 1 gallon, imperial (British) = 1.20094 U.S. gallons
- 1 gallon, proof (British) = 1.37 U.S. proof gallons
- 1 gil = 0.25 pint = 0.118292 liter
- 1 grain = 0.06480 gram
- 1 gram = 15.43 grains = 0.03527 avoirdupois ounce
- 1 gram (Libya) = 165.3 pounds
- 1 hamlah (Egypt) = 165.1 pounds
- 1 hectare = 2.471044 acres



- 1 hogshead = 63 U.S. gallons
- 1 hundredweight (British) = 112 pounds
- 1 inch = 0.0833 foot = 2.54005 centimeters
- 1 iron, leather thickness measure =  $\frac{1}{48}$  inch
- 1 kantar (Egypt) = 99.034 pounds
- 1 keel (British), coal = 21.2 long tons
- 1 kilogram = 2.205 pounds
- 1 koku (Japan) = 47.65 gallons = 5.119 bushels
- 1 kula (Tangier), oil = 4.00 gallons
- 1. kun (Korea) = 1.323 pounds
- 1 kwan (Japan) = 1,000 momme = 8.267 pounds
- 1 ligne, metal button measure =  $\frac{1}{40}$  inch
- 1 liter = 1.057 liquid quarts
- 1 lug (Bahamas) = 30 pounds avoirdupois
- 1 maund (Tibet), wool =  $82\frac{3}{4}$  pounds
- 1 meter, square = 1.196 square yards
- 1 mil, square = 0.000001 square inch
- 1 mettar (Tunisia), oil = 5.2 gallons
- 1 micron = 0.001 millimeter = 0.00003937 inch
- 1 mil = 0.001 inch = 0.0254 millimeter
- 1 mile = 5,280 feet = 1.60935 kilometers
- 1 mile, square = 640 acres
- 1 millimeter = 0.03937 inch
- 1 ounce, avoirdupois = 28.35 grams = 0.0625 pound
- 1 ounce, troy = 31.1 grams
- 1 peck = 0.25 bushel = 8.8096 liters
- 1 picul (China) = 100 catties =  $133\frac{1}{3}$  pounds
- 1 picul (East Indies) = 136.2 pounds
- 1 picul (Japan) = 132.3 pounds
- 1 pint, dry measure = 33.6 cubic inches
- 1 pint, liquid measure = 28.875 cubic inches
- 1 pood (Russian) = 36.11 pounds
- 1 pound, avoirdupois = 16 ounces = 7,000 grains = 0.4536 kilogram
- 1 pound, Ionian (Greece) = 1 avoirdupois pound
- 1 pound, troy = 12 ounces = 0.37324 kilogram
- 1 pound, Venetian = 1.058 avoirdupois pounds
- 1 quart, dry measure = 2 pints, dry = 1.1012 liters
- 1 quart, liquid = 57.749 cubic inches = 0.9463 liter
- 1 quintal (British) = 100 pounds
- 1 quintal, metric = 100 kilograms = 220.5 pounds
- 1 ream, paper measure = 500 sheets = 20 quires

- 1 scruple, apothecary weight = 20 grains = 1.296 grams  
 1 shih tan (China) = 50 kilograms = 110.231 pounds  
 Specific gravity  $\times$  0.036 = weight in pounds per cubic inch  
 1 standard (British), timber = 1,980 board feet  
 1 standard (U.S.A.), timber =  $16\frac{2}{3}$  cubic feet  
 1 tank (India), gem stones and pearls = 24 rati = 0.145 ounce  
 1 tierce, thin-staved cask = 42 gallons, 310 to 370 pounds  
 1 ton, long = 2,240 pounds = 1016.047 kilograms  
 1 ton, metric = 1,000 kilograms = 0.9842 long ton = 1.102 short tons  
 1 ton, short = 2,000 pounds = 0.8929 long ton  
 1 tomin (Spain), silver = 9.25 grains  
 1 vedro (Russian) = 3.249 gallons  
 1 yard = 3 feet = 0.9144 meter

### Metric Length Measurements

| Unit                | Inches  | Feet    | Milli-<br>meters | Centi-<br>meters | Meters |
|---------------------|---------|---------|------------------|------------------|--------|
| One inch.....       | 1       | 0.0833  | 25.4             | 2.54             | 0.0254 |
| One foot.....       | 12      | 1       | 304.8            | 30.48            | 0.3048 |
| One millimeter..... | 0.03937 | 0.00328 | 1                | 0.1              | 0.001  |
| One centimeter..... | 0.3937  | 0.0328  | 10               | 1                | 0.01   |
| One meter.....      | 39.37   | 3.2809  | 1000             | 100              | 1      |
| One yard.....       | 36      | 3       | 914.4            | 91.44            | 0.9144 |

### Standard Metal Gages

The Brown & Sharpe, or American standard, wire gage is used for aluminum, brass, bronze, and German silver sheet, also for nonferrous wires and rod.

The Birmingham wire gage (B.W.G.), also known as the Stubs' iron wire gage, applies to seamless tubing and to sheet spring steel.

The British imperial gage (B.I.G.), also known as the legal standard gage (L.S.G.), is used in Great Britain, and also in the United States for copper wire.

The Washburn & Moen gage, also known as the Roebling gage, or the national wire gage, applies to all bare, galvanized, and annealed steel and iron wire, and to tinned steel wire and spring steel wire.

The music wire gage is used for "music" wire.

The U.S. standard gage is used for steel and iron plate.

The twist drill gage, also known as the Morse gage, is used for drill-steel rod. Stubs' steel wire gage is used for steel drill rod. The American screw gage is applied to machine screws. The zinc gage is for sheet zinc.

## Metal Gages in Common Use

| Gage No. | Brown & Sharpe | Birmingham wire | British Imperial wire | Washburn & Moen | Music wire | U.S. Standard Plate | Twist drill | Stubs steel wire | American screw | Zinc  |
|----------|----------------|-----------------|-----------------------|-----------------|------------|---------------------|-------------|------------------|----------------|-------|
| 7-0      | .....          | .....           | 0.500                 | 0.4900          | .....      | 0.5000              |             |                  |                |       |
| 6-0      | .....          | .....           | 0.464                 | 0.4600          | .....      | 0.4690              |             |                  |                |       |
| 5-0      | .....          | .....           | 0.432                 | 0.4300          | .....      | 0.4380              |             |                  |                |       |
| 4-0      | 0.4600         | 0.454           | 0.400                 | 0.3940          | .....      | 0.4060              |             |                  |                |       |
| 3-0      | 0.4100         | 0.425           | 0.372                 | 0.3630          | .....      | 0.3750              | .....       | .....            | 0.0315         |       |
| 2-0      | 0.3650         | 0.380           | 0.348                 | 0.3310          | 0.0085     | 0.3440              | .....       | .....            | 0.0447         |       |
| 0        | 0.3250         | 0.340           | 0.324                 | 0.3070          | 0.0090     | 0.3130              | .....       | .....            | 0.0578         |       |
| 1        | 0.2890         | 0.300           | 0.300                 | 0.2830          | 0.0100     | 0.2810              | 0.2280      | 0.227            | 0.0710         | 0.002 |
| 2        | 0.2580         | 0.284           | 0.276                 | 0.2630          | 0.0110     | 0.2660              | 0.2210      | 0.219            | 0.0842         | 0.004 |
| 3        | 0.2290         | 0.259           | 0.252                 | 0.2440          | 0.0120     | 0.2500              | 0.2130      | 0.212            | 0.0973         | 0.006 |
| 4        | 0.2040         | 0.238           | 0.232                 | 0.2250          | 0.0130     | 0.2340              | 0.2090      | 0.207            | 0.1100         | 0.008 |
| 5        | 0.1820         | 0.220           | 0.212                 | 0.2070          | 0.0140     | 0.2190              | 0.2055      | 0.204            | 0.1240         | 0.010 |
| 6        | 0.1620         | 0.203           | 0.192                 | 0.1920          | 0.0160     | 0.2030              | 0.2040      | 0.201            | 0.1370         | 0.012 |
| 7        | 0.1440         | 0.180           | 0.176                 | 0.1770          | 0.0180     | 0.1880              | 0.2010      | 0.199            | 0.1500         | 0.014 |
| 8        | 0.1290         | 0.165           | 0.160                 | 0.1620          | 0.0200     | 0.1720              | 0.1990      | 0.197            | 0.1630         | 0.016 |
| 9        | 0.1140         | 0.148           | 0.144                 | 0.1480          | 0.0220     | 0.1560              | 0.1960      | 0.194            | 0.1760         | 0.018 |
| 10       | 0.1020         | 0.134           | 0.128                 | 0.1350          | 0.0240     | 0.1410              | 0.1940      | 0.191            | 0.1890         | 0.020 |
| 11       | 0.0907         | 0.120           | 0.116                 | 0.1210          | 0.0260     | 0.1250              | 0.1910      | 0.188            | 0.2030         | 0.024 |
| 12       | 0.0808         | 0.109           | 0.104                 | 0.1060          | 0.0280     | 0.1090              | 0.1890      | 0.185            | 0.2160         | 0.028 |
| 13       | 0.0720         | 0.095           | 0.092                 | 0.0915          | 0.0300     | 0.0938              | 0.1850      | 0.182            | 0.2290         | 0.032 |
| 14       | 0.0641         | 0.083           | 0.080                 | 0.0800          | 0.0320     | 0.0781              | 0.1820      | 0.180            | 0.2420         | 0.036 |
| 15       | 0.0571         | 0.072           | 0.072                 | 0.0720          | 0.0340     | 0.0703              | 0.1800      | 0.178            | 0.2550         | 0.040 |
| 16       | 0.0508         | 0.065           | 0.064                 | 0.0625          | 0.0360     | 0.0625              | 0.1770      | 0.175            | 0.2680         | 0.045 |
| 17       | 0.0453         | 0.058           | 0.056                 | 0.0540          | 0.0380     | 0.0563              | 0.1730      | 0.172            | 0.2820         | 0.050 |
| 18       | 0.0403         | 0.049           | 0.048                 | 0.0475          | 0.0400     | 0.0500              | 0.1695      | 0.168            | 0.2950         | 0.055 |
| 19       | 0.0359         | 0.042           | 0.040                 | 0.0410          | 0.0420     | 0.0438              | 0.1660      | 0.164            | 0.3080         | 0.060 |
| 20       | 0.0320         | 0.035           | 0.036                 | 0.0348          | 0.0440     | 0.0375              | 0.1610      | 0.161            | 0.3210         | 0.070 |
| 21       | 0.0285         | 0.032           | 0.032                 | 0.0318          | 0.0460     | 0.0344              | 0.1590      | 0.157            | 0.3340         | 0.080 |
| 22       | 0.0254         | 0.028           | 0.028                 | 0.0286          | 0.0480     | 0.0313              | 0.1570      | 0.155            | 0.3470         | 0.090 |
| 23       | 0.0226         | 0.025           | 0.024                 | 0.0258          | 0.0510     | 0.0281              | 0.1540      | 0.153            | 0.3610         | 0.100 |
| 24       | 0.0201         | 0.022           | 0.022                 | 0.0230          | 0.0550     | 0.0250              | 0.1520      | 0.151            | 0.3740         | 0.125 |
| 25       | 0.0179         | 0.020           | 0.020                 | 0.0204          | 0.0590     | 0.0219              | 0.1500      | 0.148            | 0.3870         | 0.250 |

## Metal Gages in Common Use.—(Continued)

| Gage No. | Brown & Sharpe | Birmingham wire | British Imperial wire | Washburn & Moen | Music wire | U.S. Standard Plate | Twist drill | Stub steel wire | American screw | Zinc  |
|----------|----------------|-----------------|-----------------------|-----------------|------------|---------------------|-------------|-----------------|----------------|-------|
| 26       | 0.0159         | 0.018           | 0.018                 | 0.0181          | 0.0630     | 0.0188              | 0.1470      | 0.146           | 0.4000         | 0.375 |
| 27       | 0.0142         | 0.016           | 0.0164                | 0.0173          | 0.0670     | 0.0172              | 0.1440      | 0.143           | 0.4130         | 0.500 |
| 28       | 0.0126         | 0.014           | 0.0148                | 0.0162          | 0.0710     | 0.0156              | 0.1410      | 0.139           | 0.4260         | 1.000 |
| 29       | 0.0113         | 0.013           | 0.0136                | 0.0150          | 0.0740     | 0.0141              | 0.1360      | 0.134           | 0.4390         |       |
| 30       | 0.0100         | 0.012           | 0.0124                | 0.0140          | 0.0780     | 0.0125              | 0.1285      | 0.127           | 0.4530         |       |
| 31       | 0.0089         | 0.010           | 0.0116                | 0.0132          | 0.0820     | 0.0109              | 0.1200      | 0.120           | 0.4660         |       |
| 32       | 0.0079         | 0.009           | 0.0108                | 0.0128          | 0.0860     | 0.0101              | 0.1150      | 0.115           | 0.4790         |       |
| 33       | 0.0071         | 0.008           | 0.0100                | 0.0118          | 0.0900     | 0.0094              | 0.1130      | 0.112           | 0.4920         |       |
| 34       | 0.0063         | 0.007           | 0.0092                | 0.0104          | 0.0940     | 0.0086              | 0.1110      | 0.110           | 0.5050         |       |
| 35       | 0.0056         | 0.005           | 0.0084                | 0.0095          | 0.0980     | 0.0078              | 0.1100      | 0.108           | 0.5180         |       |
| 36       | 0.0050         | 0.004           | 0.0076                | 0.0090          | 0.1020     | 0.0070              | 0.1065      | 0.106           | 0.5320         |       |
| 37       | 0.0044         | .....           | 0.0068                | 0.0085          | 0.1060     | 0.0066              | 0.1040      | 0.103           | 0.5450         |       |
| 38       | 0.0040         | .....           | 0.0060                | 0.0080          | 0.1120     | 0.0063              | 0.1015      | 0.101           | 0.5580         |       |
| 39       | 0.0035         | .....           | 0.0052                | 0.0075          | 0.1180     | .....               | 0.0995      | 0.099           | 0.5710         |       |
| 40       | 0.0031         | .....           | 0.0048                | 0.0070          | 0.1250     | .....               | 0.0980      | 0.097           | 0.5840         |       |
| 41       | .....          | .....           | 0.0044                | 0.0066          | .....      | .....               | 0.0960      | 0.095           | 0.597          |       |
| 42       | .....          | .....           | 0.0040                | 0.0062          | .....      | .....               | 0.0935      | 0.092           | 0.611          |       |
| 43       | .....          | .....           | 0.0036                | 0.0060          | .....      | .....               | 0.0890      | 0.088           | 0.624          |       |
| 44       | .....          | .....           | 0.0032                | 0.0058          | .....      | .....               | 0.0860      | 0.085           | 0.637          |       |
| 45       | .....          | .....           | 0.0028                | 0.0055          | .....      | .....               | 0.0820      | 0.081           | 0.650          |       |
| 46       | .....          | .....           | 0.0024                | 0.0052          | .....      | .....               | 0.0810      | 0.079           | 0.663          |       |
| 47       | .....          | .....           | 0.0020                | 0.0050          | .....      | .....               | 0.0785      | 0.077           | 0.676          |       |
| 48       | .....          | .....           | 0.0016                | 0.0048          | .....      | .....               | 0.0760      | 0.075           | 0.690          |       |
| 49       | .....          | .....           | 0.0012                | 0.0046          | .....      | .....               | 0.0730      | 0.072           | 0.703          |       |
| 50       | .....          | .....           | 0.0010                | 0.0044          | .....      | .....               | 0.0700      | 0.069           | 0.716          |       |
| 51       | .....          | .....           | .....                 | .....           | .....      | .....               | 0.0670      |                 |                |       |
| 52       | .....          | .....           | .....                 | .....           | .....      | .....               | 0.0635      |                 |                |       |
| 53       | .....          | .....           | .....                 | .....           | .....      | .....               | 0.0595      |                 |                |       |
| 54       | .....          | .....           | .....                 | .....           | .....      | .....               | 0.0550      |                 |                |       |
| 55       | .....          | .....           | .....                 | .....           | .....      | .....               | 0.0520      |                 |                |       |
| 56       | .....          | .....           | .....                 | .....           | .....      | .....               | 0.0465      |                 |                |       |
| 57       | .....          | .....           | .....                 | .....           | .....      | .....               | 0.0430      |                 |                |       |
| 58       | .....          | .....           | .....                 | .....           | .....      | .....               | 0.0420      |                 |                |       |
| 59       | .....          | .....           | .....                 | .....           | .....      | .....               | 0.0410      |                 |                |       |
| 60       | .....          | .....           | .....                 | .....           | .....      | .....               | 0.0400      |                 |                |       |

### Hardness Numbers

The Brinell method of determining hardness is by the indentation effect of a hard ball pressed into the surface of the metal to be tested. Tables of hardness numbers corresponding to the various indentation measurements are furnished by the makers.

The Scleroscope, or "Shore," method measures hardness by a comparison of the effect of the drop and rebound of a diamond-tipped hammer dropping by gravity from a fixed height. The resulting rebound is then read on a graduated scale.

The Rockwell hardness tester measures hardness by determining the depth of penetration under load of a steel ball or diamond cone in the material being tested. Rockwell hardness is expressed as a number, which is read on a graduated gage.

The Moh hardness scale for abrasives and minerals is measured by scratch comparison, the mineral talc being taken as 1, and the diamond as 10 on the scale. This method is only an approximation for mineral comparison, and the Knoop indenter is used for measuring comparative hardness of hard materials.

The Vickers method is similar to the Brinell and Rockwell methods except that a diamond in the form of a pyramid is used as the penetrator. It is thus suitable for measuring metals of high hardness.

The Bierbaum microcharacter, or Bierbaum number, is used to determine the hardness by scratch. The width of a scratch made by drawing the point of a cube-shaped diamond across the surface under a 3-gram load is measured with a microscope and determines the degree of hardness.

### Comparative Hardness of Hard Abrasives

(Scale: Diamond 10, Corundum 9)

|                                                 |       |
|-------------------------------------------------|-------|
| South American brown bort.....                  | 10.00 |
| South American Ballas.....                      | 9.99  |
| Belgian Congo yellow (cubic crystals).....      | 9.96  |
| Belgian Congo clear white (cubic crystals)..... | 9.95  |
| Belgian Congo gray opaque (cubic crystals)..... | 9.89  |
| South American carbonados.....                  | 9.82  |
| Boron carbide.....                              | 9.32  |
| Black silicon carbide.....                      | 9.15  |
| Green silicon carbide.....                      | 9.13  |
| Tungsten carbide (13% cobalt).....              | 9.09  |
| Fused alumina (3.14% TiO <sub>2</sub> ).....    | 9.06  |
| Fused alumina.....                              | 9.03  |
| African crystal corundum.....                   | 9.00  |
| Rock-crystal quartz.....                        | 8.94  |

**Approximate Relationship of Vickers, Shore (Scleroscope), Rockwell, and Brinell Hardness Numbers**

| Vickers<br>or Firth | Shore or<br>Sclero-<br>scope | Rockwell |     | Brinell | Approximate<br>Tensile<br>Strength of<br>Steels, lb.<br>per sq. in. | Hardness<br>Class of<br>Steel        |
|---------------------|------------------------------|----------|-----|---------|---------------------------------------------------------------------|--------------------------------------|
|                     |                              | C        | B   |         |                                                                     |                                      |
| 1,220               | 96                           | 68       | ... | 780     | 329,000-<br>380,000                                                 | Hard<br>to file                      |
| 1,114               | 94                           | 67       | ... | 745     |                                                                     |                                      |
| 1,021               | 92                           | 65       | ... | 712     |                                                                     |                                      |
| 940                 | 89                           | 63       | ... | 682     |                                                                     |                                      |
| 867                 | 86                           | 62       | ... | 653     |                                                                     |                                      |
| 803                 | 84                           | 60       | ... | 627     | 165,000-<br>317,000                                                 | Machining<br>operations<br>difficult |
| 746                 | 81                           | 58       | ... | 601     |                                                                     |                                      |
| 694                 | 78                           | 56       | ... | 578     |                                                                     |                                      |
| 649                 | 75                           | 55       | ... | 555     |                                                                     |                                      |
| 608                 | 73                           | 53       | ... | 534     |                                                                     |                                      |
| 587                 | 71                           | 51       | ... | 514     |                                                                     |                                      |
| 551                 | 68                           | 50       | ... | 495     |                                                                     |                                      |
| 534                 | 66                           | 48       | ... | 477     |                                                                     |                                      |
| 502                 | 64                           | 47       | ... | 461     |                                                                     |                                      |
| 474                 | 62                           | 46       | ... | 444     |                                                                     |                                      |
| 460                 | 60                           | 44       | ... | 429     |                                                                     |                                      |
| 435                 | 58                           | 43       | ... | 415     |                                                                     |                                      |
| 423                 | 56                           | 42       | ... | 401     |                                                                     |                                      |
| 401                 | 54                           | 41       | ... | 388     |                                                                     |                                      |
| 390                 | 52                           | 39       | ... | 375     |                                                                     |                                      |
| 380                 | 51                           | 38       | ... | 363     |                                                                     |                                      |
| 361                 | 49                           | 37       | ... | 352     |                                                                     |                                      |
| 344                 | 48                           | 36       | ... | 341     | 78,000-<br>159,000                                                  | Commercial<br>machine<br>range       |
| 335                 | 46                           | 35       | ... | 331     |                                                                     |                                      |
| 320                 | 45                           | 34       | ... | 321     |                                                                     |                                      |
| 312                 | 43                           | 32       | ... | 311     |                                                                     |                                      |
| 305                 | 42                           | 31       | ... | 302     |                                                                     |                                      |
| 291                 | 41                           | 30       | ... | 293     |                                                                     |                                      |
| 285                 | 40                           | 29       | ... | 285     |                                                                     |                                      |
| 278                 | 38                           | 28       | ... | 277     |                                                                     |                                      |
| 272                 | 37                           | 27       | ... | 269     |                                                                     |                                      |
| 261                 | 36                           | 26       | ... | 262     |                                                                     |                                      |
| 255                 | 35                           | 25       | ... | 255     |                                                                     |                                      |
| 250                 | 34                           | 24       | 100 | 248     |                                                                     |                                      |
| 240                 | 33                           | 23       | 99  | 241     |                                                                     |                                      |
| 235                 | 32                           | 22       | 99  | 235     |                                                                     |                                      |
| 226                 | 32                           | 21       | 98  | 229     |                                                                     |                                      |
| 221                 | 31                           | 20       | 97  | 223     |                                                                     |                                      |
| 217                 | 30                           | 18       | 96  | 217     |                                                                     |                                      |
| 213                 | 30                           | 17       | 95  | 212     |                                                                     |                                      |
| 209                 | 29                           | 16       | 95  | 207     |                                                                     |                                      |
| 197                 | 28                           | 14       | 93  | 197     |                                                                     |                                      |
| 186                 | 27                           | 12       | 91  | 187     |                                                                     |                                      |
| 177                 | 25                           | 10       | 89  | 179     |                                                                     |                                      |
| 171                 | 24                           | 8        | 87  | 170     |                                                                     |                                      |
| 154                 | 23                           | 4        | 83  | 156     |                                                                     |                                      |
| 144                 | 21                           | 0        | 79  | 143     |                                                                     |                                      |

**Moh Hardness Scale for Minerals**

| Original Moh scale |            | Modified Moh scale |                    | Bierbaum number           |
|--------------------|------------|--------------------|--------------------|---------------------------|
| Hardness number    | Mineral    | Hardness number    | Material           |                           |
| 1                  | Talc       | 1                  | Talc               | 1                         |
| 2                  | Gypsum     | 2                  | Gypsum             | 15                        |
| 3                  | Calcite    | 3                  | Calcite            |                           |
| 4                  | Fluorite   | 4                  | Fluorite           |                           |
| 5                  | Apatite    | 5                  | Apatite            |                           |
| 6                  | Orthoclase | 6                  | Orthoclase         |                           |
|                    |            | 7                  | Vitreous silica    |                           |
| 7                  | Quartz     | 8                  | Quartz or stellite | 10,000 (1 micron scratch) |
| 8                  | Topaz      | 9                  | Topaz              |                           |
|                    |            | 10                 | Garnet             |                           |
|                    |            | 11                 | Fused zirconia     |                           |
| 9                  | Corundum   | 12                 | Fused alumina      |                           |
|                    |            | 13                 | Silicon carbide    |                           |
|                    |            | 14                 | Boron carbide      |                           |
| 10                 | Diamond    | 15                 | Diamond            |                           |

**Hardness Grades in Woods**

1. Exceedingly hard. Lignum-vitae, ebony
2. Extremely hard... Boxwood, lilac, jarrah, karri
3. Very hard..... Whitehorn, blackthorn, persimmon
4. Hard..... Hornbeam, elder, yew
5. Rather hard..... Ash, holly, plum, elm
6. Firm..... Teak, chestnut, beech, walnut, apple, oak
7. Soft..... Willow, deal, alder, Australian red cedar, birch, hazel
8. Very soft..... White pine, poplar, redwood.

**Knoop Indentor Hardness of Hard Materials**

|                                  |             |
|----------------------------------|-------------|
| Diamond                          | 6,000-6,500 |
| Boron carbide                    | 2,250-2,260 |
| Silicon carbide                  | 2,130-2,140 |
| Sapphire                         | 1,600-2,100 |
| Aluminum oxide (corundum)        | 1,635-1,680 |
| Tungsten carbide (cobalt binder) | 1,000-1,500 |
| Spinel                           | 1,200-1,400 |
| Topaz                            | 1,250       |
| Quartz                           | 710- 790    |
| Hardened steel                   | 400- 800    |
| Glass                            | 300- 600    |

## Temperature Conversion Scale

To change a temperature in degrees centigrade, to degrees Fahrenheit, multiply by  $\frac{9}{5}$  and add 32, thus,  $F = \frac{9}{5} C + 32$ . To change degrees Fahrenheit, to degrees centigrade, subtract 32 and multiply by  $\frac{5}{9}$ , thus  $C = \frac{5}{9} F - 32$ .

| C.  | F.  | C.  | F.  | C.  | F.   | C.  | F.   | C.   | F.   |
|-----|-----|-----|-----|-----|------|-----|------|------|------|
| 0   | 32  | 230 | 446 | 460 | 860  | 690 | 1274 | 920  | 1688 |
| 5   | 41  | 235 | 455 | 465 | 869  | 695 | 1283 | 925  | 1697 |
| 10  | 50  | 240 | 464 | 470 | 878  | 700 | 1292 | 930  | 1706 |
| 15  | 59  | 245 | 473 | 475 | 887  | 705 | 1301 | 935  | 1715 |
| 20  | 68  | 250 | 482 | 480 | 896  | 710 | 1310 | 940  | 1724 |
| 25  | 77  | 255 | 491 | 485 | 905  | 715 | 1319 | 945  | 1733 |
| 30  | 86  | 260 | 500 | 490 | 914  | 720 | 1328 | 950  | 1742 |
| 35  | 95  | 265 | 509 | 495 | 923  | 725 | 1337 | 955  | 1751 |
| 40  | 104 | 270 | 518 | 500 | 932  | 730 | 1346 | 960  | 1760 |
| 45  | 113 | 275 | 527 | 505 | 941  | 735 | 1355 | 965  | 1769 |
| 50  | 122 | 280 | 536 | 510 | 950  | 740 | 1364 | 970  | 1778 |
| 55  | 131 | 285 | 545 | 515 | 959  | 745 | 1373 | 975  | 1787 |
| 60  | 140 | 290 | 554 | 520 | 968  | 750 | 1382 | 980  | 1796 |
| 65  | 149 | 295 | 563 | 525 | 977  | 755 | 1391 | 985  | 1805 |
| 70  | 158 | 300 | 572 | 530 | 986  | 760 | 1400 | 990  | 1814 |
| 75  | 167 | 305 | 581 | 535 | 995  | 765 | 1409 | 995  | 1823 |
| 80  | 176 | 310 | 590 | 540 | 1004 | 770 | 1418 | 1000 | 1832 |
| 85  | 185 | 315 | 599 | 545 | 1013 | 775 | 1427 | 1005 | 1841 |
| 90  | 194 | 320 | 608 | 550 | 1022 | 780 | 1436 | 1010 | 1850 |
| 95  | 203 | 325 | 617 | 555 | 1031 | 785 | 1445 | 1015 | 1859 |
| 100 | 212 | 330 | 626 | 560 | 1040 | 790 | 1454 | 1020 | 1868 |
| 105 | 221 | 335 | 635 | 565 | 1049 | 795 | 1463 | 1025 | 1877 |
| 110 | 230 | 340 | 644 | 570 | 1058 | 800 | 1472 | 1030 | 1886 |
| 115 | 239 | 345 | 653 | 575 | 1067 | 805 | 1481 | 1035 | 1895 |
| 120 | 248 | 350 | 662 | 580 | 1076 | 810 | 1490 | 1040 | 1904 |
| 125 | 257 | 355 | 671 | 585 | 1085 | 815 | 1499 | 1045 | 1913 |
| 130 | 266 | 360 | 680 | 590 | 1094 | 820 | 1508 | 1050 | 1922 |
| 135 | 275 | 365 | 689 | 595 | 1103 | 825 | 1517 | 1055 | 1931 |
| 140 | 284 | 370 | 698 | 600 | 1112 | 830 | 1526 | 1060 | 1940 |
| 145 | 293 | 375 | 707 | 605 | 1121 | 835 | 1535 | 1065 | 1949 |
| 150 | 302 | 380 | 716 | 610 | 1130 | 840 | 1544 | 1070 | 1958 |
| 155 | 311 | 385 | 725 | 615 | 1139 | 845 | 1553 | 1075 | 1967 |
| 160 | 320 | 390 | 734 | 620 | 1148 | 850 | 1562 | 1080 | 1976 |
| 165 | 329 | 395 | 743 | 625 | 1157 | 855 | 1571 | 1085 | 1985 |
| 170 | 338 | 400 | 752 | 630 | 1166 | 860 | 1580 | 1090 | 1994 |
| 175 | 347 | 405 | 761 | 635 | 1175 | 865 | 1589 | 1095 | 2003 |
| 180 | 356 | 410 | 770 | 640 | 1184 | 870 | 1598 | 1100 | 2012 |
| 185 | 365 | 415 | 779 | 645 | 1193 | 875 | 1607 | 1105 | 2021 |
| 190 | 374 | 420 | 788 | 650 | 1202 | 880 | 1616 | 1110 | 2030 |
| 195 | 383 | 425 | 797 | 655 | 1211 | 885 | 1625 | 1115 | 2039 |
| 200 | 392 | 430 | 806 | 660 | 1220 | 890 | 1634 | 1120 | 2048 |
| 205 | 401 | 435 | 815 | 665 | 1229 | 895 | 1643 | 1125 | 2057 |
| 210 | 410 | 440 | 824 | 670 | 1238 | 900 | 1652 | 1130 | 2066 |
| 215 | 419 | 445 | 833 | 675 | 1247 | 905 | 1661 | 1135 | 2075 |
| 220 | 428 | 450 | 842 | 680 | 1256 | 910 | 1670 | 1140 | 2084 |
| 225 | 437 | 455 | 851 | 685 | 1265 | 915 | 1679 | 1045 | 2093 |



### Index of Refraction

Index of refraction indicates the relative amount of light transmitted by a material. As the index of refraction increases, the transmitted light decreases. The amount of light reflected back may be considered as in inverse proportion to the amount transmitted, though much of the light may be dissipated. A vacuum transmits 100% of the light and reflects 0%, and has a refractive index of 1.00. A polished diamond with parallel sides will transmit only 83% of the light, and the reflected light makes the diamond shine. The sparkle of angle-cut diamonds and highly refractive cut glass is caused by the dissipated or deflected light emerging from the angles.

| Material                        | Index | Material                        | Index  |
|---------------------------------|-------|---------------------------------|--------|
| Diamond.....                    | 2.42  | Nylon.....                      | 1.53   |
| Ruby.....                       | 1.80  | Polyethylene plastic.....       | 1.52   |
| Sapphire (synthetic).....       | 1.77  | Pyrex (borosilicate glass)..... | 1.52   |
| Iceland spar.....               | 1.66  | Window glass (soda-lime).....   | 1.52   |
| Flint glass (dense leaded)..... | 1.66  | Acrylic plastics.....           | 1.50   |
| Flint glass (dense barium)..... | 1.62  | Cellulose acetate.....          | 1.48   |
| Vinylidene chloride.....        | 1.61  | Cellulose acetate butyrate..... | 1.47   |
| Polystyrene plastic.....        | 1.59  | Ethyl cellulose.....            | 1.47   |
| Flint glass (light leaded)..... | 1.58  | Fused quartz.....               | 1.46   |
| Flint glass (light barium)..... | 1.57  | Water.....                      | 1.33   |
| Amber.....                      | 1.55  | Ice.....                        | 1.30   |
| Quartz crystal.....             | 1.54  | Air.....                        | 1.0003 |
| Urea-formaldehyde.....          | 1.54  | Vacuum.....                     | 1.00   |

### Acidity and Alkalinity Scale

The degree of acidity or alkalinity of solutions is expressed by the pH value. Water is considered as neutral and is given a pH value of 7. Values below 7 are acid, each declining value being 10 times more acid than the previous value. A pH of 6 is 10 times more acid than a pH of 7, and a pH of 3 is 10,000 times more acid than pH 7. Solutions having values from 7 to 14 are alkaline by the same multiples of 10. A pH of 14 is 10 million times more alkaline than a pH of 7. Chemical indicators used to indicate the acidity or alkalinity of solutions are shown at the top of the opposite page.

|                         | pH range | Color change   |
|-------------------------|----------|----------------|
| Meta cresol purple..... | 1.2-2.8  | Red to yellow  |
| Thymol blue.....        | 1.2-2.8  | Red to yellow  |
| Bromophenol blue.....   | 3.0-4.6  | Yellow to blue |
| Bromocresol green.....  | 4.0-5.6  | Yellow to blue |
| Chlorphenol red.....    | 5.2-6.8  | Yellow to red  |
| Bromthymol blue.....    | 6.0-7.6  | Yellow to blue |
| Phenol red.....         | 6.8-8.4  | Yellow to red  |
| Cresol red.....         | 7.2-8.8  | Yellow to red  |
| Thymol blue.....        | 8.0-9.6  | Red to blue    |

### Viscosity of Liquids

The viscosity of a liquid is its resistance to change in its form caused by the internal friction of its particle components. Thus, the higher the viscosity the less fluid it is. When a liquid is hot, there is less internal friction owing to the greater motion and distance apart of the molecules, and the liquid will flow more readily than when it is cold. Thus, all comparisons of viscosity should be at the same temperature. Kinematic viscosity is the ratio of viscosity to density. Specific viscosity is the ratio of the viscosity of any liquid to that of water at the same temperature. The reciprocal of viscosity is called Fluidity. Viscosity is usually expressed in poises or centipoises, a poise being equal to 1 gram per cm per sec.

| Liquid                        | Viscosity,<br>centipoises | Liquid                     | Viscosity,<br>centipoises |
|-------------------------------|---------------------------|----------------------------|---------------------------|
| Benzene (0°C.).....           | 0.906                     | Linseed oil (30°C.).....   | 33.1                      |
| Carbon tetrachloride (0°C.).. | 1.35                      | Soybean oil (30°C.).....   | 40.6                      |
| Mercury (0°C.).....           | 1.68                      | Sperm oil (15°C.).....     | 42.0                      |
| Ethyl alcohol (0°C.).....     | 1.77                      | Sulphuric acid (0°C.)..... | 48.4                      |
| Water (0°C.).....             | 1.79                      | Castor oil (10°C.).....    | 2,420                     |
| Phenol (18°C.).....           | 12.7                      | Rape oil (0°C.).....       | 2,530                     |

### Specific Gravity of Liquids

The specific gravity of a liquid is the relative weight per unit volume of the liquid compared with the weight per unit volume of pure water. Water is arbitrarily assigned the value of 1.000 gram per cubic centimeter.

## Specific Gravity Conversion Table

(All readings taken at 60°F)

| Specific Gravity | Light Baumé degrees | Heavy Baumé degrees | Pounds per gal. | Gallons per lb |
|------------------|---------------------|---------------------|-----------------|----------------|
| 0.6731           | 78                  | ...                 | 5.60            | 0.1786         |
| 0.6863           | 74                  | ...                 | 5.72            | 0.1748         |
| 0.7000           | 70                  | ...                 | 5.83            | 0.1715         |
| 0.7071           | 68                  | ...                 | 5.89            | 0.1698         |
| 0.7216           | 64                  | ...                 | 6.01            | 0.1664         |
| 0.7368           | 60                  | ...                 | 6.14            | 0.1629         |
| 0.7527           | 56                  | ...                 | 6.27            | 0.1595         |
| 0.7692           | 52                  | ...                 | 6.41            | 0.1560         |
| 0.7865           | 48                  | ...                 | 6.55            | 0.1527         |
| 0.8046           | 44                  | ...                 | 6.70            | 0.1493         |
| 0.8235           | 40                  | ...                 | 6.86            | 0.1458         |
| 0.8434           | 36                  | ...                 | 7.03            | 0.1422         |
| 0.8642           | 32                  | ...                 | 7.20            | 0.1389         |
| 0.8861           | 28                  | ...                 | 7.38            | 0.1355         |
| 0.9091           | 24                  | ...                 | 7.57            | 0.1321         |
| 0.9333           | 20                  | ...                 | 7.78            | 0.1285         |
| 0.9589           | 16                  | ...                 | 7.99            | 0.1252         |
| 0.9722           | 14                  | ...                 | 8.10            | 0.1235         |
| 0.9859           | 12                  | ...                 | 8.21            | 0.1218         |
| 1.000            | 10                  | 0                   | 8.33            | 0.1200         |
| 1.007            | ...                 | 1                   | 8.38            | 0.1193         |
| 1.014            | ...                 | 2                   | 8.46            | 0.1182         |
| 1.021            | ...                 | 3                   | 8.50            | 0.1176         |
| 1.028            | ...                 | 4                   | 8.56            | 0.1168         |
| 1.043            | ...                 | 6                   | 8.69            | 0.1151         |
| 1.058            | ...                 | 8                   | 8.81            | 0.1135         |
| 1.074            | ...                 | 10                  | 8.94            | 0.1119         |
| 1.090            | ...                 | 12                  | 9.08            | 0.1101         |
| 1.107            | ...                 | 14                  | 9.21            | 0.1086         |
| 1.124            | ...                 | 16                  | 9.36            | 0.1068         |
| 1.142            | ...                 | 18                  | 9.51            | 0.1052         |
| 1.160            | ...                 | 20                  | 9.67            | 0.1034         |
| 1.198            | ...                 | 24                  | 9.99            | 0.1001         |
| 1.239            | ...                 | 28                  | 10.32           | 0.0969         |
| 1.283            | ...                 | 32                  | 10.69           | 0.0935         |
| 1.330            | ...                 | 36                  | 11.09           | 0.0902         |
| 1.381            | ...                 | 40                  | 11.51           | 0.0869         |

Thus, all liquids heavier than water have specific gravities greater than 1.000, and all liquids lighter than water have specific gravities less than 1.000.

Specific gravities may be given in the direct numeral relation to water, usually to three or four decimal places, or they may be given in terms of Degrees Baumé. The specific gravity of a liquid may be measured directly by means of a Hygrometer, which is a weighted and graduated glass cylinder designed to float vertically in a liquid. The value of the specific gravity, or of the corresponding numerical figure representing the Degree Baumé, is read from the graduation at the liquid surface. Since the density of a liquid varies with the temperature, readings are taken at a uniform temperature, usually 60°F or 15°C.

### Color Determination of Lubricating Oils

Color determination of lubricating oils and petrolatum is made by comparison with standard colored disks. Light is dispersed through a 4-oz sample bottle of the oil to be tested, and the color is compared visually with the gelatine colors on the glass. The colors on the standard glass disks of the National Petroleum Association are as follows:

|    |                   |    |             |
|----|-------------------|----|-------------|
| 1  | Lily white        | 4  | Orange pale |
| 1½ | Cream white       | 4½ | Pale        |
| 2  | Extra pale        | 5  | Light red   |
| 2½ | Extra lemon pale  | 6  | Dark red    |
| 3  | Lemon pale        | 7  | Claret red  |
| 3½ | Extra orange pale |    |             |

### Gasoline and Fuel Oil Rating

The **Cetane Number** of a diesel fuel is numerically equal to the percentage by volume of cetane in a mixture of cetane and *α*-methylnaphthalene which will match the fuel in ignition quality. Cetane has the composition  $\text{CH}_3(\text{CH}_2)_{14}\text{CH}_3$ , and *α*-methylnaphthalene  $\text{CH}_3 \cdot \text{C}_{10}\text{H}_7$ . The cetane number of a fuel is given as the nearest whole number. Thus, if it required 49.8% of cetane in the mixture to match, the number would be 50.

The **Octane Number** of a fuel is the whole number nearest to the percentage by volume of iso-octane,  $(\text{CH}_3)_3\text{C} \cdot \text{CH}_2\text{CH}(\text{CH}_3)_2$ , in a blend of iso-octane and normal heptane,  $\text{CH}_3(\text{CH}_2)_5\text{CH}_3$ , that the fuel matches in knock characteristics.

### Measurement of Impact Strength

The Impact Strength of a material is its ability to withstand a sudden hard blow, and depends upon the toughness of the material. Two standard methods are used to measure impact strength.

The **Charpy Method** consists in the resultant of a single blow of a weighted pendulum at the center of the test sample which is supported at both ends and in a horizontal position. The sample may or may not be notched. The **Izod Method** is similar to the Charpy method except that the test sample is held vertically at one end only. The test sample is always notched so that it will not break at the support. Impact strength is measured in foot-pounds of energy necessary to break the test sample.

## PHYSICAL PROPERTIES OF MATERIALS

### Definitions of Physical and Chemical Properties

**Acid number** is the weight in milligrams of potassium hydroxide required to neutralize the fatty acid in 1 gram of fat or fatty oil.

**Aliphatic.** Having a straight chainlike molecular structure.

**Aromatic.** Having a ringlike molecular structure.

**Anhydrous.** Having no water of crystallization in the molecule. A hydrated compound contains water of crystallization which can be driven off by heating.

**Brittleness.** The property of breaking without perceptible warning or without visible deformation.

**Conductivity.** The relative rate at which a material conducts heat or electricity at normal temperature (60°F). Silver is the standard of reference, as it is the best known conductor of both heat and electricity.

**Ductility.** The property of being permanently deformed by tension without rupture, that is, the ability to be drawn from a large to a small size.

**Elasticity.** The ability of a material to resume its original form after the removal of the force which has produced a change in form. A substance is highly elastic which is easily deformed and quickly recovers.

**Elastic limit.** The greatest unit stress that a material is capable of withstanding without permanent deformation.

**Elongation.** The increase in length of a bar or section under test expressed as a percentage difference between the original length and the length at the moment of rupture.

**Factor of safety.** The ratio of the ultimate strength of a material to its working stress.

**Flash point.** The minimum temperature in degrees Fahrenheit at which a material or its vapor will ignite or explode.

**Flow, or creep.** The gradual continuous distortion of a material under continued load, usually at high temperatures.

**Fusibility.** The ease with which a material is melted.

**Hardness.** A property applied to solids and very viscous liquids to indicate solidity and firmness in substance or outline. A hard substance does not readily receive an indentation.

**Hygroscopic.** Readily absorbing and retaining moisture.

**Impact strength.** The force in foot-pounds required to break a material when applied with a sudden blow.

**Iodine value** is the number of grams of iodine absorbed by 100 grams of fat or fatty oil. It gives a measure of the chemical unsaturation of an oil or fat. High iodine value, 117 to 206, in vegetable oils, indicates suitability of the oil for use in paints. Low iodine value, not subject to oxidation, indicates nondrying suitable for soaps.

**Malleability.** The property of being permanently deformed by compression without rupture, that is, the ability to be rolled or hammered into thin sheets.

**Modulus of elasticity.** The ratio of the unit stress to unit strain.

**Modulus of rigidity.** When an elastic material is subjected to a shearing stress, a displacement takes place; the ratio of the unit shearing stress to the displacement per unit length is the modulus of rigidity.

**Plasticity.** The property in a material of being deformed under the action of a force and not returning to its original shape upon the removal of the force.

**Porosity.** The ratio of the volume of the interstices of a material to the volume of its mass.

**Reduction of area.** The percentage difference between the area of a bar before being subjected to stress and the area of the bar after rupture.

**Resilience.** The energy of elasticity, that is, the energy stored in a material under strain within its elastic limit which will cause it to resume its original shape when the extreme stress is removed. The modulus of resilience is the capacity of a unit volume to store energy up to the elastic limit.

**Saponification value** is the number of milligrams of potassium hydroxide required to saponify 1 gram of fatty oil or grease.

**Shrinkage.** The diminution in dimensions and mass of a material.

**Solubility.** Capacity for being dissolved in a liquid so that it will not separate out on standing, except the excess over the percentage which the liquid (solvent) will dissolve. A suspension is a physical dispersion of particles sufficiently large that physical forces control their dissolution in the liquid. A colloidal solution is a dispersion of particles so finely divided that surface phenomena and kinetic energy control their behavior in the liquid. A colloidal solution is close to a molecular combination.

**Specific gravity** is the ratio of the weight of a given volume of a material to the weight of an equal volume of pure water at 4°C.

**Specific heat** is the number of calories required to raise 1 gram of the material 1°C in temperature.

**Stiffness.** The material property which is measured by the rate at which the stress in a material increases with the strain.

**Strain.** The distortion set up in a material by the action of an external force.

**Strength.** The ability to resist physical forces imposed upon a material.

**Stress.** Internal forces set up in a material by the action of an external force.

**Tensile strength.** The maximum tensile load per square unit of original cross section that a material is able to withstand. Tensile strength is the most common measure of the strength and ductility of metals.

**Thermal conductivity** is the number of calories transmitted per second between opposite faces of a cube, 1 cm by 1 cm by 1 cm, when the difference between the opposite faces of the cube is 1°C.

**Thermal expansion.** The coefficient of linear thermal expansion is the increase in unit length with each change of 1 deg in temperature.

**Thermoplastic.** Capable of being molded and remolded without rupture by heat and pressure at temperatures slightly above normal. When a material sets under heat and pressure into a hard solid not capable of being remolded, it is called Thermosetting.

**Toughness.** The relative degree of resistance to impact without fracture; the property of a material which enables it to absorb energy while being stressed above its elastic limit but without being fractured.

**Ultimate strength.** The stress, calculated on the maximum value of the force and the original area of cross section, which causes fracture of the material.

**Valency.** The capacity of an atom or radical to combine with other atoms. A radical is a group of atoms so combined as to act as a single atom, such as the hydroxyl radical —OH. Different atoms have different valencies. Hydrogen has a valency of 1, oxygen has a valency of 2. It thus requires 2 atoms of hydrogen to combine with 1 atom of oxygen to form a stable compound  $H_2O$ .

**Yield point.** The minimum tensile stress required to produce continuous deformation in a solid material.



**Modulus of Elasticity in Tension of Typical Materials**

|                                            |            |
|--------------------------------------------|------------|
| Lead (cast).....                           | 700,000    |
| Lead (hard-drawn).....                     | 1,000,000  |
| Bakelite (fabric laminated).....           | 1,000,000  |
| Pine (static bending).....                 | 1,200,000  |
| Ash (static bending).....                  | 1,300,000  |
| Bakelite (paper base).....                 | 2,100,000  |
| Tin (cast).....                            | 4,000,000  |
| Tin (rolled).....                          | 5,700,000  |
| Glass.....                                 | 8,000,000  |
| Brass.....                                 | 9,000,000  |
| Aluminum (cast).....                       | 10,000,000 |
| Duralumin.....                             | 10,000,000 |
| Copper (cast).....                         | 11,000,000 |
| Zinc (cast).....                           | 11,000,000 |
| Zinc (rolled).....                         | 12,000,000 |
| Cast iron (soft gray iron).....            | 12,000,000 |
| Brass (cast).....                          | 13,000,000 |
| Bronze (average).....                      | 13,000,000 |
| Phosphor bronze.....                       | 13,000,000 |
| Manganese bronze (cast).....               | 14,000,000 |
| Slate.....                                 | 14,000,000 |
| Copper (soft, wrought).....                | 15,000,000 |
| Duronze.....                               | 15,500,000 |
| Cast iron (average, with steel scrap)..... | 16,000,000 |
| Clock brass.....                           | 16,600,000 |
| Copper (hard-drawn).....                   | 18,000,000 |
| Cast iron (hard, white iron).....          | 20,000,000 |
| Meehanite metal.....                       | 22,000,000 |
| Monel metal.....                           | 23,000,000 |
| Malleable iron.....                        | 23,000,000 |
| Wrought iron.....                          | 27,000,000 |
| Carbon steel.....                          | 30,000,000 |
| Alloy steel (nickel-chromium).....         | 30,000,000 |
| Nickel.....                                | 30,000,000 |
| Tungsten.....                              | 60,000,000 |

**Order of Ductility of Metals**

- |             |             |
|-------------|-------------|
| 1. Gold     | 6. Aluminum |
| 2. Platinum | 7. Nickel   |
| 3. Silver   | 8. Zinc     |
| 4. Iron     | 9. Tin      |
| 5. Copper   | 10. Lead    |

**Melting Points of Materials  
Commonly Used for Heat-treating Baths**

| Material                                                        | Melting points |         |
|-----------------------------------------------------------------|----------------|---------|
|                                                                 | Deg. F.        | Deg. C. |
| 35 per cent lead }<br>65 per cent tin }                         | 358            | 181     |
| 50 per cent sodium nitrate }<br>50 per cent potassium nitrate } | 424            | 218     |
| Tin.....                                                        | 450            | 232     |
| Sodium nitrate.....                                             | 586            | 308     |
| Lead.....                                                       | 620            | 327     |
| Potassium nitrate.....                                          | 642            | 339     |
| 45 per cent sodium chloride }<br>55 per cent sodium sulphate }  | 1154           | 623     |
| Sodium chloride (common salt).....                              | 1474           | 801     |
| Sodium sulphate.....                                            | 1618           | 881     |
| Barium chloride.....                                            | 1760           | 960     |

**Forging Temperatures of Steels**

|                                              | Maximum<br>forging<br>temperatures,<br>deg. F. | Burning<br>temperatures,<br>deg. F. |
|----------------------------------------------|------------------------------------------------|-------------------------------------|
| 1.5 per cent carbon steel.....               | 1920                                           | 2080                                |
| 1.1 per cent carbon steel.....               | 1980                                           | 2140                                |
| 0.9 per cent carbon steel.....               | 2050                                           | 2230                                |
| 0.7 per cent carbon steel.....               | 2140                                           | 2340                                |
| 0.5 per cent carbon steel.....               | 2280                                           | 2460                                |
| 0.2 per cent carbon steel.....               | 2410                                           | 2680                                |
| 0.1 per cent carbon steel.....               | 2460                                           | 2710                                |
| Silico-manganese spring steel.....           | 2280                                           | 2460                                |
| 3 per cent nickel steel.....                 | 2280                                           | 2500                                |
| 3 per cent nickel-chromium steel.....        | 2280                                           | 2500                                |
| Air-hardening Ni-Cr steel.....               | 2280                                           | 2500                                |
| 5 per cent nickel (casehardening) steel..... | 2320                                           | 2640                                |
| Chromium-vanadium steel.....                 | 2280                                           | 2460                                |
| High-speed steel.....                        | 2370                                           | 2520                                |
| Stainless steel.....                         | 2340                                           | 2520                                |
| Austenitic chromium-nickel steel.....        | 2370                                           | 2590                                |

**Temperatures Available for Melting and Welding**

|                                 |         |
|---------------------------------|---------|
| Direct electric arc.....        | 4000°C. |
| Oxygen-acetylene torch.....     | 3500°C. |
| Electric furnace.....           | 3000°C. |
| Aluminum-iron oxide powder..... | 2800°C. |
| Combustion furnace.....         | 1700°C. |
| Oxygen-hydrogen torch.....      | 1450°C. |

**Thermal Conductivity of Materials<sup>1</sup>**

Conductivity measured in British thermal units transmitted per hour per square foot of material 1 in. thick, per degree Fahrenheit difference in temperature of the two faces

|                             |         |                            |       |
|-----------------------------|---------|----------------------------|-------|
| Silver.....                 | 2,920.0 | Diatomite block.....       | 0.58  |
| Copper.....                 | 2,588.0 | Magnesia, 85 per cent..... | 0.51  |
| Steel, 1.0 carbon.....      | 328.0   | Wood pulp board.....       | 0.39  |
| Building stone.....         | 12.50   | Bagasse board.....         | 0.35  |
| Slate shingles.....         | 10.37   | Cork, ground.....          | 0.31  |
| Concrete, 1-2-4.....        | 6.10    | Flax fiber.....            | 0.31  |
| Glass, plate.....           | 5.53    | Diatomite powder.....      | 0.308 |
| Brickwork, mortar bond..... | 4.00    | Mineral wool.....          | 0.296 |
| Gypsum plaster.....         | 2.32    | Asbestos sheet.....        | 0.29  |
| Brick, dry.....             | 1.21    | Vermiculite.....           | 0.263 |
| Air space, 3½ in.....       | 1.10    | Wool.....                  | 0.261 |
| Pine wood.....              | 0.958   | Hair felt.....             | 0.26  |
| Clay tile.....              | 0.60    | Cotton, compressed.....    | 0.206 |

<sup>1</sup> From Paul M. Tyler, U.S. Bureau of Mines.

**Linear Expansion of Metals**

Unit length increase per degree centigrade rise in temperature

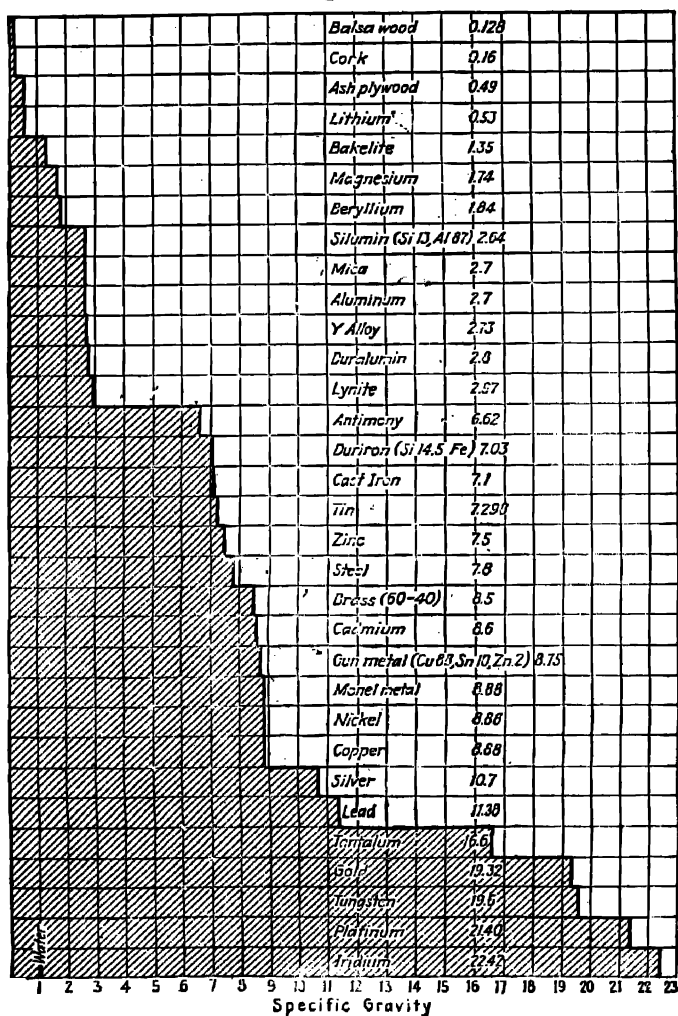
|                   |          |
|-------------------|----------|
| Cast iron.....    | 0.000010 |
| Steel.....        | 0.000011 |
| Cobalt.....       | 0.000012 |
| Bismuth.....      | 0.000013 |
| Gold.....         | 0.000014 |
| Nickel.....       | 0.000014 |
| Copper.....       | 0.000017 |
| Brass.....        | 0.000019 |
| Silver.....       | 0.000019 |
| Tobin bronze..... | 0.000021 |
| Aluminum.....     | 0.000024 |
| Zinc.....         | 0.000026 |
| Tin.....          | 0.000027 |
| Lead.....         | 0.000028 |
| Cadmium.....      | 0.000029 |
| Magnesium.....    | 0.000029 |

**Specific Gravities and Weights**

For rough estimating of common construction materials

|                         | Specific gravity | Weight, pounds per cubic foot |
|-------------------------|------------------|-------------------------------|
| Aluminum.....           | 2.6              | 165                           |
| Bronze.....             | 8.0              | 509                           |
| Cast iron.....          | 7.2              | 450                           |
| Copper.....             | 8.9              | 556                           |
| Glass.....              | 2.5              | 160                           |
| Lead.....               | 11.37            | 710                           |
| Magnesium.....          | 1.74             | 109                           |
| Nickel.....             | 8.9              | 556                           |
| Steel.....              | 7.8              | 490                           |
| Zinc.....               | 7.0              | 440                           |
| Ash, dry.....           | 0.63             | 40                            |
| Cedar, dry.....         | 0.36             | 22                            |
| Fir, dry.....           | 0.56             | 32                            |
| Maple, dry.....         | 0.65             | 43                            |
| Redwood, dry.....       | 0.42             | 26                            |
| White pine, dry.....    | 0.41             | 26                            |
| Granite.....            | 2.6              | 165                           |
| Limestone.....          | 2.5              | 165                           |
| Sandstone.....          | 1.8              | 110                           |
| Pressed brick.....      | 2.2              | 140                           |
| Common brick.....       | 1.9              | 120                           |
| Terra cotta.....        | 1.9              | 120                           |
| Concrete.....           | 2.3              | 144                           |
| Portland cement.....    | 3.0              | 183                           |
| Mortar.....             | 1.7              | 103                           |
| Earth, dry, loose.....  | .....            | 76                            |
| Earth, dry, packed..... | .....            | 95                            |
| Sand and gravel.....    | .....            | 60                            |
| Asbestos.....           | .....            | 153                           |
| Marble.....             | 2.7              | 170                           |
| Shale.....              | .....            | 92                            |
| Tar.....                | 1.2              | 75                            |
| Bluestone.....          | 2.5              | 159                           |

## Relative Weights of Materials



Average Fatty Acid Composition and Constants of Fats and Oils

|                      | Chemical formula        | Coconut | Palm kernel | Tallow  | Lard    | Palm    | Olive   | Cottonseed | Corn    | Peanut  | Soybean | Sunflower | Linseed | Perrilla | Castor  | Tung    | Whale   | Mechaden | Sardine | Herring |
|----------------------|-------------------------|---------|-------------|---------|---------|---------|---------|------------|---------|---------|---------|-----------|---------|----------|---------|---------|---------|----------|---------|---------|
| Saturated Acids      |                         |         |             |         |         |         |         |            |         |         |         |           |         |          |         |         |         |          |         |         |
| Caproic              | $C_6H_{12}O_2$          | 0.2     | Trace       |         |         |         |         |            |         |         |         |           |         |          |         |         |         |          |         |         |
| Caprylic             | $C_8H_{16}O_2$          | 8.0     | 3.0         |         |         |         |         |            |         |         |         |           |         |          |         |         |         |          |         |         |
| Capric               | $C_{10}H_{20}O_2$       | 7.0     | 6.0         |         |         |         |         |            |         |         |         |           |         |          |         |         |         |          |         |         |
| Lauric               | $C_{12}H_{24}O_2$       | 48.0    | 50.0        |         |         |         |         |            |         |         |         |           |         |          |         |         |         |          |         |         |
| Myristic             | $C_{14}H_{28}O_2$       | 17.5    | 15.0        | 2.0     | 1.0     | 1.0     | Trace   | 0.5        |         |         |         |           |         |          |         |         | 8.0     | 7.0      | 5.0     | 7.0     |
| Palmitic             | $C_{16}H_{32}O_2$       | 8.8     | 7.5         | 30.0    | 26.0    | 42.5    | 9.0     | 21.0       | 7.5     | 7.0     | 6.5     | 3.5       | 5.0     | 7.5      |         | 4.0     | 11.0    | 16.0     | 14.0    | 8.0     |
| Stearic              | $C_{18}H_{36}O_2$       | 2.0     | 1.5         | 21.0    | 11.5    | 4.0     |         | 2.0        | 3.5     | 5.0     | 4.5     | 3.0       | 3.5     | Trace    | 2.0     | 1.5     | 2.5     | 1.0      | 3.0     | Trace   |
| Arachidic            | $C_{20}H_{40}O_2$       |         |             |         |         |         | 0.2     | Trace      | 0.5     | 4.0     | 0.7     | 0.6       | Trace   |          |         |         |         |          |         |         |
| Behenic              | $C_{22}H_{44}O_2$       |         |             |         |         | Trace   |         |            |         |         |         |           |         |          |         |         |         |          |         |         |
| Lignoceric           | $C_{24}H_{48}O_2$       |         |             |         |         |         |         |            | 0.2     | 3.0     | Trace   | 0.4       |         |          |         |         |         |          |         |         |
| Unsaturated Acids    |                         |         |             |         |         |         |         |            |         |         |         |           |         |          |         |         |         |          |         |         |
| Myristoleic          | $C_{14}H_{26}O_2$       |         |             |         |         |         |         |            |         |         |         |           |         |          |         |         |         |          |         |         |
| Palmitoleic          | $C_{16}H_{30}O_2$       |         |             |         |         |         |         |            |         |         |         |           |         |          |         |         | 1.5     | Trace    | Trace   | Trace   |
| Oleic                | $C_{18}H_{34}O_2$       | 6.0     | 16.0        | 45.0    | 58.0    | 43.0    | 82.5    | 33.0       | 46.3    | 60.0    | 33.5    | 34.0      | 5.0     | 8.0      | 8.6     | 15.0    | 34.0    | 27.0     | 10.0    | 9.0     |
| Linoleic             | $C_{18}H_{32}O_2$       | 2.5     | 1.0         | 2.0     | 3.5     | 9.5     | 6.0     | 43.5       | 42.0    | 21.0    | 52.5    | 58.5      | 61.5    | 38.0     | 3.5     |         | 9.0     | Trace    | 15.0    | 13.0    |
| Linolenic            | $C_{18}H_{30}O_2$       |         |             |         |         |         |         |            |         |         | 2.3     |           | 25.0    | 46.5     |         |         | Trace   |          |         |         |
| Elaeostearic         | $C_{18}H_{30}O_2$       |         |             |         |         |         |         |            |         |         |         |           |         |          |         | 79.5    |         |          |         |         |
| Ricinoleic           | $C_{18}H_{34}O_2$       |         |             |         |         |         |         |            |         |         |         |           |         |          | 85.9    |         |         |          |         |         |
| $C_{20}$ unsaturated | $C_{20}H_{38(20-n)}O_2$ |         |             |         |         |         |         |            |         |         |         |           |         |          |         |         | 5.0     | 20.0     | 22.0    | 20.0    |
| $C_{22}$ unsaturated | $C_{22}H_{42(22-n)}O_2$ |         |             |         |         |         |         |            |         |         |         |           |         |          |         |         | 12.0    | 12.0     | 19.0    | 25.0    |
| Constants            |                         |         |             |         |         |         |         |            |         |         |         |           |         |          |         |         |         |          |         |         |
| Saponification value |                         | 251-264 | 240-250     | 196-200 | 195-200 | 196-206 | 185-200 | 192-200    | 188-193 | 185-192 | 189-194 | 189-194   | 189-196 | 188-197  | 175-183 | 189-195 | 185-195 | 189-193  | 189-193 | 179-194 |
| Iodine number        |                         | 8-10    | 16-23       | 35-44   | 50-69   | 48-58   | 74-94   | 100-115    | 116-130 | 83-95   | 124-148 | 120-136   | 179-204 | 185-206  | 86      | 160-170 | 110-136 | 148-185  | 170-231 | 130-144 |
| Titer—°C.            |                         | 20-23   | 20-23       | 46-43   | 36-43   | 38-47   | 25-47   | 32-38      | 18-32   | 28-32   | 20-21   | 17-20     | 19-21   | 12-17    |         | 37-38   | 22-24   | 31-33    | 28-34   | 23-27   |

### Relative Values of Insulating Materials

The usual comparisons of insulating values of materials are made on a comparison of their dielectric strengths. The Dielectric Strength of a material is the voltage that a material of a given thickness will resist. It is usually given in volts per mil (1 mil equals 0.001 in.). In any higher voltage the dielectric strength will permit a spark to pass through the material. The quoted dielectric strengths, however, are generally the minimum for the materials. Thus, although the minimum allowable for muscovite mica is 1,000 volts per mil, the best sheets may test up to 1,500 volts per mil.

| Material                  | Dielectric strength, volts per mil | Material                 | Dielectric strength, volts per mil |
|---------------------------|------------------------------------|--------------------------|------------------------------------|
| Mica, muscovite.....      | 1,000                              | Buna rubbers.....        | 515                                |
| Glass.....                | 900                                | Vinylidene chloride..... | 500                                |
| Mica, phlogopite.....     | 800                                | Fish paper.....          | 500                                |
| Electrical porcelain..... | 800                                | Methyl methacrylate..... | 480                                |
| Steatite.....             | 750                                | Cellulose acetate.....   | 400                                |
| Hard rubber.....          | 700                                | Casein plastic.....      | 400                                |
| Silicone rubber.....      | 600                                | Shellac.....             | 400                                |
| Polystyrene.....          | 600                                | Varnished cambric.....   | 400                                |
| Pyroxylin.....            | 600                                |                          |                                    |

### Standard Paper Sizes

|                              |              |
|------------------------------|--------------|
| Folio note.....              | 5½ by 8½ in. |
| Pocket note.....             | 6 by 9½ in.  |
| U.S. government writing..... | 8 by 10½ in. |
| Commercial writing.....      | 8½ by 11 in. |
| Legal cap.....               | 8½ by 14 in. |
| Foolscap.....                | 13 by 16 in. |
| Denny.....                   | 16 by 21 in. |
| Folio.....                   | 17 by 22 in. |
| Royal.....                   | 19 by 24 in. |
| Super royal.....             | 20 by 28 in. |
| Elephant.....                | 23 by 28 in. |
| Imperial.....                | 23 by 31 in. |

### The Electrochemical Series of Elements

In the table given below, the elements are electropositive to the ones which follow them, and will displace them from solutions of their salts

|               |               |                |
|---------------|---------------|----------------|
| 1. Cesium     | 23. Nickel    | 45. Silicon    |
| 2. Rubidium   | 24. Cobalt    | 46. Titanium   |
| 3. Potassium  | 25. Thallium  | 47. Columbium  |
| 4. Sodium     | 26. Cadmium   | 48. Tantalum   |
| 5. Lithium    | 27. Lead      | 49. Tellurium  |
| 6. Barium     | 28. Germanium | 50. Antimony   |
| 7. Strontium  | 29. Indium    | 51. Carbon     |
| 8. Calcium    | 30. Gallium   | 52. Boron      |
| 9. Magnesium  | 31. Bismuth   | 53. Tungsten   |
| 10. Beryllium | 32. Uranium   | 54. Molybdenum |
| 11. Ytterbium | 33. Copper    | 55. Vanadium   |
| 12. Erbium    | 34. Silver    | 56. Chromium   |
| 13. Scandium  | 35. Mercury   | 57. Arsenic    |
| 14. Aluminum  | 36. Palladium | 58. Phosphorus |
| 15. Zirconium | 37. Ruthenium | 59. Selenium   |
| 16. Thorium   | 38. Rhodium   | 60. Iodine     |
| 17. Cerium    | 39. Platinum  | 61. Bromine    |
| 18. Didymium  | 40. Iridium   | 62. Chlorine   |
| 19. Lanthanum | 41. Osmium    | 63. Fluorine   |
| 20. Manganese | 42. Gold      | 64. Nitrogen   |
| 21. Zinc      | 43. Hydrogen  | 65. Sulphur    |
| 22. Iron      | 44. Tin       | 66. Oxygen     |

### Classification of Coal<sup>1</sup>

Computed on an ash-free basis

| Rank                          | Moisture,<br>per cent | Volatile<br>matter,<br>per cent | Fixed<br>carbon,<br>per cent | Heat<br>value,<br>B.t.u. |
|-------------------------------|-----------------------|---------------------------------|------------------------------|--------------------------|
| Lignite.....                  | 43.4                  | 18.8                            | 37.8                         | 7,400                    |
| Subbituminous.....            | 23.4                  | 34.2                            | 42.4                         | 9,720                    |
| Low-rank bituminous.....      | 11.6                  | 41.4                            | 47.0                         | 12,880                   |
| Medium-rank bituminous.....   | 5.0                   | 40.8                            | 54.2                         | 13,880                   |
| Cannel coal.....              | 2.2                   | 34.8                            | 63.0                         | 13,250                   |
| High-rank bituminous.....     | 3.2                   | 32.2                            | 64.6                         | 15,160                   |
| Low-rank semibituminous.....  | 3.0                   | 22.0                            | 75.0                         | 15,480                   |
| High-rank semibituminous..... | 5.0                   | 11.6                            | 83.4                         | 15,360                   |
| Semianthracite.....           | 6.0                   | 10.2                            | 83.8                         | 14,880                   |
| Anthracite.....               | 3.2                   | 1.2                             | 95.6                         | 14,440                   |

<sup>1</sup> U.S. Geological Survey.



**Electrical Conductivity of Elements Used in Alloys**

|                 |        |                |       |
|-----------------|--------|----------------|-------|
| Silver.....     | 100.00 | Iron.....      | 14.57 |
| Copper.....     | 97.61  | Platinum.....  | 14.43 |
| Gold.....       | 76.61  | Tin.....       | 14.39 |
| Aluminum.....   | 63.00  | Tungsten.....  | 14.00 |
| Tantalum.....   | 54.63  | Osmium.....    | 13.98 |
| Magnesium.....  | 39.44  | Titanium.....  | 13.73 |
| Sodium.....     | 31.98  | Iridium.....   | 13.52 |
| Beryllium.....  | 31.13  | Ruthenium..... | 13.22 |
| Barium.....     | 30.61  | Nickel.....    | 12.89 |
| Zinc.....       | 29.57  | Rhodium.....   | 12.60 |
| Indium.....     | 26.98  | Palladium..... | 12.00 |
| Cadmium.....    | 24.38  | Steel.....     | 12.00 |
| Calcium.....    | 21.77  | Thallium.....  | 9.13  |
| Rubidium.....   | 20.46  | Lead.....      | 8.42  |
| Cesium.....     | 20.00  | Columbium..... | 5.13  |
| Lithium.....    | 18.68  | Vanadium.....  | 4.95  |
| Molybdenum..... | 17.60  | Arsenic.....   | 4.90  |
| Cobalt.....     | 16.93  | Antimony.....  | 3.59  |
| Uranium.....    | 16.47  | Mercury.....   | 1.75  |
| Chromium.....   | 16.00  | Bismuth.....   | 1.40  |
| Manganese.....  | 15.75  | Tellurium..... | 0.001 |

**Effect of Chromium in Cast Iron**

| Chromium,<br>per cent | Structure                                                       |
|-----------------------|-----------------------------------------------------------------|
| 0.00                  | Ferrite, coarse graphite, and pearlite                          |
| 0.30                  | Ferrite, finer pearlite increasing, and graphite becoming finer |
| 0.60                  | Fine graphite and pearlite; free carbides beginning to form     |
| 1.00                  | Pearlite, cementite, and fine graphite                          |
| 3.00                  | Graphite disappears, matrix of cementite                        |
| 5.00                  | Much massive carbide                                            |
| 10.00-30.00           | Fine cementite                                                  |

# INDEX

## A

- A-metal, 540
- A powder, 341
- A shot, 483
- Abaca, 451
- Abalyn, 608
- Abietic acid, 607
- Abietine, 563
- Aboudikro, 624
- Abrasive cloth, 1
- Abrasive garnet, 3
- Abrasive sand, 4
- Abrasive wheels, 2
- Abrasives, 1
- Absinthe, 785
- Absolute alcohol, 275
- Absorbed oil, 426
- Absorbent cotton, 225
- Absorbent fabric, 61
- Absorbent paper, 525
- Abyssinian gold, 263
- Acacia, 418
- Acacia gum, 338
- Acapau, 266
- Acaroid resin, 4
- Accelerated cement, 159
- Accelerated Salt WS, 140
- Ac'cent, 581
- Accoloy, 348
- Accotile, 67
- Ace hard rubber, 612
- Acciral, 32
- Acele, 156
- Acetaldehyde, 5
- Acetaldehyde ammonia, 5
- Acetaldol, 18
- Acetamide, 5
- Acetic acid, 5
- Acetic acid amine, 5
- Acetic anhydride, 6
- Acetin, 6
- Acetone, 6
- Acetone-formaldehyde resin, 707
- Acetone oil, 7
- Acetylated cotton, 225
- Acetylene, 7
- Acetylene black, 132
- Acetylene snow, 7
- Acetylene tetrachloride, 721
- Acid-cured rubber, 611
- Acid-resistant alloys, 483
- Acid-resistant cast iron, 641
- Acid spar, 300
- Acidproof cement, 663
- Acipen steel, 349
- Aconite, 257
- Aconitic acid, 71
- Aconitine, 257
- Acousti-Celotex, 71
- Acrax, 769
- Acridine, 229
- Aerolein, 718
- Aerolite, 549
- Acrylic acid, 8
- Acrylic aldehyde, 718
- Acrylic resins, 8
- Acryloid, 8
- Acryloid A-10, 9
- Acryloid B-7, 9
- Acrylon, 371
- Acrylonitrile, 9
- Acrylonitrile fiber, 9
- Acrysol, 8
- Actinic glass, 322
- Actinolite, 60
- Activated alumina, 26
- Activated alumina F-1, 27
- Activated alumina F-6, 27
- Activated bauxite, 78
- Activated carbon, 9
- Activated charcoal, 9
- Activated clay, 305
- Activated oxygen, 518
- Acury, 555
- Ad-aluminum, 35
- Adalox, 38
- Adamant alloy, 69
- Adamantine, 125
- Adamite, 38, 770
- Adamsite, 571
- Adeps, 395
- Adeps lanae, 241
- Adhesives, 10
- Adipic acid, 13
- Adjab butter, 441
- Adjinimoto, 581
- Admerols, 261
- Admiralty alloy, 13
- Admiralty bronze, 13
- Admiralty gunmetal, 341
- Admiralty metal, 13
- Adnic, 234
- Adobe brick, 106
- Adr alloy, 423
- Advance metal, 235
- Advagum, 760
- Advawax 2575, 531
- Aeralloy, 204
- Aerocarb, 140
- Aerocase, 140
- Aerocrete, 203
- Aerolite, 30
- Aeron, 34, 43
- Aerosol, 371
- Aerosol OS, 773
- Aerosol Q, 589
- Aerosol wetting agents, 773
- African boxwood, 101
- African greenheart, 335
- African mahogany, 389, 624
- African pencil cedar, 383
- African teak, 717
- African walnut, 766
- Agadite, 242
- Agalite, 708
- Agalmatolite, 550
- Agaloy, 279
- Agar-agar, 13
- Agar attar, 606
- Agate, 15
- Agateen, 393
- Agathon steel, 22
- Agatized wood, 15
- Agave fibers, 652
- Agavose, 652
- Agel fiber, 215
- Agripol, 616
- Agstone, 412
- Ahcolein, 511
- Aich's metal, 477
- Aico, 197
- Air-cell, 396
- Air-hardening steel, 358
- Air-kool steel, 501
- Air Wick, 50
- Aircraft quality steel, 691
- Airdi 110 steel, 250
- Airdi 225 steel, 250
- Airplane cloth, 71
- Airtem steel, 501
- Airvan steel, 502
- AISI steel 4130, 174

- Ajax bull metal, 70  
 Ajax metal, 79  
 Ajowan oil, 16  
 Ajwan ka phul, 16  
 Ajwan seed, 16  
 Akund, 387  
 Alabamine, 592  
 Alabandite, 447  
 Alabaster, 345  
 Alabaster glass, 323  
 Alabastine, 522  
 Aladdinite, 141  
 Alalmalt, 577  
 Alanine, 646  
 Alant starch, 687  
 Alaska cedar, 239  
 Alaskan pine, 352  
 Alaskite, 286  
 Alathon, 276  
 Albalith, 418  
 Albanene tracing paper, 526  
 Albany steel, 249  
 Alberene stone, 658  
 Albert coal, 66  
 Albertite, 66  
 Albertol resins, 706  
 Albite, 285  
 Albone, 518  
 Albor die steel, 174  
 Albumen, 16  
 Albumen gluc, 327  
 Albumin, 16  
 Alclad, 263  
 Alclad 24S-T4, 30  
 Alcoa Ni-Iron, 487  
 Alcoa 2S, 28  
 Alcoa 3S, 31  
 Alcoa 4S, 31  
 Alcoa 11S, 30  
 Alcoa 13, 40  
 Alcoa 17S, 29  
 Alcoa 24S, 30  
 Alcoa 32S, 41  
 Alcoa 43, 41  
 Alcoa 51S, 31  
 Alcoa 52S, 31  
 Alcoa 56S, 31  
 Alcoa 61S, 30  
 Alcoa 63S, 31  
 Alcoa 75S, 43  
 Alcoa 85, 248  
 Alcoa 112, 32  
 Alcoa 113, 43  
 Alcoa 122, 32  
 Alcoa 195, 32  
 Alcoa 212, 32  
 Alcoa 214, 33  
 Alcoa 218, 248  
 Alcoa 220, 32  
 Alcoa 360, 41  
 Alcoa 380, 41  
 Alcoa 384, 41  
 Alcoa 750, 33  
 Alcoa A132, 41  
 Alcoa A214, 43  
 Alcoa alloys, 30  
 Alcoa EC, 28  
 Alcohol, 17  
 Alcumite, 483  
 Alcunic, 35  
 Alcuplate, 263  
 Aldamine, 5  
 Aldecor steel, 421  
 Aldehyde, 17  
 Alder, 17  
 Aldol, 18  
 Aldrey, 30  
 Aldur, 750  
 Aleppo galls, 310  
 Aleppo oak, 310  
 Aleppo pine, 743  
 Aletris root, 259  
 Alfa, 528  
 Alfalfa leaf meal, 510  
 Alfer magnet alloys, 439  
 Alferium, 30  
 Alfograf, 428  
 Alfol, 302  
 Alfrax, 27  
 Algaroba, 419  
 Algarobilla, 251  
 Alger metal, 382  
 Algin, 14  
 Alginic acid, 14  
 Alginic fibers, 15  
 Algonite, 568  
 Algrip steel, 56  
 Alizari, 431  
 Alizarin, 431  
 Alkali, 18  
 Alkali lead, 399  
 Alkali lignin, 408  
 Alkali metals, 18  
 Alkaline air, 46  
 Alkaloids, 256  
 Alkanet, 19  
 Alkannin, 19  
 Alkannin paper, 15  
 Alkyd resins, 19  
 Alkyl groups, 272  
 Allantal, 263  
 Allegheny 18-8-M, 180  
 Allegheny 55, 349  
 Allegheny metal, 180  
 Allen red metal, 356  
 Allenoy, 472  
 Allen's metal, 356  
 Allicine, 674  
 Alligator leather, 20  
 Alligator pear oil, 512  
 Alligator pepper, 535  
 Allite, 23  
 Allium, 674  
 Allmul firebrick, 297  
 Allophane, 386  
 Alloprence, 172  
 Alloy, 21  
 Alloy 142, 33  
 Alloy 712, 37  
 Alloy AM230, 249  
 Alloy cast iron, 145  
 Alloy steel, 22  
 Allspice, 672  
 Alluvium, 807  
 Allyl alcohol, 23  
 Allyl cinnamate, 537  
 Allyl diglycol carbonate, 24  
 Allyl ester, 23  
 Allyl plastics, 23  
 Allyl starch, 24  
 Allyl sucrose, 24  
 Almag, 30  
 Almag 55, 436  
 Almandite, 312  
 Almasilium, 30  
 Almendro, 335  
 Almo steel, 174  
 Almon, 397  
 Almond oil, 24  
 Alneon, 43  
 Alnico, 439  
 Alnico I, 440  
 Alnico IV, 440  
 Alnico V, 440  
 Alobrant, 38  
 Aloe, 259  
 Aloe wood oil, 606  
 Aloes wood, 606  
 Alowalt, 38  
 Aloxite, 38  
 Alpaca, 24  
 Alpaca fiber, 24  
 Alpax, 40  
 Alpha alumina, 39  
 Alpha brass, 103  
 Alpha cellulose, 153  
 Alpha pinene, 272  
 Alpha rays, 590  
 Alpiste, 126  
 Alplate, 42  
 Alrania grease, 425  
 Alsace green, 603  
 Alsifer, 291  
 Alsifilm, 462  
 Alsimag, 398  
 Alsimin, 291  
 Alstonia, 184  
 Alsynite, 325  
 Aludur, 30  
 Alulion, 38  
 Alum, 25  
 Alumalum, 56  
 Aluman, 31  
 Alumel, 602  
 Alumentized steel, 42

- Alumilite, 29
- Alumina, 26
- Alumina A-14, 27
- Alumina abrasive powder, 39
- Alumina AJ-200, 27
- Alumina balls, 27
- Alumina clay, 162
- Aluminate cement, 159
- Aluminite, 598
- Aluminium, 28
- Aluminized steel, 42, 263
- Alumino-Hi Temp, 347
- Aluminoid, 38
- Aluminosilicates, 150
- Aluminox, 38
- Aluminum, 28
- Aluminum acetate, 768
- Aluminum alloy, 29
- Aluminum alloy 150S, 30
- Aluminum alloy MG-7, 33
- Aluminum-base alloy, 248
- Aluminum brass, 34
- Aluminum bronze, 35
- Aluminum bronze 46B-186, 36
- Aluminum bronze powder, 39
- Aluminum carbide, 459
- Aluminum chloride, 150
- Aluminum-chromium alloys, 31
- Aluminum-coated paper, 527
- Aluminum-coated steel, 42
- Aluminum-copper alloys, 29
- Aluminum flake, 39
- Aluminum fluoride, 299
- Aluminum foil, 302
- Aluminum hydroxide, 27
- Aluminum-magnesium alloys, 32
- Aluminum-manganese alloy, 31
- Aluminum-nickel alloys, 33
- Aluminum oleate, 39
- Aluminum oxide, 37
- Aluminum paint, 521
- Aluminum palmitate, 39
- Aluminum pellets, 40
- Aluminum-Plymetl, 569
- Aluminum powder, 39
- Aluminum resinate, 39
- Aluminum-silicon alloy, 32, 40
- Aluminum solder, 665
- Aluminum stearate, 39
- Aluminum steel, 41
- Aluminum sulphate, 25
- Aluminum trihydrate, 26
- Aluminum-zinc alloy, 42
- Aluminumweld, 771
- Alumstone, 25
- Alundum, 38
- Alundum 32, 38
- Alunite, 25
- Alvars, 759
- Alzak, 29
- Amalgam, 43
- Amaloy, 720
- Amang, 654
- Amanirana, 384
- Amarith, 138
- Amatol, 47
- Amazon stone, 285
- Amber, 45
- Amber glass, 322
- Amber mica, 460
- Amber oil, 45
- Amber seed, 537
- Amberex, 765
- Ambergris, 45
- Amberine, 15
- Amberlac, 20
- Amberlite IRA-400, 768
- Amberoid, 45
- Amberol, 549
- Amberlite, 63
- Amblygonite, 407
- Ambrac, 485
- Ambrac No. 850, 485
- Ambrac 854, 495
- Ambraloy 927, 34
- Ambraloy 928, 35
- Ambraloy 930, 36
- Ambrette oil, 537
- Amcoah steel, 501
- Amcoloy 4640, 36
- Amerchol L-101, 241
- American ash, 64
- American aspen, 64
- American beech, 83
- American cherry, 168
- American elm, 267
- American poplar, 64
- American styrax, 694
- American vermilion, 401
- American walnut, 766
- Americium, 748
- Ameripol, 615
- Ameroid, 141
- Amersil, 636
- Amethyst, 45
- AMF alloy, 483
- Amidone, 515
- Amiesite, 66
- Aminized cotton, 225
- Amino acids, 580
- Amino sugar, 698
- Aminoaldehyde, 705
- Aminobenzene, 49
- Aminoethyl sulphuric acid, 702
- Aminoform, 353
- Amioca starch, 686
- Amlo oil, 426
- Ammonia, 46
- Ammoniac, 48
- Ammoniacum, 48
- Ammonium alum, 26
- Ammonium-aluminum sulphate, 26
- Ammonium bifluoride, 273
- Ammonium carbonate, 46
- Ammonium chloride, 47
- Ammonium ferrous phosphate, 579
- Ammonium gelatin, 500
- Ammonium hydrate, 46
- Ammonium hydroxide, 46
- Ammonium lactate, 48
- Ammonium nitrate, 47
- Ammonium perchlorate, 47
- Ammonium picrate, 281
- Ammonium sulfamate, 699
- Ammonium sulphate, 47
- Ammonium sulphocyanide, 749
- Ammonium thiocyanate, 749
- Ammonium vanadate, 48
- Amole, 626
- Amonilla, 766
- Amorphous carbon, 129
- Amorphous graphite, 332
- Amorphous selenium, 629
- Amorphous silica, 636
- Amorphous silicon, 538
- Amosil, 621
- Amosite, 61
- Amotun steel, 360
- Ampco metal, 12, 36
- Ampco metal 18-22, 36
- Ampcoloy, 91, 90
- Amphiboles, 60
- Amsco alloy, 349
- Amsco steel, 449
- Amsco welding rod, 771
- Amygdalin, 24
- Amyl acetate, 48
- Amyl alcohol, 48
- Amyl cinnamic aldehyde, 186
- Amylin, 244
- Amyloid, 531
- Anabesine, 370
- Anacardic acid, 141
- Anacanda phosphor bronze, 551
- Anatase, 730
- Anauxite, 161
- Anchusa, 19
- Anda-assu oil, 261
- Andalusite, 475
- Andaman marblewood, 266
- Andradite, 313

- Anethole, 673  
 Aneurin, 762  
 Angarite, 76  
 Angelica, 318  
 Angelica oil, 318  
 Angeliue, 334  
 Angico, 235  
 Angico vermelho, 235  
 Angelsite, 400  
 Angora wool, 346  
 Anhydrous alcohol, 275  
 Anhydrous ammonia, 46  
 Aniline, 49  
 Animal charcoal, 96  
 Animal glue, 326  
 Animal protein colloid, 327  
 Animal protein factor, 581  
 Animal starch, 687  
 Animi gum, 49  
 Anion-active agents, 243  
 Anion exchange agents, 768  
 Anise camphor, 673  
 Anise oil, 49  
 Anise seed, 49  
 Anisette, 49  
 Anisic acid, 695  
 Anjojoli, 631  
 Annatto, 49  
 Annatto paste, 50  
 Anode metals, 51  
 Anodex HR, 396  
 Anodized aluminum, 29  
 Anorthite, 285  
 Ansul oil, 427  
 Antaciron, 642  
 Antarctic beech, 82  
 Antarctic pine, 562  
 Anthophyllite, 61  
 Anthracene, 715  
 Anthracite, 51  
 Anthraxylon, 315  
 Anti-acid bronze, 357  
 Anti-adhesive paper, 526  
 Antibiotics, 831  
 Anticorodal, 30  
 Antifouling paint, 457  
 Antifreeze compounds, 52  
 Antifriction metal, 70  
 Antigorite, 630  
 Antimonial lead, 53  
 Antimony, 54  
 Antimony blend, 55  
 Antimony ores, 54  
 Antimony oxide, 55  
 Antimony pentasulphide, 56  
 Antimony red, 55  
 Antimony sulphide, 55  
 Antimony sulphuret, 55  
 Antimony tetroxide, 55  
 Antimony trisulphide, 55  
 Antioxidant, 56  
 Antisep oil, 287  
 Antiseptic soap, 657  
 Antiseptics, 250  
 Antislip metals, 56  
 Antler, 57  
 Antu, 682  
 Apac board, 62  
 Apatite, 553  
 Apex zinc alloy, 789  
 Apitong, 397  
 Aplite, 286  
 Apolloy, 213  
 Apparel wool, 783  
 Apple honey, 697  
 Apple sirup, 697  
 Apricot, 24  
 Aqua ammonia, 46  
 Aqua fortis, 497  
 Aqua regia, 363  
 Aquablak No. 1, 97  
 Aquablak H, 133  
 Aquablak M, 133  
 Aquadag, 237  
 Aquagel, 663  
 Aqualite, 82  
 Aqualized gum, 735  
 Aquaplex, 20  
 Aquasol, 699  
 Aquazinc, 793  
 Aquinite, 570  
 Arabian coffee, 194  
 Arabin, 601  
 Arachidic acid, 533  
 Arachis oil, 533  
 Arak, 619  
 Aralac fiber, 141  
 Aramina fiber, 384  
 Aranium, 177  
 Araroba, 259  
 Araucanian pine, 562  
 Araucarie oil, 562  
 Arbor vitae, 725  
 Arc carbons, 131  
 Architectural bronze, 110  
 Arco refractory brick, 597  
 Arcoloy, 212  
 Arcozon, 158  
 Arctic bronze, 357  
 Ardil, 581  
 Arenga fiber, 112  
 Argent français, 382  
 Argentale, 382  
 Argentarium, 664  
 Argentine metal, 382  
 Argentine onyx, 514  
 Argentite, 57  
 Argol, 265  
 Argols, 57  
 Argon, 58  
 Argyrodite, 57  
 Ari lac, 633  
 Arional, 30  
 Aristowax, 530  
 Arizona cypress, 239  
 Arizona sycamore, 704  
 Arizonite, 729  
 Arkansas ash, 64  
 Arkansas pine, 561  
 Arlex, 668  
 Arma steel, 146  
 Armalon, 188  
 Armat, 440  
 Armco 430 ELC steel, 181  
 Armco ingot iron, 367  
 Armco stainless 17-7PH, 180  
 Armeo steel 17-4PH, 685  
 Armco, 740  
 Armitte, 372  
 Armorply, 568  
 Army-Navy steel AN-T-69, 173  
 Aromatic-free gasoline, 314  
 Aroplaz 1248M, 20  
 Arrack, 697  
 Arrow steel, 175  
 Arrowroot starch, 687  
 Arsenic, 58  
 Arsenic acid, 59  
 Arsenic disulphide, 59  
 Arsenic ores, 59  
 Arsenic trioxide, 58  
 Arsenic trisulphide, 59  
 Arsenical bronze, 402  
 Arsenical copper, 207  
 Arsenious anhydride, 58  
 Arsenious oxide, 58  
 Arsenopyrite, 59  
 Art bronze, 110  
 Art denim, 255  
 Art paper, 525  
 Art silk, 593  
 Artdie steel, 249  
 Artificial anthracite, 52  
 Artificial asphalt, 65  
 Artificial barite, 73  
 Artificial bates, 76  
 Artificial bristles, 108  
 Artificial chamois, 166  
 Artificial corundum, 223  
 Artificial ebony, 266  
 Artificial gold, 559  
 Artificial graphite, 332  
 Artificial horsehair, 345  
 Artificial ivory, 381  
 Artificial latex, 396  
 Artificial leather, 404  
 Artificial lignum vitae, 409  
 Artificial malachite, 209  
 Artificial marble, 453  
 Artificial meerschaum, 454  
 Artificial oilstone, 511  
 Artificial pozzuolana, 160  
 Artificial pumice, 583

Artificial silk, 593  
 Artificial suede, 695  
 Artist's oil, 738  
 Arwax, 531  
 Aryl groups, 272  
 Asafetida, 601  
 Asarcology, 778  
 Asarcon, 773, 79  
 Asbestine, 708  
 Asbeston, 61  
 Asbestos, 60  
 Asbestos board, 62  
 Asbestos ebony, 63  
 Asbestos fabrics, 61  
 Asbestos felt, 62  
 Asbestos lumber, 62  
 Asbestos millboard, 62  
 Asbestos paper, 63  
 Asbestos rope, 61  
 Asbestos shingles, 62  
 Asbestos siding, 62  
 Asbestos wick, 61  
 Ascaridole, 785  
 Ascorbic acid, 763  
 Asem, 329  
 Ash, 63  
 Ashanti pepper, 535  
 Ashberry metal, 545  
 Aspen, 64  
 Asphalt, 65  
 Asphalt oil, 67  
 Asphalt tile, 66  
 Asphaltite, 65  
 Asphyxiating gases, 570  
 Assam rubber, 611  
 Assie mahogany, 625  
 ASTM alloy No. 1, 201  
 ASTM alloy No. 2, 201  
 ASTM alloy No. 3, 41  
 ASTM alloy No. 6, 105  
 ASTM alloy No. 7, 564  
 ASTM alloy A231X, 436  
 ASTM alloy AZ80X, 436  
 ASTM alloy TA54, 436  
 ASTM bearing bronze, 78  
 ASTM bearing grease, 424  
 ASTM brass ingot metal, 105  
 ASTM bronzes, 110  
 ASTM magnesium alloys, 435  
 ASTM manganese bronze, 445  
 ASTM phosphor bronze, 551  
 ASTM silver solder, 650  
 ASTM spring steel, 679  
 Astrotone, 537  
 A.S.V. steel, 734  
 Atabrine, 184  
 Atacamite, 211  
 Aterite, 483

Atha's 2600 alloy, 489  
 Athiaenon stone, 588  
 Atlas 89 alloy, 36  
 Atlas 90 alloy, 36  
 Atlas 10 bronze, 37  
 Atlas cedar, 152  
 Atlas steel, 362  
 Atlas steel No. 93, 174  
 Atlatic 31, 66  
 Atmosphere, 798  
 Atom, 803  
 Atropine, 257  
 Atsil steel, 635  
 Attar of rose, 538  
 Attasol, 708  
 Auer metal, 585  
 Auric brown, 288  
 Auromet 55, 37  
 Austenite, 143  
 Austenitic cast iron, 443  
 Austenitic steel, 178, 448  
 Australian agar, 13  
 Australian blackwood, 419  
 Australian gold, 329  
 Australian locust, 419  
 Australian mahogany, 340  
 Australian pine gum, 622  
 Australian quinine, 184  
 Australian red kino, 391  
 Australian teak, 718  
 Austrian oak, 505  
 Austrium, 309  
 Autobestos, 102  
 Autunite, 747  
 Auxiliary pigments, 558  
 Auxin, 294  
 Avaram bark, 630  
 Avarem, 151  
 Avena, 508  
 Aventurine, 587  
 Avialite, 36  
 Avocado oil, 512  
 Awarra palm, 67  
 Awaruite, 379  
 Awning duck, 262  
 Azelaic acid, 554  
 Azlon, 582  
 Azo dyes, 265  
 Azoimide, 306  
 Azolite, 73  
 Azolitmin, 418  
 Azotic acid, 497  
 Azulene, 336  
 Azurite, 210

**B**

B carbon, 131  
 B metal, 400  
 B powder, 341  
 Babassu oil, 67  
 Babbitt metal, 68

Bachite, 10  
 Baddeleyite, 794  
 Badin metal, 727  
 Bagasse, 70  
 Bagi-lumbang oil, 738  
 Bagtikan, 397  
 Bahmetall, 399  
 Baize, 287  
 Bakelite, 549  
 Bakelite C-11, 9  
 Bakelite laminated, 548  
 Baking soda, 659  
 Baku bark, 450  
 Balata, 71  
 Bald cypress, 239  
 Balaen, 775  
 Balfour pink granite, 331  
 Baling paper, 167  
 Balk, 782  
 Ball clay, 386  
 Ball-bearing steels, 182  
 Ballas diamonds, 245  
 Ballnut, 354  
 Balloon cloth, 71  
 Balm of Gilead, 126  
 Balsa fiber, 387  
 Balsa sawdust, 72  
 Balsa wood, 72  
 Balsam fir, 72  
 Balsam of Peru, 730  
 Balsam poplar, 229  
 Balsam wool, 347  
 Balsams, 272  
 Baltic oil, 414  
 Baltic pine, 562  
 Baltimore oil, 785  
 Bamboo, 72  
 Bambuk butter, 755  
 Banana oil, 48  
 Banning sand, 4  
 Banewort, 257  
 Bank-run gravel, 334  
 Banrock, 466  
 Baobab, 528  
 Barbasco, 242  
 Barbed wire, 311  
 Barcote, 153  
 Bardol B, 715  
 Barite, 73  
 Barium, 74  
 Barium azoimide, 306  
 Barium carbonate, 74  
 Barium chlorate, 74  
 Barium chloride, 74  
 Barium manganate, 559  
 Barium naphthenate, 254  
 Barium nitrate, 74  
 Barium oxalate, 75  
 Barium potassium chlorate, 579  
 Barium selenite, 629  
 Barium stearate, 458

- Barium sulphate, 73  
 Barium titanate crystal, 586  
 Barley, 75  
 Barley straw, 75  
 Barr alloy No. 6, 357  
 Barrier paper, 527  
 Barrios balsa, 72  
 Barsprout, 579  
 Barwood, 126  
 Baryte, 73  
 Basalt, 75  
 Basalt glass, 583  
 Basic aluminum acetate, 768  
 Basic lead chromate, 401  
 Basic lead sulphate, 401  
 Basic phosphate slag, 653  
 Basic pig iron, 556  
 Basifrit, 432, 599  
 Basis brass, 356  
 Bass, 555  
 Bassia butter, 99  
 Bassine, 555  
 Basswood, 76  
 Bastnasite, 164  
 Bat guano, 293  
 Bataan mahogany, 396  
 Batata, 577  
 Bate, 76  
 Bath metal, 776  
 Bathite, 38  
 Batiste, 226  
 Batterium metal, 33  
 Battery acid, 701  
 Battery manganese, 447  
 Battery paint, 521  
 Battleship linoleum, 413  
 Baudoin alloy, 494  
 Bauxite, 76  
 Bay oil, 539  
 Bay rum, 539  
 Bay salt, 620  
 Bayberry tallow, 755  
 Baywood, 440  
 Bead catalysts, 150  
 Bearing brass, 78  
 Bearing bronze, 78  
 Bearing materials, 80  
 Bearingoy, 70  
 Bearium, 357  
 Beautywood, 549  
 Beaver steel, 490  
 Beckite, 587  
 Beckol, 20  
 Beckosol 1341, 20  
 Beckton white, 418  
 Bedford cord, 227  
 Beech, 82  
 Beef, 83  
 Beef cloth, 167  
 Beef extract, 84  
 Beef gall, 310  
 Beef oak, 506  
 Beef tallow, 710  
 Beeswax, 84  
 Beet pulp, 697  
 Beetle, 750  
 Belgian hare, 346  
 Bell metal, 85  
 Belladonna, 257  
 Belmalloy, 442  
 Belt dressings, 85  
 Belt duck, 262  
 Belting leather, 403  
 Beluga whale, 773  
 Bementite, 447  
 Bemul, 339  
 Ben oil, 86  
 Bendalloy, 308  
 Benedict metal, 233, 494  
 Benet metal, 34  
 Bengal kino, 391  
 Benne oil, 631  
 Benniseed, 631  
 Bentonite, 86  
 Benzaldehyde, 24  
 Benzedrine, 87  
 Benzene, 86  
 Benzine, 479  
 Benzoate of soda, 695  
 Benzoated lead, 395  
 Benzoic acid, 695  
 Benzoic sulphinide, 698  
 Benzoin, 694  
 Benzol, 86  
 Benzyl alcohol, 87  
 Benzyl cellulose, 87  
 Benzyl chloride, 87  
 Benzyl dichloride, 87  
 Benzyl iodide, 719  
 Benzyl propionate, 539  
 Beraloy C, 90  
 Bereff oil, 703  
 Bergamot oil, 542  
 Berkelium, 592  
 Berlaloy, 222  
 Bersh metal, 33  
 Bertholite, 173  
 Bertrandite, 89  
 Beryl, 88  
 Berylco alloy 165, 90  
 Beryllia, 89  
 Beryllium, 88  
 Beryllium alloy 50, 91  
 Beryllium bronze, 89  
 Beryllium-cobalt alloys, 90  
 Beryllium copper, 88  
 Beryllium-copper alloys, 90  
 Beryllium-fluoride glass, 516  
 Beryllium-nickel alloy, 91  
 Beryllium oxide, 89  
 Beryllonite, 89  
 RES alloy 2L5, 43  
 BES alloy 3L11, 32  
 BES alloy L8, 32  
 BES alloy L24, 33  
 BES alloy 218, 477  
 BES alloy 362, 32  
 BES alloy 383, 341  
 BES brass 265, 356  
 BES gilding metal, 595  
 Bessemer matte, 473  
 Bessemer pig iron, 556  
 Bessemer steel, 91  
 Beta brass, 103  
 Beta quartz, 586  
 Beta rays, 590  
 Beth-Cu-Loy, 213  
 Bethabara, 334  
 Bethalon steel, 180  
 Bethanized steel, 311  
 Bethlehem 66 steel, 359  
 Bethlehem A-H steel, 501  
 Betong bamboo, 73  
 Betula oil, 93  
 Beverage alcohol, 275  
 Biacetyl, 118  
 Bihiru, 334  
 Bidery metal, 778  
 Big-leaf mahogany, 390  
 Big-leaf maple, 451  
 Bikhrit, 38  
 Bilsted, 338  
 Biltmore ash, 64  
 Bimlipatam jute, 384  
 Binder twine, 215  
 Binding metal, 789  
 Biolite, 546  
 Biologic catalysts, 150  
 Biondo gum, 735  
 Biotin, 762  
 Biotite, 330  
 Birch, 92  
 Birch oil, 93  
 Birch tar, 93  
 Birch tar oil, 93  
 Birdseed, 126  
 Birmabright, 33  
 Birmasil, 40  
 Birmingham platina, 776  
 Bisabol myrrh, 601  
 Bismite, 94  
 Bismuth, 93  
 Bismuth amalgams, 44  
 Bismuth chromate, 94  
 Bismuth-lead alloy, 778  
 Bismuth ochre, 94  
 Bismuth oxychloride, 94  
 Bismuth phosphate, 94  
 Bismuth solder, 665  
 Bismuth steel, 94  
 Bismuth trisulphide, 94  
 Bismuth wire, 94  
 Bismuthinite, 94

- Bismutite, 94
- Bistre, 559
- Bitness, 116
- Bitter ash, 588
- Bitter chocolate, 192
- Bitter orange, 542
- Bitter root, 258
- Bitternut, 354
- Bitterwood, 588
- Bitudobe, 107
- Bitumen, 65
- Bituminous coal, 94
- Bituminous paints, 521
- Bituminous rock, 65
- Bituminous shale, 631
- Bituplastic, 714
- Bituvia, 715
- Biviny, 116
- Bixin, 49
- Bixine, 49
- Bixol, 49
- Black alder, 18
- Black ash, 64
- Black balsam, 730
- Black band ore, 378
- Black birch, 92
- Black boy resin, 4
- Black cherry, 168
- Black cobalt oxide, 190
- Black copper oxide, 211
- Black coral, 214
- Black cottonwood, 229
- Black cumini, 674
- Black dammar, 240
- Black diamonds, 245
- Black ebony, 266
- Black factice, 765
- Black ferric oxide, 288
- Black giant steel, 644
- Black ginger, 318
- Black granite, 331
- Black gum, 338
- Black hickory, 354
- Black lead, 331
- Black locust, 418
- Black maple, 451
- Black mustard, 478
- Black nickel, 749
- Black oak, 505
- Black pepper, 534
- Black persimmon, 542
- Black pine, 562
- Black plate, 727
- Black powder, 341
- Black rouge, 610
- Black sesame, 127
- Black spruce, 680
- Black stainless steel, 686
- Black tea, 716
- Black thermit, 723
- Black tupelo, 338
- Black walnut, 766
- Black wattle, 151
- Black willow, 779
- Blackbutt, 95
- Blackfish oil, 95
- Blackheart iron, 441
- Blackstrap molasses, 696
- Bladen, 371
- Blanc fixe, 73
- Blanketing clouds, 654
- Blankophors, 430
- Blast-furnace slag, 652
- Blasting gelatin, 500
- Blasting powders, 280
- Blasting shot, 380
- Bleaching clay, 305
- Bleaching powder, 170
- Blister copper, 210
- Blister gas, 570
- Blister steel, 691
- Block coal, 95
- Block tin, 725
- Blood albumin, 16
- Blotting paper, 525
- Blown fish oils, 510
- Blown oils, 510
- Blue asbestos, 60
- Blue ash, 64
- Blue Billy ore, 379
- Blue Chip steel, 359
- Blue copper carbonate, 210
- Blue cross, 571
- Blue dogwood, 252
- Blue gum, 339
- Blue lead, 399
- Blue mahoe, 766
- Blue moonstone, 16
- Blue spruce, 680
- Blue stone, 624
- Blue vitriol, 214
- Blue head whale, 773
- Bobierre's metal, 355
- Bock beer, 75
- Boca copal, 205
- Roettger's paper, 19
- Bog iron ore, 378
- Bog manganese, 447
- Bog spruce, 680
- Boghead coal, 127
- Bogota divi-divi, 251
- Bohemian glass, 320
- Bohnalite, 30
- Bohnalite B, 32
- Bohnalite J, 32
- Bohnalite S43, 41
- Bohnalite S51, 31
- Bohnalite S53, 31
- Bohnalite Y, 33
- Boiled linseed oil, 414
- Boiler plate, 96
- Boiler-plug alloys, 309
- Boiler-tube steel, 96
- Bois d'arc, 309
- Bois de rose, 606
- Bois glacé, 548
- Bolt steel, 422
- Bolting cloth, 647
- Bombay hemp, 703
- Bond paper, 525
- Bonded metal, 578
- Bonderized steel, 556
- Bone, 97
- Bone black, 96
- Bone char, 96
- Bone china, 386
- Bone clay, 386
- Bone glue, 327
- Bone oil, 98
- Book paper, 525
- Booster explosives, 280
- Boracic acid, 99
- Borak, 98
- Borate glass, 516
- Borax, 98
- Borax glass, 321
- Borcher's metal, 221
- Borcoloy, 236
- Bordeaux mixture, 370
- Bordeaux turpentine, 743
- Boric acid, 99
- Borite, 38
- Borium, 741
- Borneo camphor, 125
- Borneo camphorwood, 125
- Borneo cedar, 397
- Borneo mahogany, 397
- Borneo rosewood, 606
- Borneo tallow, 99
- Borneo wax, 530
- Borneol, 125
- Bornite, 210
- Borod, 741
- Boroflux, 101
- Borolon, 38
- Boron, 100
- Boron carbide, 100
- Boron nitride, 427
- Boron steel, 100
- Boron trichloride, 100
- Boronatocalcite, 98
- Boroto metal, 334
- Boroto sharkskin, 632
- Bort, 245
- Borundum, 335
- Botanicals, 256
- Bottle glass, 319
- Bottled gas, 543
- Bottlenose whale, 671
- Bowstring hemp, 384
- Box elder, 451
- Boxwood, 101
- Bowhead whale, 774
- Bragite, 164
- Brake lining, 102
- Brass, 102



- Brass anodes**, 51  
**Brass-clad steel**, 263  
**Brass forgings**, 477  
**Brass ingot metal**, 104  
**Brass polish**, 113  
**Brass powder**, 138  
**Brassicidic acid**, 592  
**Brassoid**, 578  
**Brattice cloth**, 116  
**Brazier's copper**, 208  
**Brazil nuts**, 105  
**Brazil wax**, 136  
**Brazilian copal**, 205  
**Brazilian cork**, 217  
**Brazilian cotton**, 224  
**Brazilian hemp**, 384  
**Brazilian jute**, 384  
**Brazilian onyx**, 514  
**Brazilian peanut**, 533  
**Brazilian pine**, 562  
**Brazilian walnut**, 766  
**Brazilianite**, 88  
**Brazilite**, 794  
**Brazilwood**, 105  
**Brazing brass**, 106  
**Brazing metal**, 106  
**Brazing rods**, 106, 771  
**Brazing solder**, 106  
**Brazing wire**, 106  
**Breccia**, 452, 807  
**Bretonite**, 571  
**Breunnerite**, 432  
**Brevolite**, 393  
**Briar**, 783  
**Briar Hill stone**, 624  
**Brick**, 106  
**Brick clays**, 107  
**Brick tea**, 716  
**Brilliantine**, 227  
**Brimstone**, 699  
**Brines**, 621  
**Bristles**, 107  
**Bristol board**, 532  
**Bristol brass**, 356  
**Britannia metal**, 545  
**British oak**, 505  
**Broadcloth**, 783  
**Broad-leaved maple**, 451  
**Bromellite**, 89  
**Bromine**, 108  
**Bromlost**, 570  
**Bromo styrene**, 585  
**Bromoacetone**, 719  
**Bromobenzyl cyanide**, 711  
**Bromomethane**, 306  
**Bronzalum**, 56  
**Bronze**, 109  
**Bronze-clad steel**, 200  
**Bronze mixture** 44, 110  
**Bronze on steel**, 263  
**Bronze powder**, 110  
**Bronzing liquids**, 393  
**Bronzochrom**, 106  
**Brookite**, 729  
**Broom root**, 112  
**Broomcorn**, 111  
**Brown ash**, 64  
**Brown coal**, 408  
**Brown factice**, 765  
**Brown hematite**, 377  
**Brown Indian hemp**, 384  
**Brown mahogany**, 624  
**Brown ochre**, 508  
**Brown ore**, 378  
**Brown rice**, 604  
**Brownskin**, 527  
**Brucine**, 504  
**Brucite**, 432  
**Brunswick black**, 66  
**Brush fibers**, 112  
**Brush hair**, 345  
**Brush wire**, 113  
**Brushing lacquers**, 393  
**Bryiron**, 484  
**RTR steel**, 733  
**Bua bua**, 718  
**Bubbfil**, 677  
**Buchite**, 475  
**Buchu**, 260  
**Buckeye**, 169  
**Buckram**, 113  
**Buckskin**, 166  
**Buckthorn bark**, 265  
**Buckwheat**, 776  
**Buffalo hides**, 355  
**Buffing compositions**, 113  
**Building brick**, 107  
**Building paper**, 527  
**Building sand**, 113  
**Building stone**, 114  
**Bulletproof glass**, 502  
**Bulletwood**, 71  
**Buna N rubber**, 613  
**Buna S latex**, 396  
**Buna S rubber**, 613  
**Bung oil**, 414  
**Bunker C oil**, 305  
**Bunker Hill zinc**, 788  
**Bunting**, 115  
**Bunting bronze** 72, 79  
**Burgundy pitch**, 607  
**Buri oil**, 68  
**Burkeite**, 702  
**Burlap**, 115  
**Burlap-lined paper**, 528  
**Burma cutch**, 151  
**Burma lancewood**, 394  
**Burnettized wood**, 791  
**Burnishing sand**, 4  
**Burnishing wax**, 137  
**Burnt alum**, 25  
**Burnt sienna**, 508  
**Burnt umber**, 509  
**Burr oak**, 506  
**Burrstone**, 465  
**Burrwood**, 506  
**Bus-bar copper**, 206  
**Bush gum**, 388  
**Bush metal**, 78  
**Rushed iron**, 376  
**Buster steel**, 742  
**Butacite**, 761  
**Butadiene**, 116  
**Butadiene rubber**, 613  
**Butane**, 543  
**Butane dicarboxylic acid**, 13  
**Butanoic acid**, 283  
**Butanol**, 118  
**Butea gum**, 391  
**Butt brass**, 355  
**Butta-Van**, 118  
**Butter**, 116  
**Butter flavors**, 118  
**Butter of zinc**, 790  
**Buttercup yellow**, 791  
**Butternut**, 766  
**Button lac**, 634  
**Buttonball**, 564  
**Buttonwood**, 564  
**Butvars**, 759  
**Butyl alcohol**, 118  
**Butyl chloride**, 667  
**Butyl ether**, 273  
**Butyl rubber**, 615  
**Butyric acid**, 283  
**Byssus silk**, 647  
**C carbon**, 131  
**C55 steel**, 363  
**Cable lacquers**, 393  
**Cable lead**, 53  
**Cable paper**, 167  
**Cabretta**, 633  
**Cabuya**, 453  
**Cacahuanache oil**, 511  
**Cadalyte**, 119  
**Cade oil**, 383  
**Caderite**, 719  
**Cadmium**, 118  
**Cadmium amalgam**, 44  
**Cadmium bronze**, 119  
**Cadmium copper**, 119  
**Cadmium nitrate**, 119  
**Cadmium orange**, 559  
**Cadmium red**, 559  
**Cadmium solder**, 665  
**Cadmium sulphide**, 559  
**Cadmium-tin solder**, 665  
**Cadmium yellow**, 559  
**Cadmium-zinc solder**, 665  
**Cadmolith**, 418  
**Caesium**, 164  
**Caffeine**, 120

- Cajeput bark, 120
- Cajeput oil, 120
- Cajeputene, 267
- Cake tea, 717
- Calamine, 791
- Calaverite, 330
- Calavo, 512
- Calc spar, 121
- Calcareous sandstone, 623
- Calcene, 165
- Calcia, 410
- Calciferol, 763
- Calced alumina, 27
- Calced bauxite, 78
- Calced carbon, 715
- Calced dolomite, 252
- Calced gypsum, 343
- Calcinite, 641
- Calcite, 121
- Calcium, 121
- Calcium abietate, 457
- Calcium acetate, 122
- Calcium acid phosphate, 553
- Calcium arsenate, 369
- Calcium borate, 98
- Calcium carbide, 122
- Calcium carbonate, 165
- Calcium chloride, 122
- Calcium chloride hypochlorite, 170
- Calcium cyanamide, 499
- Calcium cyanide, 661
- Calcium diphosphate, 122
- Calcium feldspar, 285
- Calcium fluoride, 300
- Calcium fluorite, 300
- Calcium hypochlorite, 170
- Calcium lactate, 121
- Calcium lead, 400
- Calcium-lead alloy, 399
- Calcium linoleate, 457
- Calcium-manganese-silicon, 123
- Calcium metasilicate, 467
- Calcium mica, 460
- Calcium molybdate, 123
- Calcium monophosphate, 122
- Calcium nitrate, 662
- Calcium nitrate tetrahydrate, 294
- Calcium oxalate, 682
- Calcium oxide, 410
- Calcium peroxide, 519
- Calcium phosphate, 121
- Calcium plaster, 344
- Calcium resinate, 457
- Calcium silicate, 122
- Calcium silicon, 123
- Calcium stearate, 457
- Calcium sulphate, 343
- Calcium sulphite, 122
- Calcium triphosphate, 122
- Calcium tungstate, 627
- Caledonian brown, 509
- Calfskins, 354
- Calicel, 203
- Caliche, 662, 807
- Calico, 226
- Calido, 602
- California red gum, 338
- California redwood, 596
- California sardine, 353
- California sycamore, 704
- California whale, 773
- Calite, 348, 583
- Calking putty, 584
- Calomel, 185
- Calorene, 276
- Calorite, 602
- Calorized metals, 264
- Calsun bronze, 37
- Calumba root, 259
- Cambrie, 123
- Camel hair, 124
- Camel wool, 124
- Cameline oil, 592
- Cameroon mahogany, 441
- Camite, 719, 740
- Camouflage paint, 559
- Camp bones, 97
- Camphire, 265
- Camphor, 124
- Camphor oil, 124
- Camphor sassafrassy oil, 125
- Camphorene, 125
- Campillit, 571
- Camwood, 126
- Canada balsam, 126
- Canada turpentine, 126
- Canadian ash, 64
- Canadian spruce, 680
- Canaigre, 126
- Canaigre extract, 126
- Cananga oil, 786
- Canary seed, 126
- Canary whitewood, 737
- Candelilla wax, 127
- Candied orange peel, 542
- Candle pitch, 689
- Candle tar, 689
- Candlenut oil, 738
- Cane ash, 64
- Cane sirup, 696
- Canela preta, 767
- Canfieldite, 57
- Cannabis, 352
- Canned beef, 83
- Canned hash, 83
- Cannel coal, 127
- Canoe birch, 93
- Cantala, 651
- Canton silk, 647
- Canvas, 262
- Caoba, 440
- Caoutchouc, 610
- Cap copper, 595
- Cap powder, 306
- Cape asbestos, 61
- Cape boxwood, 101
- Cape ruby, 312
- Capeskin, 391
- Capivara skins, 354
- Cappagh brown, 509
- Caproic acid, 284
- Capyrylic acid, 284
- Capsicum, 535
- Car brass, 356
- Carageen, 14
- Caraguata, 215
- Caramel, 697
- Caramel malt, 75
- Caranday fiber, 671
- Carapa fat, 441
- Caraway, 674
- Caraway oil, 674
- Carbamide, 748
- Carbex, 641
- Carbicon, 641
- Carbitol, 277
- Carbitol acetate, 277
- Carbibrant, 641
- Carbocell, 131
- Carbofrax, 598
- Carbohydrates, 127
- Carbohydrogen, 459
- Carboids, 66
- Carbolic acid, 545
- Carbolite, 641
- Carboloid, 750
- Carbolox, 641
- Carboloy, 741
- Carbolux, 196
- Carbomang, 770
- Carbon, 129
- Carbon 13, 130
- Carbon 14, 130
- Carbon bisulphide, 132
- Carbon black, 132
- Carbon brick, 130
- Carbon brushes, 130
- Carbon dioxide, 133
- Carbon disulphide, 132
- Carbon electrodes, 130
- Carbon inks, 368
- Carbon-manganese steel, 448
- Carbon-molybdenum steel, 472
- Carbon monoxide, 133
- Carbon paper, 133
- Carbon steel, 134
- Carbon tetrachloride, 136
- Carbon tool steel, 732

- Carbon-vanadium steel, 751  
 Carbon-vanadium tool steel, 734  
 Carbona, 136  
 Carbonados, 245  
 Carbonate iron ore, 378  
 Carbonated beverages, 133  
 Carbonex, 715  
 Carbonic acid, 133  
 Carbonic anhydride, 133  
 Carbonite, 197  
 Carbonitrided steel, 139  
 Carbons, 245  
 Carbonyl chloride, 550  
 Carbonyl iron powder, 376  
 Carbor, 641  
 Carborite, 641  
 Carborundum, 641  
 Carbotam, 291  
 Carboxide, 306  
 Carboxy methyl cellulose, 154  
 Carboxyl group, 283  
 Carburit, 140  
 Carburite, 22  
 Carburizing compounds, 139  
 Cardamon, 674  
 Cardanol, 142  
 Cardboard, 531  
 Cardox, 133  
 Carex, 50  
 Careystone, 203  
 Caribbean pine, 561  
 Carilloy, 22  
 Carilloy FC steel, 135  
 Cariron, 484  
 Carmine lake, 191  
 Carmine red, 191  
 Carnallite, 574  
 Carnation oil, 539  
 Carmauba wax, 136  
 Carnelian, 15  
 Carnotite, 137  
 Caroa, 138  
 Carob bean, 419  
 Carob flour, 419  
 Caroba wood, 605  
 Carobronze, 551  
 Carolina poplar, 228  
 Carolina stone, 286  
 Carotene, 761  
 Carpenter stainless 5, 685  
 Carpenter stainless 8, 179  
 Carpenter stainless 10, 180  
 Carpenter stainless 20, 489  
 Carpenter stainless 303, 180  
 Carpenter steel 5-317, 490  
 Carpenter steel 158, 468  
 Carpenter steel 485, 501  
 Carpenter steel 610, 183  
 Carpenter steel 872, 422  
 Carpenter steel 874, 422  
 Carpenter steel 883, 501  
 Carpet wool, 784  
 Carragar, 14  
 Carrapicho, 384  
 Carrara marble, 452  
 Carrara structural glass, 565  
 Carrot oil, 50  
 Cartonite, 245  
 Cartridge brass, 138  
 Cartridge paper, 525  
 Carvacrol, 673  
 Caryophil oil, 186  
 Cascalote, 251  
 Cascamite, 750  
 Cascara, 258  
 Cascara sagrada, 258  
 Casehardening bone, 97  
 Casehardening materials, 138  
 Casein, 140  
 Casein bristles, 108  
 Casein fiber, 141  
 Casein glue, 327  
 Casein plastics, 140  
 Cashew nut, 141  
 Cashew-nut shell oil, 141  
 Cashmere, 142  
 Casings, 151  
 Caselen, 141  
 Castilla rubber, 610  
 Castilloa, 610  
 Cassava, 686  
 Cassel brown, 508  
 Cassel earth, 508  
 Cassel yellow, 401  
 Cassel's green, 559  
 Cassia, 185  
 Cassia buds, 185  
 Cassia oil, 186  
 Cassie, 538  
 Cassiterite, 142  
 Cast iron, 142  
 Cast-iron thermit, 723  
 Cast steel, 148  
 Castaloy, 770  
 Castile soap, 657  
 Casting brasses, 104  
 Castor beans, 147  
 Castor oil, 146  
 Castordag, 428  
 Castung, 148  
 Catalin, 547  
 Catalin-coated wood, 548  
 Catalyst, 150  
 Catalyst carriers, 28  
 Cataract metal, 234  
 Catasil, 150  
 Catechin, 311  
 Catechol, 710  
 Catechu, 151  
 Catechutanannic acid, 311  
 Catgut, 151  
 Cathartine, 630  
 Cation-active agents, 243  
 Cation exchange agents, 768  
 Cat's eye dammar, 240  
 Cattail fiber, 387  
 Cattle hair, 345  
 Cattle hides, 354  
 Cauassu wax, 137  
 Caustic ash, 659  
 Caustic lime, 410  
 Caustic magnesite, 431  
 Caustic potash, 662  
 Caustic soda, 661  
 Cavalite, 188  
 Cavalry twill, 227  
 Caxiguba latex, 611  
 Cayenne linaloe, 606  
 Cayenne oil, 606  
 Cayenne pepper, 535  
 Ceara rubber, 611  
 Ceara wax, 136  
 Ceccolloy, 144  
 Cedar, 152  
 Cedar pine, 561  
 Cedarwood oil, 383  
 Cedro, 152  
 Ceglin, 154  
 Cellinite, 347  
 Celairse, 156  
 Celanese, 156  
 Elastoid, 156  
 Celcon, 154  
 Celeron, 549  
 Celery, 673  
 Celery seed, 673  
 Celery-seed oil, 673  
 Celestial blue, 292  
 Celestite, 693  
 Celite, 247  
 Cellomold, 156  
 Cellon, 572  
 Cellophane, 153  
 Cellosolve, 277  
 Cellulak, 764  
 Cellular cellulose acetate, 678  
 Cellular rubber, 677  
 Cellulith, 764  
 Celluloid, 157  
 Cellulose, 153  
 Cellulose acetate, 155  
 Cellulose acetate butyrate, 156  
 Cellulose acetate lacquers, 156  
 Cellulose acetate propionate, 157  
 Cellulose ether, 154  
 Cellulose gum, 154  
 Cellulose nitrate, 157

Cellulose nitrate lacquer, 158  
 Cellulose nitrate plastics, 157  
 Cellulose triacetate, 155  
 Cel-O-Glass, 780  
 Cel-Rock, 71  
 Celotex, 71, 669  
 Cement, 158  
 Cement mortar, 159  
 Cement rock, 158  
 Cementite, 143  
 Central American cedar, 152  
 Centricast alloys, 488  
 Centrosphere, 798  
 Ceralan, 241  
 Ceramic binders, 161  
 Ceramic clays, 160  
 Ceramic enamels, 269  
 Ceramic granules, 115  
 Ceramitalc, 708  
 Cerargyrite, 162  
 Ceratherm, 162  
 Cerelose, 326  
 Ceresan M, 251  
 Ceresin, 519  
 Ceria, 163  
 Ceric molybdate, 164  
 Ceric oxide, 163  
 Ceric titanate, 163  
 Cerious nitrate, 163  
 Cerious oxide, 163  
 Ceritamic acid, 763  
 Cerium, 163  
 Cerium fluoride, 163  
 Cerium metals, 163  
 Cerium salts, 163  
 Cerium standard alloy, 163  
 Cerium stearate, 458  
 Cerotic acid, 84  
 Cerrobasc, 279  
 Cerrobend, 308  
 Cerrocast, 308  
 Cerromatrix, 279  
 Cerrosafe, 308  
 Certified malleable iron, 442  
 Cerulean blue, 726  
 Cerussite, 400  
 Cervantite, 55  
 Ceryl palmitate, 136  
 Cesium, 164  
 Cesium chloride, 164  
 Cetyl piperidine ricinoleate, 427  
 Cevadilla, 370  
 Cevalina, 251  
 Cevil, 235  
 Chaco cotton, 225  
 Chain bronze, 595  
 Chalcanthite, 214  
 Chalcedony, 587

Chalcocite, 210  
 Chalcopyrite, 209  
 Chalk, 165  
 Chalky wax, 136  
 Chalybeate steel, 732  
 Chambray, 226  
 Chamet bronze, 476  
 Chamico, 257  
 Chamois, 165  
 Champaca, 786  
 Champion sillimanite, 476  
 Champion steel, 359  
 Channel black, 132  
 Char, 139  
 Charcoal, 166  
 Charcoal iron, 166  
 Charcoal pig iron, 166  
 Charcoal plate, 726  
 Chardonnay silk, 593  
 Charka silk, 647  
 Charklets, 166  
 Charmeuse, 226  
 Charred peat, 533  
 Charta bombycina, 524  
 Charta damascena, 524  
 Chase alloy 720, 444  
 Chase alloy 772, 444  
 Chaser stones, 465  
 Chat sand, 114  
 Chateaugay iron, 557  
 Chats, 4  
 Chaulmoogra oil, 167  
 Cheddite, 678  
 Cheese, 118  
 Cheesecloth, 167  
 Chelene, 171  
 Chemalloy F32M, 488  
 Chemalloy H1, 493  
 Chemalloy N4, 489  
 Chemclad, 216  
 Chemic, 621  
 Chemical indicators, 168  
 Chemical lead, 399  
 Chemical lime, 410  
 Chemical stoneware, 162  
 Chemical wood pulp, 525  
 Chemigum, 616  
 Chemiseal gaskets, 290  
 Chempur tin, 725  
 Cherry, 168  
 Cherry birch, 92  
 Cherry gum, 475  
 Cherry kernel oil, 756  
 Cherry mahogany, 390  
 Chert, 623  
 Chessylite, 210  
 Chestnut, 169  
 Chestnut extract, 169  
 Chestnut oak, 505  
 Cheviot, 783  
 Chevreau, 391  
 Chevette, 391

Chia-seed oil, 169  
 Chiclec, 170  
 Chicory, 195  
 Chile saltpeter, 662  
 Chilean oak, 506  
 Chillex, 51  
 Chili pepper, 535  
 Chimo steel, 742  
 China clay, 385  
 China grass, 591  
 China silk, 647  
 China stone, 386  
 China tea, 716  
 China wood oil, 737  
 Chinaware, 385  
 Chinese blue, 292  
 Chinese bronze, 485  
 Chinese coir, 112  
 Chinese colza oil, 592  
 Chinese date, 383  
 Chinese dogwood, 252  
 Chinese elm, 268  
 Chinese green, 265  
 Chinese ink, 368  
 Chinese lacquer, 392  
 Chinese scarlet, 401  
 Chinese speculum, 671  
 Chinese vegetable tallow, 693  
 Chinese white, 793  
 Chinese yellow, 508  
 Chinook salmon, 619  
 Chinquapin oak, 505  
 Chintz, 413  
 Chip soap, 656  
 Chipboard, 532  
 Chir pine, 743  
 Chittam bark, 258  
 Chloracetophenone, 719  
 Chloramine T, 250  
 Chloramines, 46  
 Chlorate of potash, 574  
 Chlordane, 371  
 Chloride of lime, 170  
 Chlorinated hydrocarbons, 170  
 Chlorinated lime, 170  
 Chlorinated paraffin, 529  
 Chlorinated rubber, 171  
 Chlorine, 173  
 Chlorine dioxide, 173  
 Chloroacetone, 570  
 Chlorobromo ethane, 136  
 Chlorofluorine gas, 299  
 Chloroform, 171  
 Chlorophyll, 50  
 Chloropicrin, 570  
 Chloroprene, 615  
 Chloroprene polymers, 613  
 Chlorostannic acid, 172  
 Chlorowax, 529  
 Choclo, 219

- Chocolate, 192  
 Chocolate powder, 192  
 Chocolate, 192  
 Cholesterol, 241  
 Choline, 405  
 Chondrus, 14  
 Chromalin, 711  
 Chromaloid, 263  
 Chromang welding rod, 771  
 Chromate-protein films, 393  
 Chrome cake, 702  
 Chrome copper, 178  
 Chrome green, 174  
 Chrome lock, 313  
 Chrome-magnesite brick, 598  
 Chrome-magnesite cement, 599  
 Chrome-molybdenum steel, 173  
 Chrome ore, 176  
 Chrome-ore cement, 599  
 Chrome oxide green, 174  
 Chrome red, 401  
 Chrome-tanned leather, 710  
 Chrome-vanadium steel, 174  
 Chrome yellow, 401  
 Chromel No. 502, 488  
 Chromel A, 487  
 Chromel-Alumel, 723  
 Chromel C, 487  
 Chromel D, 488  
 Chromend 9M, 772  
 Chromic acid, 175  
 Chromic anhydride, 175  
 Chromic trioxide, 176  
 Chromite, 176  
 Chromite brick, 297  
 Chromium, 177  
 Chromium acetate, 474  
 Chromium boride, 100  
 Chromium bronze, 178  
 Chromium cast iron, 177  
 Chromium copper, 178  
 Chromium-iron alloys, 221  
 Chromium magnet steel, 439  
 Chromium-manganese steel, 179  
 Chromium mica, 460  
 Chromium-nickel alloys, 221  
 Chromium-nickel steel, 178  
 Chromium oxide, 610  
 Chromium phosphate, 560  
 Chromium plating, 177  
 Chromium-silicon steel, 635  
 Chromium stearate, 458  
 Chromium steel, 181  
 Chromium sulphate, 711  
 Chromium trioxide, 175  
 Chromium-tungsten steel, 182  
 Chromized steel, 350  
 Chromoloid, 578  
 Chromovan steel, 502  
 Chondure, 222  
 Chrysarobin, 259  
 Chrysochalk, 596  
 Chrysocolla, 211  
 Chrysolite, 513  
 Chrysoprase, 587  
 Chrysotile, 60  
 Ciccol, 511  
 Cigarette paper, 528  
 Cimex, 488  
 Cinchona, 183  
 Cinchonidine, 184  
 Cinchonine, 184  
 Cineole, 340  
 Cinerin, 584  
 Cinnabar, 185  
 Cinnamic aldehyde, 186  
 Cinnamon, 185  
 Cinnamon leaf oil, 186  
 Cinnamon oil, 186  
 Circassian walnut, 766  
 Circle C steel, 360  
 Circle L4 Steel, 770  
 Circle L10 steel, 183  
 Circle L12M steel, 683  
 Circle L18 steel, 42  
 Circle L22 steel, 181  
 Circle L22M steel, 181  
 Circle L22NM steel, 181  
 Circle L23 steel, 181  
 Circle L25M steel, 685  
 Citral, 406  
 Citrated caffeine, 120  
 Citric acid, 411  
 Citrine, 587  
 Citronella oil, 406  
 Citronellal, 406  
 Civet, 537  
 Civetone, 537  
 Clad steels, 264  
 Clarite steel, 359  
 Clary sage oil, 674  
 Clavenol, 243  
 Clavine, 259  
 Clay ironstones, 378  
 Clayite, 161  
 Clays, 160  
 Clear Flo starch, 687  
 Cleartex oil, 237  
 Clebrum, 350  
 Cleftstone, 653  
 Cleveite, 251  
 Clevite, 38  
 Clicker die steel, 635  
 Climax metal, 602  
 Clinker brick, 162  
 Clinkstone, 550  
 Cloisonné enamel, 270  
 Clorafin 42, 529  
 Clorafin 70, 529  
 Clothing wool, 783  
 Clove buds, 186  
 Clove oil, 186  
 Clovene, 186  
 Cloves, 186  
 Club moss, 700  
 Clupanodonic acid, 455  
 Clutch lining, 102  
 CM tap steel, 733  
 CMM tap steel, 733  
 CN-6 steel, 360  
 Co-Co steel, 360  
 Coal, 186  
 Coal briquettes, 304  
 Coal logs, 304  
 Coal oil, 389  
 Coal tar, 714  
 Coal-tar carbon, 715  
 Coal-tar oils, 715  
 Coal-tar pitch, 714  
 Coal-tar solvents, 666  
 Coalite, 196  
 Coast gray boxwood, 101  
 Coated fabrics, 187  
 Cob meal, 220  
 Cobalt, 189  
 Cobalt glance, 190  
 Cobalt high-speed steel, 358  
 Cobalt magnet steel, 439  
 Cobalt ores, 190  
 Cobalt oxide, 190  
 Cobalt pyrites, 59  
 Cobalt steels, 191  
 Cobalt-tungsten alloy, 739  
 Cobaltchrom, 770  
 Cobaltite, 190  
 Cochayuyo, 14  
 Cochin oil, 193  
 Cochineal, 191  
 Cocoa, 192  
 Cocoa beans, 191  
 Cocoa butter, 192  
 Cocoa waste, 120  
 Cocowood, 193  
 Cocobola, 193  
 Coconut butter, 194  
 Coconut charcoal, 10  
 Coconut fiber, 196  
 Coconut oil, 193  
 Coconut shell, 196  
 Coconut shell flour, 196  
 Cocos wood, 193  
 Codeine, 515  
 Codite, 764  
 Coffee, 194  
 Coffee-Captan, 195  
 Cohrastic, 63  
 Cohune oil, 68  
 Coin silver, 648  
 Coin steel, 491  
 Coinage copper, 110  
 Coinage gold, 329

- Cair, 195
- Cair fiberboard, 195
- Cair yarn, 196
- Coke, 196
- Coke plate, 726
- Coking coals, 95
- Cola mahogany, 390
- Colasta, 549
- Cold-drawn steel, 198
- Cold-heading die steel, 249
- Cold-molded plastics, 197
- Cold-resistant alloys, 483
- Cold-rolled steel, 197
- Cold rubber, 614
- Cold solder, 666
- Colhead steel, 734
- Colic root, 259
- Collagen, 316
- Collet steel, 450
- Collocl A, 154
- Collocl S, 154
- Collodion, 157
- Colloidal clay, 86
- Colloidal graphite, 332
- Colloidal silica, 636
- Colloidal tungsten, 739
- Collongite, 550
- Colloresin, 155
- Colmanite, 98
- Colmonoy, 100
- Cologne earth, 508
- Colombian mahogany, 440
- Colona steel, 490
- Colonial stainless steel, 684
- Colonial steel, 359
- Colonial steel No. 7, 752
- Colonial steel 410, 685
- Colophony, 607
- Coloradoite, 185
- Colorbestos, 61
- Coltrock, 750
- Columbite, 198, 713
- Columbium, 198
- Columbium carbide, 199
- Columbium oxide, 199
- Columbium pentoxide, 713
- Columbo-tantalite, 198
- Colza oil, 592
- Comber waste, 225
- Combination lead, 332
- Combing wool, 784
- Comet metal, 602
- Commercial brass, 355
- Commercial bronze, 595
- Common brass, 355
- Common lead, 399
- Comol, 439
- Compensator alloys, 541
- Complex sugars, 128
- Composite metals, 199
- Composite tool steel, 199
- Composition brass, 200
- Composition leaf, 111
- Composition metal, 200
- Compound, 803
- Compounded grease, 425
- Compreg, 567
- Compressed wood, 409
- Conambi, 242
- Concentrated alum, 26
- Concentrates, 517
- Concrete, 202
- Concrete blocks, 203
- Condensation plastics, 705
- Condensite, 353
- Condiment, 672
- Conductive coatings, 271
- Conductive glass, 321
- Conductivity bronze, 119
- Confidendrin, 56
- Congo coffee, 194
- Congo copal, 205
- Congo gum, 205
- Congo jute, 385
- Congo steel, 359
- Coniferin, 753
- Conifers, 810
- Conjugated oils, 260
- Conjulinol, 260
- Conjusoy, 260
- Conolite, 325
- Conolon, 325
- Conpernik, 541
- Constantan, 235
- Contact metals, 203
- Contact poisons, 369
- Continex FF, 133
- Contracid, 423
- Coodie, 605
- Coolants, 204
- Cooper alloy 531, 222
- Cooper alloy S-16, 488
- Cooper alloy S-21A, 488
- Cooper alloys, 488
- Cooperite, 235
- Cop-O-Top, 527
- Cop-R-Loy, 213
- Copaiba balsam, 342
- Copal, 205
- Copalite, 206
- Copaloy, 70
- Copel, 235
- Copene, 706
- Copey oak, 506
- Copper, 206
- Copper acetate, 209
- Copper-aluminum, 209
- Copper anodes, 51
- Copper-antimony alloys, 79
- Copper arsenite, 559
- Copper carbonate, 209
- Copper-chromium alloys, 178
- Copper-clad steel wire, 200
- Copper-Clude, 213
- Copper cyanide, 661
- Copper foil, 208
- Copper hydroxide, 211
- Copper iron, 213
- Copper-iron alloy, 208
- Copper-kote, 527
- Copper-lead alloys, 357
- Copper manganese, 445
- Copper-manganese alloys, 603
- Copper-manganese-lithium, 417
- Copper-nickel alloy, 234, 492
- Copper-nickel-iron alloy, 483
- Copper ores, 209
- Copper oxide, 211
- Copper powder, 208
- Copper pyrites, 209
- Copper-rich brass, 595
- Copper shot, 209
- Copper-silicon alloys, 212
- Copper-silicon-lithium, 417
- Copper-silver alloy, 208
- Copper sponge, 81
- Copper steel, 212
- Copper sulphate, 214
- Copper-tin alloy, 109
- Copper uranite, 747
- Copper wool, 693
- Copperas, 292
- Copperclad, 63
- Copperized CZC, 790
- Copperoid, 213
- Copperskin, 527
- Coppersmith's copper, 208
- Copra, 193
- Cor-Ten, 213
- Cor-Ten welding rod, 772
- Coral, 214
- Corbestos, 313
- Cord, 215
- Cordage, 214
- Cordage fibers, 214
- Cordfil, 225
- Cordierite, 708
- Cordite, 498
- Cordovan, 403
- Corduroy, 757
- Core binders, 217
- Core oils, 216
- Core sand, 469
- Corex, 641
- Coriander, 673
- Corinco corkboard, 218
- Corinth steel, 135
- Cork, 217
- Cork elm, 267
- Cork pine, 560

- Cork tile, 218  
 Cork waste, 217  
 Corkboard, 217  
 Corkoustic, 218  
 Corn, 218  
 Corn oil, 220  
 Corn sirup, 326  
 Corn sugar, 326  
 Corn sugar molasses, 326  
 Corn tassels, 220  
 Corncobs, 220  
 Corned beef, 83  
 Cornice copper, 208  
 Cornish clay, 386  
 Cornmint oil, 536  
 Cornstalks, 220  
 Cornstarch, 686  
 Cornwall stone, 286  
 Corolite, 652  
 Corozo oil, 68  
 Corresite, 325  
 Corroding lead, 398  
 Corrosion-resistant alloys, 221  
 Corrosiron, 642  
 Corrosive sublimate, 456  
 Corrugated asbestos, 62  
 Corsican pine, 744  
 Corundum, 222  
 Corvic bronze, 551  
 Cosal, 761  
 Coslettised steel, 556  
 Cosmos metal, 70  
 Cotalacc, 404  
 Cotthias metal, 109  
 Coticule, 776  
 Cotton, 223  
 Cotton batting, 225  
 Cotton bunting, 115  
 Cotton cashmere, 142  
 Cotton chintz, 413  
 Cotton crepe, 226  
 Cotton damask, 226  
 Cotton duvetyn, 227  
 Cotton fabrics, 226  
 Cotton gum, 338  
 Cotton-leather, 405  
 Cotton linters, 415  
 Cotton waste, 225  
 Cotton wax, 137  
 Cottonnade, 226  
 Cottonseed meal, 228  
 Cottonseed oil, 228  
 Cottonseed stearine, 228  
 Cottonwood, 228  
 Coumarin, 732  
 Cowrie, 388  
 Cow's milk, 464  
 CPR dust base, 370  
 Crab apple, 537  
 Crabwood, 441  
 Crash, 226, 412  
 Crayons, 708  
 Crazy water crystals, 702  
 Cream of tartar, 57  
 Cream softener, 699  
 Creamery butter, 116  
 Creosote, 229  
 Creosote bush resin, 601  
 Creosote oil, 229  
 Crescent steel, 362  
 Cresol, 229  
 Cressylite, 281  
 Cresylic acid, 229  
 Crilley metal, 44  
 Crim sagyz, 240  
 Crimp metal, 279  
 Crin, 112  
 Crin vegetal, 112  
 Crinex, 345  
 Crinoline, 230  
 Cristite, 770  
 Cristobalite, 588  
 Crobalt, 236  
 Crocar steel, 183  
 Crocidolite, 60  
 Crocin, 50  
 Crocus, 610  
 Crocus cloth, 610  
 Croloy, 200  
 Croloy steel, 183  
 Cromal, 31  
 Cromansil, 421  
 Cromax, 348  
 Cromo steel, 174  
 Cromoco die steel, 250  
 Cronak, 660  
 Crooksite, 722  
 Croton oil, 148  
 Crotonaldehyde, 230  
 Crotonic aldehyde, 230  
 Crow steel, 135  
 Crown filler, 343  
 Crown glass, 320  
 Crown steel, 175  
 Crucible steel, 691  
 Crude antimony, 54  
 Crude drugs, 256  
 Crushed stone, 115  
 Cryolite, 230  
 Cryolithionite, 407  
 Cryptocrystalline silica, 636  
 Cryptone, 793  
 Cryptostegia rubber, 231  
 Cryptozanthin, 762  
 Crysolite paint, 714  
 Crystal glass, 321  
 Crystalite, 8  
 Crystallin, 547  
 Crystalline graphite, 332  
 Crystalline silica, 636  
 Crystalline silicon, 638  
 Crystals of Venus, 209  
 Crystamet, 663  
 Crystex, 700  
 Crystogen, 353  
 Crystol oils, 510  
 Crystolite, 641  
 Crystolon, 641  
 Cu-Z metal, 442  
 Cuba jute, 384  
 Cuba wood, 309  
 Cuban pine, 561  
 Cubé, 242  
 Cube cutch, 311  
 Cubeb, 535  
 Cubeb oil, 535  
 Cucumber magnolia, 737  
 Cudbear, 418  
 Cufenium, 234  
 Cullet, 320  
 Cumar, 232  
 Cumar gum, 232  
 Cumaru bean, 731  
 Cumaru oil, 732  
 Cumerone, 232  
 Cumerone-indene resin, 232  
 Cumerone resins, 232  
 Cumin, 674  
 Cup grease, 425  
 Cup jewels, 366  
 Cupal, 263  
 Cupaloy, 208  
 Cupric oxide, 211  
 Cupric oxide hydrated, 560  
 Cuprite, 210  
 Cupron, 235  
 Cupronickel, 233  
 Cupronickel-manganese, 502  
 Cuprous oxide, 211  
 Cuprous sulphide, 210  
 Curaçao oil, 542  
 Curana, 385  
 Curare, 504  
 Curcas oil, 148  
 Curium, 748  
 Curled hair, 345  
 Curry powders, 319  
 Curua oil, 68  
 Curupay, 235  
 Cusiloy, 212  
 Cut shellac, 634  
 Cutanit, 741  
 Cutback asphalt, 66  
 Cutch, 151  
 Cutch brown, 312  
 Cutting alloys, 235  
 Cutting compounds, 237  
 Cutting oils, 236  
 Cuttle bone, 237  
 Cuttlefish bone, 237  
 Cutwire shot, 379  
 Cyanegg, 661  
 Cyanogas, 661

Cyanogen bromide, 571  
 Cyanogen chloride, 571  
 Cycline oil, 612  
 Cyclized rubber, 172  
 Cyclohexane, 667  
 Cyclohexanol, 667  
 Cyclohexyl levulinate, 125  
 Cyclohexol, 536  
 Cyclo trimethylene trinitroamine, 282  
 Cyclopentadiene, 261  
 Cyclopentane, 584  
 Cyclopol, 20  
 Cyclops steel No. 17, 349  
 Cycor, 191, 217  
 Cykelin, 261  
 Cykelsoy, 261  
 Cylinder grease, 425  
 Cylinder iron, 238  
 Cymene, 16  
 Cypress, 238  
 Cyprus bronze, 356  
 Cyprus pine, 622  
 Cyprus umber, 508  
 Cystamine, 353  
 Cystine, 580  
 Cytase, 150  
 C.Y.W. steel, 362

## D

D-acidite, 768  
 D nickel, 482  
 D-steel, 449  
 D-6Co steel, 360  
 D-stoff, 550  
 Dahoma, 335  
 Damar, 239  
 Damascene steel, 472  
 Damascus steel, 472  
 Damask, 413  
 Damask rose, 538  
 Dammar, 239  
 Dammar hitam, 240  
 Dammar Penak, 240  
 Dammar sengai, 240  
 Damourite, 463  
 Dandelion metal, 53  
 Dandelion rubber, 240  
 Danish pebbles, 335  
 Dannemora iron, 377  
 Danzig pine, 562  
 Daraloy 437, 36  
 D'Arcet's alloy, 309  
 Darex X-34, 614  
 Dariloid, 15  
 Dartex, 172  
 Darwin fiber, 112  
 Dasheen, 577  
 Davis metal, 234  
 DBL steel, 361  
 DDT, 371

Dead oil, 229  
 Deadburned magnesite, 431  
 Deadly nightshade, 257  
 Deal, 562  
 Dec-O-Ply, 568  
 Decalin, 481  
 Deccan hemp, 384  
 Deenite, 371  
 Deep-drawing brass, 355  
 Deer's tongue leaf, 732  
 Defieat iron, 683  
 Defirust iron, 683  
 Defistain, 179  
 Degami lancewood, 394  
 Degami wood, 394  
 Degras, 241  
 Degussit, 89  
 Dehydracetic acid, 125  
 Dehydranone, 125  
 Dehydrated beef, 84  
 Dehydrated castor oil, 147  
 Dehydrated coconut, 194  
 Dekorit, 549  
 Delanium, 333  
 DeLavoud metal, 145  
 Delhi A steel, 350  
 Delhi rustless iron, 350  
 Delloy No. 6, 236  
 Delta metal, 477  
 Deltamax, 541  
 Deluwang paper, 528  
 Demantoid, 313  
 Demerara greenheart, 334  
 Denaturants, 241  
 Denatured alcohol, 274  
 Denim, 255  
 Denol, 242  
 Densified wood, 409  
 Dent corn, 219  
 Dental amalgams, 44  
 Dental gold, 329  
 Dental spar, 286  
 Deodar, 152  
 Deodorized kerosene, 389  
 Deoxidizers, 35  
 Deoxidizing alloy, 291  
 Derris, 242  
 Desegatized steel, 732  
 Desiccated coconut, 194  
 Desilverized lead, 399  
 Desmophen, 12  
 Desulphurizing alloys, 660  
 Detergents, 245  
 Detonators, 306  
 Detritus, 807  
 Deuterium, 365  
 Deuterium oxide, 365  
 Devil's shoestring, 243  
 Dew of death, 570  
 Deward steel, 501  
 Dewaxed damar, 240  
 Dextrin, 244

Dextrose, 326  
 Dhupa fat, 755  
 Di-Metal No. 3, 789  
 Di-mol steel, 359  
 Diabase, 331  
 Diacetone, 7  
 Diacetone alcohol, 7  
 Diafoam, 666  
 Diala, 390  
 Dialdehyde, 303  
 Diallyl phenyl phosphate, 23  
 Diamite, 484  
 Diamond, 245  
 Diamond dust, 246  
 Diamond fiber, 764  
 Diamond flour, 246  
 Diamond powder, 246  
 Diamond wheels, 3  
 Diaspore, 78  
 Diatomaceous earth, 247  
 Diatomite, 247  
 Diatomite block, 247  
 Diatose, 150  
 Diabasic lead stearate, 458  
 Dibromethyl sulphide, 570  
 Dibutyl phthalate, 668  
 Dicalite, 247  
 Dichlorethyl ether, 667  
 Dichlorethylene, 667  
 Dichloro diphenyl trichlorethane, 371  
 Dichloroethyl formal, 667  
 Dickite, 385  
 Dick's bronze, 356  
 Didymium, 164  
 Die-block steel, 362  
 Die-casting die steel, 362  
 Die-casting metal, 247  
 Die steels, 249  
 Diethel ether, 273  
 Diethylene glycol, 277  
 Difluoro diphenyl trichlorethane, 371  
 Digitalis, 257  
 Digitoxin, 257  
 Dihydrazine sulphate, 47  
 Dihydro-ergocornine, 259  
 Dihydroacetic acid, 306  
 Dihydroxyacetic acid, 251  
 Diisooctyl adipate, 668  
 Dillecto, 548  
 Dill oil, 673  
 Dill seed, 673  
 Dill seed oil, 673  
 Dilo oil, 167  
 Diluex, 305  
 Dilver, 423  
 Dimethyl ether, 274  
 Dimethyl phthalate, 370  
 Dimethyl silicone, 645  
 Dimethyl sulpholane, 667  
 Dimethylamine, 46



- Dimity, 226  
 Dimondite, 740  
 Dinas silica, 598  
 Dinitro ortho cresol, 370  
 Dinitrotoluol, 281  
 Dioxan, 666  
 Dipentene, 266  
 Diphenyl carbonate, 87  
 Diphenyl guanidine, 337  
 Diphenyl methane, 538  
 Diphenylchloroarsine, 571  
 Diphosgene, 550  
 Dipping acid, 701  
 Direct iron, 557  
 Dirty steel, 690  
 Dirubin, 38  
 Disaccharides, 128  
 Discaloy, 349  
 Disico board, 296  
 Disinfectant soap, 657  
 Disinfectants, 250  
 Disodium phosphate, 736  
 Dispersite, 396  
 Dissolved bone, 98  
 Distrene, 572  
 Dita bark, 185  
 Ditamine, 185  
 Ditiane, 185  
 Divi-divi, 251  
 Dixie clay, 386  
 Djave butter, 441  
 DL-methionine, 581  
 Dodder oil, 592  
 Dodecanoic acid, 284  
 Dogger iron ore, 378  
 Doggrass root, 258  
 Dogwood, 251  
 Doler brass, 640  
 Dolomite, 252  
 Dolphin oil, 95  
 Dom nut, 381  
 Domestic salt, 620  
 Domet, 226  
 Domite, 487  
 Doré metal, 649  
 Dorscolene, 261  
 Dorsite, 10  
 Dotted swiss, 226  
 Doublé, 262  
 Double nickel salt, 497  
 Double sugars, 128  
 Douglas fir, 252  
 Douglas fir bark, 253  
 Douglas pine, 252  
 Douglas spruce, 252  
 Dow alloy No. 251, 435  
 Dowfume BR10, 306  
 Dowicide 7, 372  
 Dowicide G, 371  
 Dowmetal B, 435  
 Dowmetal EK30, 436  
 Dowmetal F, 435  
 Dowmetal H, 435  
 Dowmetal M, 435  
 Dowmetal ZK60A, 436  
 Down, 285  
 Dragon's blood resin, 391  
 Drawing paper, 253  
 Dreft, 243  
 Dresinite, 607  
 Dresinols, 773  
 Dri-Film 9977, 645  
 Dried beef, 84  
 Dried ginger, 318  
 Dried milk, 464  
 Drierite, 343  
 Driers, 254  
 Drill, 255  
 Drill rod, 255  
 Drill steel, 256  
 Drop black, 97  
 Drug plants, 256  
 Dry Flo starch, 687  
 Dry ice, 133  
 Dry iron, 377  
 Dry-Zero, 347  
 Dry zone mahogany, 390  
 Drycolene, 499  
 Drying oils, 260  
 Drymet, 663  
 Dryorth, 663  
 Duala mahogany, 390  
 Dubini, 390  
 Duck, 262  
 Duco, 393  
 Ductilite, 727  
 Dukuma, 390  
 Dulax, 20  
 Dulse, 14  
 Dumet, 424  
 Dumortierite, 476  
 Dunite, 513  
 Dunnite, 281  
 Duolith, 730  
 Duplate, 503  
 Duplex metal, 262  
 Duprene, 614  
 Duraloy, 684  
 Duraloy A, 348  
 Duralumin, 29  
 Duran glass, 320  
 Durana metal, 477  
 Duraplex, 20  
 Durhar bronze, 357  
 Durhar hard bronze, 357  
 Durco KA2S steel, 181  
 Durco KA2SMo steel, 181  
 Durex bronze, 333  
 Durex iron, 692  
 Durez, 549  
 Durichlor, 642  
 Durimet, 489  
 Durimet 20, 489  
 Duriron, 642  
 Durite, 487  
 Durium, 706  
 Duro gloss steel, 180  
 Durodi steel, 472  
 Duronze III, 639  
 Duroprene, 172  
 Durox 476, 500  
 Durum wheat, 775  
 Durundum, 38  
 Dusting clay, 370  
 Dutch liquid, 275  
 Dutch metal, 595  
 Dutch metal leaf, 111  
 Dutch white, 402  
 Dutch white metal, 545  
 Dutch yellow, 558  
 Dyestuffs, 264  
 Dymo diamond powder, 246  
 Dynafuel, 314  
 Dynalkol, 314  
 Dynamite, 499  
 Dynax motor fuel, 314  
 Dynel, 9  
 DYO steel, 362

## E

- E carbon, 132  
 Eagle wood, 606  
 Ear hair, 345  
 Earth metals, 19  
 Earth wax, 519  
 East African acacia, 151  
 East African mangrove, 450  
 East Indian arrowroot, 687  
 East Indian copaiba, 342  
 East Indian lemongrass, 406  
 East Indian walnut, 766  
 Eastern cottonwood, 228  
 Eastern hemlock, 351  
 Eastern spruce, 680  
 Easy solder, 651  
 Eatonite, 222  
 EB alloy, 182  
 Ebonite, 612  
 Ebonized asbestos, 63  
 Ebonized Monel, 474  
 Ebontex, 66  
 Ebony, 266  
 Ebrok, 197  
 Eclipsaloy 15A, 435  
 Eclipsaloy 56, 435  
 Eclipse-bronze, 485  
 Economo steel, 135  
 Edible calcium, 121  
 Edible fats, 283  
 Edible molasses, 696  
 Ecta bamboo, 73  
 Efkabimetal, 263  
 Egg albumin, 16  
 Egg white, 16

- Egoma oil, 540
- Egyptian blue, 746
- Egyptian cotton, 224
- Ehrhard's bearing metal, 789
- E.H.W. steel, 363
- Eider down, 285
- Eiderdown, 227
- Eighteen-eight steels, 179
- Elaine oil, 511
- Elastex, 66
- Elastite, 66
- Elaterite, 317
- Elcomet, 350
- Electric sheet steel, 643
- Electric steel, 691
- Electrical porcelain, 373
- Electrical sheet, 643
- Electrite, 296
- Electrite steel, 359
- Electrite uranium steel, 359
- Electro manganese, 443
- Electro-sheet copper, 207
- Electrode carbon, 132
- Electrolon, 641
- Electrolytic cadmium, 119
- Electrolytic copper, 207
- Electrolytic iron, 375
- Electrolytic nickel, 483
- Electrolytic tin plate, 727
- Electromet chromium copper, 178
- Electromet ferroboration, 100
- Electron, 435, 803
- Electropane, 321
- Electrose, 634
- Electrum, 329
- Elektron, 45, 435
- Elekton ZZ, 436
- Elements, 802
- Elemi, 266
- Elemi oil, 267
- Eleostearic acid, 738
- Elevator duck, 262
- Elfur iron, 487
- Elinvar, 423
- Elinvar extra, 423
- Elk leather, 267
- Elkonite, 772
- Elkskin, 267
- Elm, 267
- Eloxal, 29
- Elvandi steel, 752
- Elverite, 167
- Emerald, 88
- Emery, 268
- Emery cake, 268
- Emery paper, 268
- Emery S-751-R, 148
- Emetine, 258
- Emodin, 259
- Emulsified asphalt, 66
- Emulsifying agents, 268
- Emulsion, 268
- Enamel, 269
- Enamel paint, 520
- Enameling steels, 270
- Enamelite, 367
- Enameloid-cloisonné, 270
- Enargite, 59
- Encaustic ink, 368
- Encern steel, 441
- Enduria steel, 680
- Enduro 18-8, 179
- Eng teak, 718
- Engine sand, 622
- Engineers' bronze, 110
- English cherry, 169
- English crystal, 321
- English elm, 268
- English pewter, 544
- Enrup, 615
- Enzymes, 150
- Ephedra, 258
- Ephedrine, 258
- Epon resins, 706
- Epsom salt, 438
- Epsomite, 438
- Erasing rubbers, 765
- Eraydo, 790
- Erbia, 271
- Erbium, 271
- Erbium oxide, 271
- Ergosterol, 259
- Ergot, 259
- Ergot oil, 259
- Erigeron, 258
- Erigeron oil, 258
- Erinoid, 141
- Ermal, 146
- Ermalite, 146
- Erucic acid, 592
- Erythrene, 116
- Erythrite, 190
- Esco 20, 489
- Esopus stone, 465
- Esparto grass, 528
- Essences, 274
- Essential oils, 271
- Esskol, 414
- Essonite, 313
- Ester gum, 608
- Esterol, 20
- Esters, 272
- Estron, 156
- Etch wood, 568
- Etching brass, 355
- Etching materials, 273
- Ethanal, 5
- Ethanamide, 5
- Ethanedial, 303
- Ethanoic acid, 5
- Ethanol, 274
- Ethene, 275
- Ether, 273
- Ethocel, 154
- Ethyl acetate, 666
- Ethyl alcohol, 274
- Ethyl cellulose, 154
- Ethyl cellulose plastic, 154
- Ethyl chloride, 171
- Ethyl ether, 273
- Ethyl fluid, 721
- Ethyl gasoline, 721
- Ethyl lactate, 666
- Ethyl silicate, 277
- Ethyl vanillate, 753
- Ethylacetic acid, 283
- Ethylene, 275
- Ethylene alcohol, 277
- Ethylene diamine tartrate, 586
- Ethylene glycol, 277
- Ethylsulphuryl chloride, 570
- Eucalyptole, 340
- Eucalyptus, 339
- Eucalyptus dives oil, 340
- Eucalyptus oil, 340
- Eugenol, 186
- Euphorbia rubber, 611
- European ash, 64
- European beech, 83
- European buckthorn, 259
- European larch, 395
- European walnut, 766
- Europium, 164
- Europium salts, 164
- Eutechrom, 106
- Eutecrod, 106
- Evans' metallic cement, 44
- Evausteel, 181
- Everbrite, 234
- Everdur metal, 640
- Everdur 1000, 640
- ExB metal, 356
- Excel No. 60 oil, 237
- Excelite, 38
- Excello metal, 602
- Excelsior, 278
- Exfoliated mica, 758
- Exfoliated vermiculite, 757
- Exl-Die steel, 501
- Expanded metal, 278
- Expansive metal, 279
- Explosive, 279
- Explosive D, 281
- Extenders, 558
- Exton, 505
- Extra dynamite, 500
- Extra white metal, 316
- Extract wool, 785
- Extracted bone glue, 326
- Extruding brass, 477
- Exylin, 188
- Eyelet brass, 138

Eyrite, 86  
 E-Z Cut plate steel, 449  
 E-Z stainless steel, 685

## F

Fabinette, 404  
 Fabrifil, 225  
 Fabrikoid, 188  
 Fabroc, 549  
 Facoil, 709  
 Factex, 765  
 Factice, 765  
 Factice cake, 765  
 Factice sheet, 765  
 Factory lumber, 698  
 Fagarine, 185  
 Fagelan, 404  
 Fahlum metal, 382  
 Fahr alloy, 349  
 Fahrite, 349  
 Fahry's alloy, 778  
 Fairway metal, 34  
 Fairprene cement, 12  
 Fairprene fabrics, 188  
 False acacia, 418  
 Farlite, 549  
 Farm butter, 116  
 Fât liquors, 282  
 Fat lute, 430  
 Fatback, 455  
 Fats, 282  
 Fatty acids, 283  
 Faturan, 549  
 Fayalite, 513  
 Feathered zinc, 788  
 Feathers, 284  
 Fecraloy, 601  
 Feldspar, 285  
 Felseal, 313  
 Felt, 286  
 Feltex, 287  
 Fenchone, 673  
 Fennel, 673  
 Fennel oil, 673  
 Fenton's alloy, 789  
 Fenugreek, 673  
 Feran, 263  
 Ferberite, 780  
 Fergusonite, 164  
 Fermate, 372  
 Fermentation amyl alcohol,  
 48  
 Fernicklon, 264  
 Fernico, 423  
 Ferro-Celotex, 71  
 Ferric diethyl dithiocarbamate, 372  
 Ferric ferrocyanide, 292  
 Ferric oxide, 288  
 Ferric phosphate, 554  
 Ferric sulphate, 292

Ferrisul, 292  
 Ferrite, 143  
 Ferro-carbon-titanium, 291  
 Ferro-Therm, 346  
 Ferroboron, 100  
 Ferrocarbo, 641  
 Ferrochrome, 288  
 Ferrochromium, 288  
 Ferrocolumbium, 199  
 Ferroginous bauxite, 78  
 Ferromanganese, 289  
 Ferromanganese-sicilon, 642  
 Ferromolybdenum, 470  
 Ferrophosphorus, 290  
 Ferroselenium, 290  
 Ferrosilicon, 290  
 Ferrotitanate, 729  
 Ferrotitanium, 291  
 Ferrotungsten, 739  
 Ferrouanium, 747  
 Ferrous sulphate, 292  
 Ferrovanadium, 751  
 Ferroxcube, 439  
 Ferry metal, 400  
 Fertilizer bone, 97  
 Fertilizers, 292  
 Fialasol, 389  
 Fiber A, 9  
 Fiber leather, 404  
 Fiber pipe, 714  
 Fiber silk, 593  
 Fiber V, 593  
 Fiberboard, 294  
 Fibered quartz, 587  
 Fiberglas, 324  
 Fiberglas block, 325  
 Fiberglas cloth, 324  
 Fiberglas cordage, 216  
 Fiberglas PF, 325  
 Fiberglas tape, 324  
 Fiberglas yarns, 324  
 Fiberloid, 158  
 Fiberlon, 548  
 Fiberock, 62  
 Fibrasil, 138  
 Fibrated leather, 404  
 Fibreen, 527  
 Fibrofelt, 295  
 Fibroin, 646  
 Fibrous enamel, 271  
 Fibrous silica, 467  
 Ficus tree, 611  
 Field pine, 561  
 Fillloc, 225  
 Filt-char, 97  
 Filter alum, 25  
 Filter bauxite, 78  
 Filter felt, 287  
 Filter paper, 525  
 Filter plates, 297  
 Filter sand, 296  
 Finback whalebone, 774  
 Fine silver, 648  
 Fiori gum, 735  
 Fique fiber, 453  
 Fir, 252  
 Fire felt, 288  
 Fire sand, 598  
 Firearmor, 349  
 Firebrick, 297  
 Fireclay, 297  
 Firecrete, 297  
 Firedamp, 459  
 Firestone, 624  
 Fireworks powder, 437  
 Firthaloy, 741  
 Firthite, 741  
 Fish albumin, 17  
 Fish flour, 455  
 Fish glue, 327  
 Fish meal, 455  
 Fish oils, 509  
 Fish paper, 527, 765  
 Fish solubles, 510  
 Fixatives, 537  
 Fixed alkalies, 18  
 Fixed nitrogen, 499  
 Fixed oils, 509  
 Flagstone, 653  
 Flake alkali, 659  
 Flake graphite, 332  
 Flake powder, 39  
 Flalon, 504  
 Flameproofed paper, 527  
 Flanders' stone, 331  
 Flange plate, 96  
 Flannel, 783  
 Flare powders, 75  
 Flashless powder, 498  
 Flashlight powder, 437  
 Flasolee, 186  
 Flavors, 672  
 Flax, 298  
 Flaxseed, 413  
 Fleabane, 258  
 Flecto iron, 442  
 Fleece wool, 784  
 Flesh clay, 386  
 Flexalyn, 608  
 Flexarc welding rod, 771  
 Flexible sandstone, 624  
 Flexo steel, 679  
 Flexseal, 503  
 Flexwood, 568  
 Flint, 298  
 Flint corn, 219  
 Flint glass, 321  
 Flint paper, 298  
 Flint pebbles, 335  
 Flintmetal, 178  
 Flitters, 111  
 Flo-Sweet, 697  
 Floated flours, 1  
 Floating soap, 658

- Floor brick, 107  
 Flooring blocks, 66  
 Flooring cement, 160  
 Flooring plaster, 344  
 Flooring sand, 114  
 Flora wax, 136  
 Florence oil, 512  
 Florentine cloth, 265  
 Florentine glass, 323  
 Florentium, 592  
 Florex, 305  
 Florida arrowroot, 687  
 Floridin, 305  
 Florigel, 305  
 Florite, 305  
 Floss silk, 646  
 Flotation sulphur, 700  
 Flour bland, 659  
 Flour of emery, 268  
 Flowers of ajwan, 16  
 Flowers of camphor, 124  
 Flowers of sulphur, 700  
 Flue dust, 119  
 Fluftrok, 203  
 Fluoboric acid, 556  
 Fluorescein, 429  
 Fluorescent fabrics, 429  
 Fluorescent glass, 321  
 Fluorescent paint, 429  
 Fluorescent plastic, 430  
 Fluorex glass, 321  
 Fluoride crystals, 300  
 Fluorine, 298  
 Fluorine-phlogopite mica, 462  
 Fluorine plastics, 299  
 Fluorite, 300  
 Fluorocarbons, 299  
 Fluorothene plastic, 299  
 Fluorspar, 300  
 Flux, 300  
 Fluxing alloys, 300  
 Fluxing stone, 301  
 FNH powder, 498  
 Foam rubber, 677  
 Foamed slag, 653  
 Foamex, 677  
 Foamglas, 347  
 Foil, 302  
 Foliated graphite, 331  
 Fontainemoreau bronze, 788  
 Food colors, 49  
 Fool's gold, 379  
 Forest hardboard, 295  
 Forging brass, 477  
 Forging bronze, 476  
 Forging thermit, 723  
 Formaldehyde, 303  
 Formalin, 303  
 Formcel, 303  
 Formex, 760  
 Formic acid, 303  
 Formica, 548  
 Formin, 353  
 Formol, 303  
 Formonitrile, 363  
 Formosan alder, 18  
 Formvars, 759  
 Forsterite, 513  
 Forsterite firebrick, 513  
 Forticel, 156  
 Fortisan, 156  
 Fosfo rosin, 607  
 Fossil copal, 206  
 Fossil flour, 247  
 Fossil resins, 600  
 Foulard, 227  
 Foundry alloy, 22  
 Foundry coke, 196  
 Foundry-grade ferro-chrome, 289  
 Foundry pig iron, 557  
 Foundry sand, 468  
 Fountain-pen ink, 368  
 Foxtail millet, 465  
 Fraissite, 719  
 Framanol, 555  
 Frankfurt black, 758  
 Frankincense, 538  
 Frankite, 487  
 Franklinite, 791  
 Frary metal, 400  
 Frazer fir, 72  
 Free-cutting brass, 402  
 Free-cutting bronze, 110  
 Free-cutting copper, 208  
 Free-cutting stainless steel, 685  
 Free-cutting steel, 134, 628  
 Freestone, 623  
 Freijo, 766  
 French chalk, 165, 708  
 French pebbles, 298  
 French silver, 382  
 Freon, 600  
 Frit, 269  
 Frontier 40E alloy, 43  
 Fructose, 326  
 Fruit sugar, 326  
 F.S. smoke, 654  
 Fuchs site, 460  
 Fuel briquettes, 304  
 Fuel oil, 304  
 Fulani skins, 633  
 Fuller's earth, 305  
 Fulminates, 306  
 Fumaric acid, 707  
 Fume litharge, 596  
 Fume red lead, 596  
 Fumed oak, 506  
 Fumed silica, 637  
 Fumigant, 306  
 Fuming nitric acid, 497  
 Fuming sulphuric acid, 701  
 Fungicidal pigment, 560  
 Fungicides, 369  
 Furans, 307  
 Furfuracetone, 307  
 Furfural, 307  
 Furfural acetone, 307  
 Furfural-aniline resin, 307  
 Furfural-phenol resin, 307  
 Furfuraldehyde, 307  
 Furfuryl alcohol, 307  
 Furnace black, 132  
 Furol, 307  
 Fused quartz, 587  
 Fused silica, 636  
 Fusel oil, 48  
 Fusible alloys, 308  
 Fustians, 757  
 Fustic, 309  
 Futurit, 549  
 Fybr-Tech, 567

## G

- G bronze, 340  
 Gabardine, 227  
 Gaboon mahogany, 390  
 Gadolinite, 271  
 Gadolinium, 164  
 Gaerone clay, 161  
 Gal-Van-Alloy, 311  
 Galactan gum, 394  
 Galactose, 128  
 Galalith, 140  
 Galam butter, 755  
 Galangal, 318  
 Galbanum, 600  
 Galena, 400  
 Gall, 310  
 Gall nuts, 310  
 Gallium, 309  
 Gallium-tin alloy, 310  
 Galls, 310  
 Galuchat leather, 632  
 Galv-Weld, 311  
 Galvanized iron, 310  
 Galvanized wire, 311  
 Gamal, 1  
 Gambier, 311  
 Gambier bulat, 312  
 Gambier papu, 312  
 Gambir, 311  
 Gamboge, 754  
 Gamboge butter, 754  
 Gamma alumina, 39  
 Gamma brass, 103  
 Gamma rays, 590  
 Gammexane, 372  
 Gangaw, 380  
 Gangue, 517  
 Ganisand, 598  
 Ganister, 598

- Ganja, 352  
 Gaplek, 686  
 Gardinols, 243  
 Garlic, 674  
 Garnet, 312  
 Garnet cloth, 3  
 Garnet-coated paper, 3  
 Garnet lac, 634  
 Garnierite, 493  
 Garouille, 389  
 Gas cell fabric, 71  
 Gas oil, 304  
 Gasanol, 314  
 Gasket materials, 313  
 Gasoline, 313  
 Gasoline gel, 315  
 Gastex, 133  
 Gauze, 167  
 Gear bronze, 315  
 Gebang palm, 215  
 Gedge's metal, 477  
 Gedunohor, 624  
 Geic acid, 268  
 Gelatin, 315  
 Gelatine dynamite, 500  
 Gelobel, 500  
 Gelodyn, 500  
 Gelsor, 670  
 Gelva paint, 522  
 Gelvas, 759  
 Genelite, 333  
 Genetron, 101, 600  
 Gentian, 258  
 Genuine bablitt, 68  
 Geon latex, 188  
 Geon polyblend latex, 759  
 Geon resin, 759  
 Georgia pine, 561  
 Geraniol, 406  
 Geranium oil, 538  
 German sesame oil, 592  
 German silver, 316  
 Germania bearing bronze, 790  
 Germanite, 317  
 Germanium, 316  
 Germanium-gold alloy, 317  
 Germanium-helium alloy, 317  
 Germanium oxide, 317  
 Germicides, 250  
 Gersdorffite, 190  
 Ghatti gum, 735  
 Ghee butter, 118  
 Giant arbor vitae, 724  
 Giant bamboo, 73  
 Gibbsite, 78  
 Gibbsloy M-12, 204  
 Gifblaar, 682  
 Gilding metal, 595  
 Gilding powder, 111  
 Gilsonite, 317  
 Gilsonite dust, 318  
 Gingelly, 631  
 Ginger, 318  
 Ginger grass oil, 406  
 Ginger pine, 153  
 Gingerin, 318  
 Gingham, 226  
 Ginkgo wood, 101  
 Ginseng, 258  
 Gippsland boxwood, 101  
 Gix, 371  
 Glacial acetic acid, 6  
 Glance pitch, 318  
 Glands, 83  
 Glasfab, 324  
 Glassfloss, 325  
 Glass, 319  
 Glass blocks, 323  
 Glass-bonded mica, 461  
 Glass cloth, 227  
 Glass-coated steel, 270  
 Glass fiber, 323  
 Glass filter cloth, 325  
 Glass insulating sheet, 324  
 Glass insulating tape, 324  
 Glass mat, 325  
 Glass paper, 525  
 Glass rope, 216  
 Glass sand, 325  
 Glass sewing thread, 324  
 Glass silk, 323  
 Glass spar, 286  
 Glass wool, 323  
 Glassa, 45  
 Glassine, 526  
 Glassite, 610  
 Glassmakers' lepidolite, 407  
 Glassoid, 526  
 Glastic, 324  
 Glauber's salt, 701  
 Glazed kid, 391  
 Glos, 594  
 Gloss oil, 753  
 Glossecollite, 386  
 Glucinum, 88  
 Glucosamine, 698  
 Glucose, 326  
 Glucosides, 257  
 Glue, 326  
 Glues, 11  
 Glushartgewebe, 462  
 Glutrin, 217  
 Glyceric aldehyde, 50  
 Glycerin, 328  
 Glycerogen, 328  
 Glycerol, 328  
 Glycerol allyl ether, 261  
 Glycerol trinitrate, 499  
 Glycine, 537  
 Glyco, 70  
 Glycogen, 128  
 Glycol, 277  
 Glycol diformate, 277  
 Glycolic acid, 6  
 Glycolic aldehyde, 50  
 Glycyrrhiza, 407  
 Glydag, 428  
 Glyoxal, 303  
 Glyptal, 20  
 Goa powder, 259  
 Goatskin, 390  
 Goethite, 378  
 Gohi iron, 213  
 Gold, 329  
 Gold amalgams, 43  
 Gold bronze, 110  
 Gold chloride, 322  
 Gold-copper solder, 666  
 Gold-indium plate, 330  
 Gold leaf, 302  
 Gold powder, 111  
 Gold shell, 262  
 Gold-silver alloy, 329  
 Gold telluride, 330  
 Gold-tin purple, 322  
 Golden fir, 253  
 Golden ochre, 508  
 Golden wattle, 151  
 Goldenrod rubber, 231  
 Goldstone, 587  
 Gomuti fiber, 112  
 Goodrite resin, 50, 614  
 Goop, 437  
 Gopher plum, 338  
 Gorlseed oil, 167  
 Grafene, 333  
 Grafit, 333  
 Grahamite, 318  
 Grain alcohol, 275  
 Grain board, 344  
 Grain of poverty, 618  
 Grain oil, 48  
 Grainal alloys, 291  
 Grains of Paradise, 535  
 Gram, 508  
 Gramix, 334  
 Granite, 330  
 Granite granules, 115  
 Granite paper, 525  
 Granite pebbles, 335  
 Granite surface plates, 330  
 Granodine, 579  
 Granodized steel, 556  
 Grant sand, 469  
 Granular soap, 658  
 Granulated aluminum, 40  
 Granulated cork, 217  
 Granulated rubber, 616  
 Grape pomace, 57  
 Grape sugar, 326  
 Grapeseed oil, 331  
 Graph-Mo steel, 733  
 Graph-Sil steel, 733  
 Graph-Tung steel, 742

Graphalloy, 333  
 Graphex, 334  
 Graphicell, 131  
 Graphidox, 291  
 Graphitar, 131  
 Graphite, 331  
 Graphite brick, 130  
 Graphite carbon raiser, 332  
 Graphite grease, 425  
 Graphite lubricants, 428  
 Graphite powder, 331  
 Graphited bronze, 333  
 Graphited metals, 333  
 Graphitic steel, 146  
 Graphitoidal silicon, 638  
 Grappier cement, 411  
 Grass cloth, 591  
 Grass tree gum, 4  
 Gravata, 215  
 Gravel, 334  
 Gray birch, 92  
 Gray cobalt oxide, 190  
 Gray copper ore, 210  
 Gray Cut Cobalt steel, 360  
 Gray fir, 352  
 Gray iron, 142  
 Gray poplar, 573  
 Gray whale, 773  
 Grease, 424  
 Greasewood bush, 601  
 Gredag, 425  
 Greek fire, 607  
 Greek pitch, 607  
 Green ash, 64  
 Green bone glue, 326  
 Green chrome rouge, 610  
 Green copper ore, 210  
 Green cross, 550  
 Green ebony, 266  
 Green galls, 310  
 Green gold, 329  
 Green rouge, 1  
 Green salt, 747  
 Green tea, 716  
 Green ultramarine, 745  
 Green vitriol, 292  
 Greenalite, 377  
 Greenheart, 334  
 Greenland whale, 773  
 Greenockite, 119  
 Greensand, 296  
 Greensand cores, 469  
 Grefco, 176  
 Grenite, 688  
 Gridnic alloys, 488  
 Grinding compounds, 38  
 Grinding flour, 1  
 Grinding pebbles, 335  
 Grinding wheels, 2  
 Grindstones, 336  
 Grosgrain, 647  
 Grossularite, 313

Ground blood, 16  
 Ground glass, 2  
 Ground mica, 462  
 Groundnut oil, 532  
 Grouting sand, 114  
 GR-S ebonite, 612  
 GR-S rubber, 613  
 G.S.N. steel, 183  
 Guaiac gum, 336  
 Guaiacum, 336  
 Guaiacum oil, 336  
 Guaiacwood oil, 336  
 Guaiazulene, 336  
 Guanidine carbonate, 337  
 Guanidine nitrate, 336  
 Guano, 293  
 Guarana, 120  
 Guarea, 625  
 Guaruma wax, 137  
 Guava, 337  
 Guayaba, 337  
 Guayacan, 409  
 Guayule, 337  
 Guayule resin, 338  
 Guere palm, 67  
 Guignet's green, 610  
 Guinea gold, 595  
 Guinea pepper, 535  
 Gulf cypress, 239  
 Gum, 338  
 Gum accroides, 4  
 Gum arabic, 338  
 Gum benguela, 205  
 Gum Benjamin, 695  
 Gum elastic, 610  
 Gum kino, 391  
 Gum resins, 600  
 Gum rosin, 606  
 Gum Senegal, 339  
 Gum talha, 339  
 Gum thus, 744  
 Gum turpentine, 743  
 Gum Zanzibar, 49  
 Gummon, 67  
 Gunwood, 339  
 Gun flints, 298  
 Gun iron, 143  
 Guncotton, 498  
 Gunite, 146  
 Gunmetal, 340  
 Gunmetal ingot, 341  
 Gunny, 116  
 Gunpowder, 341  
 Gunpowder charcoal, 166  
 Gur, 697  
 Gurgi, 754  
 Gurjun balsam, 342  
 Gurjun oil, 342  
 Gut, 151  
 Guthrie's alloy, 309  
 Gutta hangkang, 342  
 Gutta jangkar, 343

Gutta percha, 342  
 Gutta siak, 342  
 Gutta soh, 342  
 Gutta sundik, 342  
 Gutta susu, 343  
 Gypsum, 343  
 Gypsum cement, 160  
 Gypsum plaster, 344  
 Gypsum wallboard, 344

## H

H-9 extra steel, 249  
 H Monel, 474  
 H-scale, 560  
 Haarlem oil, 414  
 Habutai, 647  
 Hackia, 380  
 Hackmatack, 394  
 Hadesite, 599  
 Hadfield manganese steel, 448  
 Hafnium, 345  
 Haiari, 242  
 Hair, 345  
 Hair felt, 287  
 Haircloth, 345  
 Half-and-half solder, 664  
 Halite, 620  
 Halloysite, 386  
 Halowax, 480  
 Hamamelis, 258  
 Hammer scale, 288  
 Hampden steel, 183  
 Hand grit soap, 657  
 Hand soap, 657  
 Hanover white metal, 545  
 Harassing agents, 718  
 Hard bearing bronze, 315  
 Hard bronze, 110  
 Hard coal, 51  
 Hard copal, 205  
 Hard-drawn spring wire, 680  
 Hard-finish plaster, 160  
 Hard gear bronze, 315  
 Hard glass, 320  
 Hard gold plate, 330  
 Hard lac, 634  
 Hard lead, 53  
 Hard maple, 451  
 Hard pine, 561  
 Hard porcelain, 373  
 Hard rubber, 611  
 Hard rubber dust, 616  
 Hard silk, 646  
 Hard solder, 665  
 Hard vulcanized fiber, 764  
 Hardboard, 295  
 Hardenable copper, 234  
 Hardened rosin, 602  
 Hardener alloy, 32

- Hardtem steel, 363  
 Hardware bronze, 202  
 Hardwood, 295  
 Hardwoods, 782  
 Hargus steel, 502  
 Hartmetall, 740  
 Hartporzellan, 373  
 Hartsalz, 574  
 Hartzink, 790  
 Harveyized steel, 495  
 Hashab gum, 339  
 Hashish, 352  
 Haskelite plywood, 569  
 Hastellite tungsten carbide, 740  
 Hastelloy, 484  
 Hastelloy A, 484  
 Hastelloy C, 484  
 Hastelloy D, 484  
 Hausmanite, 447  
 Haveg, 549  
 Haydite, 203  
 Haynes 25 alloy, 348  
 Hazel pine, 338  
 H.C. smoke, 655  
 HCN discoids, 364  
 Hearthstone, 624  
 Heartwood, 782  
 Heat insulators, 346  
 Heat-resistant alloys, 347  
 Heat-resistant cast iron, 145  
 Heat-resistant glass, 320  
 Heath, 295  
 Heather, 295  
 Heatherwood, 295  
 Heavy alloy, 350  
 Heavy mahogany, 625  
 Heavy naphtha, 480  
 Heavy spar, 73  
 Heavy water, 365  
 Hectorite, 86  
 Heiloy, 684  
 Helium, 351  
 Helvetia leather, 404  
 Helvite, 89  
 Hematine, 420  
 Hematite, 377  
 Hemicellulose, 128  
 Hemlock, 351  
 Hemlock-bark extract, 352  
 Hemlock spruce, 351  
 Hemoglobin, 376  
 Hemp, 352  
 Hempseed oil, 353  
 Henbane, 257  
 Henequen, 651  
 Henequen wax, 137  
 Henna, 265  
 Hennig purifier, 659  
 Heptalgin, 516  
 Heptane, 313, 561  
 Herabol myrrh, 601  
 Hercolyn, 608  
 Hercose C, 157  
 Hercosol, 563  
 Herculite, 565  
 Herculoy 418, 212  
 Herculoy 419, 212  
 Herculoy 421, 212  
 Herderite, 89  
 Herkolite, 404  
 Herolith, 549  
 Herring oil, 353  
 Hessenite, 313  
 Hessian, 116  
 Heusler alloy, 704  
 Hevea rubber, 610  
 Hevcatex, 396  
 Hevimet, 351  
 Hexachlor ethane, 170  
 Hexachloro cyclohexane, 371  
 Hexaethyl tetraphosphate, 371  
 Hexahydric alcohol, 668  
 Hexahydrophenol, 667  
 Hexalin, 667  
 Hexamine, 353  
 Hexanitro diphenylamine, 281  
 Hexanoic acid, 284  
 Hexosan, 128  
 Hexose, 128  
 Hexyl ether, 274  
 Hexylresorcinol, 251  
 Hi-Gloss steel, 180  
 Hi-Sil, 558  
 Hi-Steel, 422  
 Hi-Tem iron, 145  
 Hi-Tem S, 145  
 Hibitite, 556  
 Hickory, 354  
 Hickory elm, 267  
 Hiddenite, 675  
 Hide glue, 326  
 Hiden, 410  
 Hides, 354  
 Hiduminium, 33  
 Hiduminium alloys, 30  
 High-alloy steels, 23, 149  
 High brass, 355  
 High-brass bar, 355  
 High-carbon ferrochrome, 288  
 High-carbon ferrotitanium, 291  
 High-carbon steel, 149, 690  
 High-conductivity copper, 207  
 High explosives, 280  
 High-flash naphtha, 480  
 High-lead bronze, 356  
 High-nitrogen ferrochrome, 289  
 High-speed brass, 402  
 High-speed cement, 159  
 High-speed steel, 357  
 High-strength brass, 477  
 High-tensile brass, 35  
 High-test cast iron, 145  
 Highflex, 724  
 Hill pine, 561  
 Himalayan cedar, 152  
 Himalayan spruce, 681  
 Hiparco, 541  
 Hipernik, 541  
 Hipersil, 643  
 Hitenso, 119  
 HM steel, 359  
 Hoarhound, 258  
 Hoballoy, 468  
 Hobbing steels, 135  
 Hog tragacanth, 735  
 Hognut, 354  
 Holly, 361  
 Homberg's alloy, 309  
 Homogenized milk, 464  
 Honduras rosewood, 193  
 Honestone, 776  
 Honey, 85  
 Honey locust, 419  
 Honeycomb slag, 653  
 Honeycomb sponge, 676  
 Hoo Hoo metal, 70  
 Hoof glue, 328  
 Hoop ash, 64  
 Hoop pine, 562  
 Hop oil, 675  
 Hops, 675  
 Horn, 361  
 Horn meal, 361  
 Horn mercury, 185  
 Horn pith, 361  
 Hornbeam, 64  
 Hornblende, 3  
 Horse chestnut, 169  
 Horse gram, 508  
 Horseflesh mahogany, 440  
 Horseflesh ore, 210  
 Horsehair, 345  
 Horsehide, 354  
 Horsemint oil, 536  
 Hose duck, 262  
 Hoskins alloy 502, 348  
 Hoskins alloy 667, 602  
 Hot-die steels, 361  
 Hot-stamping brass, 477  
 Hot-work steel B-47, 362  
 Hot-work 8 steel, 363  
 House paint, 520  
 Household cements, 11  
 Hoyt metal, 53  
 H.T.M. steel, 491

- Hubnerite, 780
- Hull fiber, 415
- Humboldt redwood, 596
- Hungarian grass, 465
- Hungarian yellow wood, 309
- Hungary leather, 710
- Huron steel, 183
- Husman's alloy, 68
- Hutchinsonite, 722
- Hy-Glo steel, 685
- Hy-speed alloy, 81
- Hy-Ten-Sl, 446
- Hy-Tuf steel, 635
- Hyblum, 34
- Hybnickel, 349
- Hybrid corn, 220
- Hycar, 615
- Hycar OR-15, 615
- Hycar PA, 616
- Hycar-phenolic resin, 550
- H.Y.C.C. steel, 175
- Hydrated alumina, 26
- Hydrated alumina C-741, 27
- Hydrated ferric oxide, 377
- Hydrated lime, 410
- Hydraulic bronze, 201
- Hydraulic cement, 159
- Hydraulic fluids, 427
- Hydraulic lime, 411
- Hydrazine, 47
- Hydrocal, 344
- Hydrochloric acid, 363
- Hydrocyanic acid, 363
- Hydrocyanic acid gas, 661
- Hydrodarco, 10
- Hydrofluoric acid, 364
- Hydrogen, 364
- Hydrogen carboxylic acid, 303
- Hydrogen chloride, 363
- Hydrogen cyanide, 363
- Hydrogen fluoride, 364
- Hydrogen peroxide, 518
- Hydrogen sulphide, 700
- Hydrogenated castor oil, 148
- Hydrogenated coconut oil, 194
- Hydrogenated oils, 365
- Hydrogenated rosin, 608
- Hydrol, 326
- Hydrolyzed proteins, 580
- Hydronol, 242
- Hydrosphere, 798
- Hydrostone, 344
- Hydroxy acetic acid, 6
- Hydroxy carboxylic resins, 705
- Hydroxy stearic acid, 148
- Hydulignum, 569
- Hylastic steel, 450
- Hyoscyamine, 257
- Hyprez, 246
- Hystrene, 689
- Hytemco, 602
- Hyten M steel, 472
- Hytena, 38
- I
- Ibera, 409
- Iceland spar, 121
- Ichthyocolla, 340
- Ichthyol, 380
- Idilite, 38
- Idilon, 641
- IG wax S, 520
- IG wax V, 520
- Igamide, 749
- Igelite, 759
- Igepon T, 244
- Igepons, 244
- Igemerald, 88
- Igneous rocks, 800
- Igovin, 759
- Illiani silk, 387
- Illinium, 592
- Illipe butter, 99
- Illipe nuts, 99
- Illipe tallow, 99
- Illium, 483
- Illium R, 483
- Ilmenite, 729
- Image stone, 550
- Imbuia, 766
- Iminazoic acid, 306
- Imitation leather, 404
- Imitation pearls, 560
- Imitation silver, 484
- Imperial major steel, 360
- Impervite, 333
- Impreg weldwood, 567
- Impregnated fabrics, 189
- In wood, 342
- In oil, 718
- Incendiary powder, 437
- Incense cedar, 383
- Inconel, 488
- Inconel X, 489
- Inda, 141
- Indelible ink, 368
- Indelible lead, 332
- Indene, 232
- Indene resins, 232
- India ink, 368
- India oilstones, 511
- India rubber, 610
- Indian barley, 370
- Indian corn, 219
- Indian cutch, 151
- Indian gum, 735
- Indian hemp, 703
- Indian hog gum, 735
- Indian jute, 384
- Indian mahogany, 734
- Indian mica, 461
- Indian oak, 717
- Indian red, 288
- Indian rosewood, 605
- Indian saffron, 319
- Indian tobacco, 258
- Indiana limestone, 412
- Indianaite, 386
- Indican, 365
- Indicum, 368
- Indigo, 365
- Indigo red, 365
- Indigo white, 365
- Indirubin, 365
- Indium, 366
- Indium oxide, 366
- Indium solder, 666
- Indol, 366
- Indur, 549
- Indurite, 498
- Industrial, 62
- Industrial alcohol, 274
- Industrial diamonds, 245
- Industrial jewels, 366
- Industrial salt, 620
- Industrial stoneware, 162
- Infusorial earth, 391
- Inga seed, 127
- Ingaclad, 200
- Ingerin, 761
- Ingolin, 518
- Ingot iron, 367
- Ink, 368
- Inorganic catalysts, 150
- Inorganic plastics, 644
- Insecticide 666, 371
- Insecticides, 369
- Inside white, 793
- Insulating blocks, 466
- Insulating concrete, 203
- Insulating felt, 287
- Insulating oils, 373
- Insulating paper, 527
- Insulation porcelain, 373
- Insulators, 372
- Insulbrix, 297
- Insulcrete, 297
- Insuline, 297
- Insulite, 347
- Insuluminum, 264
- Insurox, 706
- Intensarc, 771
- Inter-Weld metal, 263
- Intermediate manganese steel, 448
- Intermediate mabbitt, 69
- Intertype metal, 745
- Inulin, 240, 687
- Invar, 422



Invar steel, 502  
 Invert soaps, 243  
 Invisible glass, 321  
 Invisible-writing ink, 368  
 Iodine, 374  
 Iodine cyanide, 374  
 Iodoacetone, 571  
 Ion, 803  
 Ionium, 374  
 Ionol, 56  
 Ionone, 406  
 Ipecac, 258  
 Ipoka, 678  
 Ipsonite, 66  
 Iridium, 374  
 Iris agate, 15  
 Irish moss, 14  
 Irish potato, 576  
 Irium, 243  
 Iroko, 717  
 Iron, 375  
 Iron 55, 376  
 Iron-aluminum alloys, 439  
 Iron carbonyl, 376  
 Iron chromate, 176  
 Iron fibered steel, 786  
 Iron ores, 376  
 Iron powder, 376  
 Iron pyrite, 379  
 Iron shot, 379  
 Iron sponge, 677  
 Iron sulphate, 292  
 Iron-tungsten alloys, 739  
 Ironbark, 340  
 Ironc, 539  
 Ironite, 487  
 Ironstone, 378  
 Ironwood, 380  
 Isano oil, 261  
 Isethionic acid, 244  
 Isinglass, 380  
 Isoamyl alcohol, 48  
 Isobutene polymers, 613  
 Isobutyl carbinol, 48  
 Isobutyl vanillate, 579  
 Isocrotyl chloride, 667  
 Isolantite, 398  
 Isolators, 669  
 Isoline, 148  
 Isopol, 572  
 Isoprene, 612  
 Isopropanol, 275  
 Isopropyl alcohol, 275  
 Isopropyl ether, 274  
 Isopropyl trichloro benzene, 171  
 Isopropylamine, 47  
 Isorod, 772  
 Isotela, 347  
 Istle, 652  
 Itacolumite, 624  
 Italian chestnut, 169

Italian cypress, 238  
 Italsil, 40  
 Itauba, 718  
 Itauba preta, 718  
 Ivoricast, 548  
 Ivory, 380  
 Ivory black, 97  
 Ivory board, 532  
 Ivory nut, 381  
 Izarine, 695

## J

J-metal, 235  
 Jaboty fat, 100  
 Jacaranda, 605  
 Jacinth, 795  
 Jacitara, 593  
 Jack pine, 561  
 Jacna metal, 68  
 Jacobs' alloy, 640  
 Jacoby metal, 778  
 Jade, 60  
 Jaggary, 697  
 Jamaica pepper, 672  
 Jamaica quassia, 588  
 Jamba oil, 479  
 Jamesonite, 55  
 Japan, 270  
 Japan fish oil, 510  
 Japan tallow, 381  
 Japan tea, 716  
 Japan wax, 381  
 Japanese ash, 64  
 Japanese herring, 353  
 Japanese spruce, 681  
 Japanese willow, 779  
 Japanese wood oil, 738  
 Japonic acid, 381  
 Jarina, 381  
 Jarrah, 340  
 Jasmine, 539  
 Jasmine-rose oil, 539  
 Jasper, 588  
 Jatabo resin, 205  
 Jaua, 577  
 Jaumave istle, 652  
 Java coffee, 195  
 Java cotton, 387  
 Java jute, 384  
 Javel water, 621  
 Jaw oil, 96  
 Jean, 255  
 Jeffry pine, 561  
 Jelutong, 573  
 Jena blue glass, 322  
 Jerked beef, 84  
 Jerusalem artichoke, 688  
 Jessco steel, 359  
 Jesuits' bark, 184  
 Jet, 408  
 Jewel diamonds, 245

Jewel pins, 367  
 Jewell alloy, 146  
 Jewelry alloys, 382  
 Jimson weed, 257  
 Johnson alloy 29, 357  
 Johnson bronze, 79  
 Johnson bronze 25, 357  
 Johnson bronze 40, 79  
 Johnson bronze 44, 79  
 Jojoba alcohol, 383  
 Jojoba oil, 382  
 Jojoba wax, 382  
 Josephinite, 379  
 Journal bronze, 78  
 J-S steel, 742  
 Juglone, 767  
 Jujube, 383  
 Juniper, 383  
 Juniper berries, 383  
 Juniper tar oil, 383  
 Jura turpentine, 680  
 Juta indiana, 384  
 Juta paulista, 384  
 Jutahycica resin, 205  
 Jute, 384  
 Jute board, 532  
 Jute paper, 384  
 Juvelite, 546

## K

K felt, 287  
 K Monel, 473  
 K-Veneer, 568  
 KA steel, 179  
 K42R alloy, 349  
 Kade, 755  
 Kafr corn, 220  
 Kabikatea, 562  
 Kail, 390  
 Kainite, 574  
 Kaiseroda, 702  
 Kaki, 266  
 Kala til seed, 127  
 Kalistron, 188  
 Kalium, 574  
 Kalsomine, 522  
 Kalunite, 25  
 Kalunti, 397  
 Kalvan, 165  
 Kamassi wood, 101  
 Kamenol D, 244  
 Kamptulicon, 413  
 Kanga, 754  
 Kangaroo leather, 385  
 Kantan, 13  
 Kantal, 602  
 Kanyin oil, 342  
 Kaolin, 385  
 Kaolinic earth, 386  
 Kaolinite, 385  
 Kapok, 387

Kapok oil, 387  
 Kapur, 125  
 Karaba, 45  
 Karakul, 388  
 Karaya, 735  
 Karbate No. 1, 131  
 Karbate No. 2, 131  
 Karbolite, 546  
 Karite, 755  
 Karma, 602  
 Karmash's alloy, 68  
 Karolith, 141  
 Karri, 340  
 Kasil, 663  
 Kastek paper, 526  
 Katchung oil, 533  
 Katharin, 136  
 Kauri gum, 388  
 Kauri pine, 388  
 Kaurit, 750  
 Keawe, 419  
 Kedempo, 755  
 Keen-edge steel, 685  
 Keene's cement, 160  
 Keilhauite, 164  
 Kekune oil, 738  
 Kel-F, 300  
 Kel-X-L oil, 261  
 Keldur, 669  
 Kelene, 171  
 Kelgin, 15  
 Kellin, 261  
 Kellsay, 261  
 Kelp, 13  
 Kelp meal, 15  
 Kelpchar, 10  
 Keltex, 15  
 Keltrol L., 414  
 Kemidol, 410  
 Kemp, 467  
 Kemrock, 624  
 Kenaf fiber, 384  
 Kennametal, 741  
 Kentanium, 728  
 Kentanium 151A, 729  
 Kerite, 610  
 Kermes, 388  
 Kermesic acid, 389  
 Kermesite, 55  
 Kernite, 98  
 Kerogen, 631  
 Kerosene, 389  
 Keruing, 737  
 Khaki, 255  
 Khasia pine, 743  
 Khaya, 389  
 Khood, 605  
 Khuskhus, 538  
 Kid, 390  
 Kidney ore, 377  
 Kidskin leather, 390  
 Kieselguhr, 391

Kieserite, 438  
 Killas, 708  
 Kimflex board, 296  
 King salmon, 619  
 Kingnut, 354  
 King's yellow, 59  
 Kingsley clay, 161  
 Kinite, 770  
 Kino resin, 391  
 Kinonglas, 503  
 Kiou-nouk, 538  
 Kip skins, 354  
 Kiri, 72, 634  
 Kiski steel, 501  
 Kitol, 774  
 Kittool, 112  
 Klebsand, 598  
 Klingenberg clay, 297  
 Klop, 570  
 Knotty pine, 561  
 Koal Pak, 304  
 Kodapak, 156  
 Koeller's alloy, 545  
 Kok sagyz, 240  
 Kola nuts, 120  
 Kombu, 14  
 Konel, 492  
 Kordofan gum, 339  
 Koresin, 707  
 Korfund isolator, 669  
 Korn-Kob, 220  
 Korogel, 615  
 Korolac, 615  
 Koroseal, 615  
 Kosmos 60, 133  
 Kosmovar, 133  
 Kousa, 252  
 Kovar, 424  
 Kraft paper, 525  
 Krala, 390  
 Krameria, 592  
 Krim-Ko gel, 14  
 Kriston, 23  
 Krokology, 770  
 Kromax glass, 321  
 Krupp analysis steel, 491  
 Krupp austenitic steel, 179  
 Kryalith, 231  
 Kryocide, 231  
 Kryolithionite, 675  
 Krypton, 481  
 Krystallin, 49  
 KS magnet steel, 439  
 Kube-Kut, 783  
 Kukui oil, 738  
 Kumium, 178  
 Kumyss, 464  
 Kunheim metal, 585  
 Kunststein, 432  
 Kuprodur, 640  
 Kuravilon, 758  
 Kuromi, 382

Kuromono, 211  
 Kut-Steel, 380  
 Kutkost alloy, 236  
 Kutkwik steel, 359  
 Kvarmtorp shale, 631  
 Kyanite, 392  
 Kyanol, 49  
 Kyrock, 65

## L

La-Led steel, 403  
 Lahdanum, 260  
 Labyrinthic gas, 569  
 Lac, 381  
 Lac dye, 633  
 Laccain, 546  
 Lace leather, 404  
 Lacquer, 392  
 Lacrimite, 550  
 Lactic acid, 464  
 Lactoid, 141  
 Lactonite, 141  
 Lactoprene rubber, 616  
 Lactose, 128  
 Lagging cloth, 324  
 Lagoriolite, 313  
 Lake copper, 207  
 Lakes, 558  
 Lallemantia oil, 261  
 Lambskin, 633  
 Lamicoid, 461  
 Laminated glass, 502  
 Laminated plastics, 548  
 Laminated wood, 566  
 Laminating paper, 527  
 Lampblack, 393  
 Lampblack oil, 394  
 Lamy, 754  
 Lanain, 241  
 Lanaset, 189  
 Lancashire iron, 786  
 Lancewood, 394  
 Lanese, 156  
 Lanese fiber, 594  
 Langbeinite, 438  
 Lanitol, 141  
 Lanoceric acid, 241  
 Lanolin, 241  
 Lanopalmic acid, 241  
 Lanoset, 455  
 Lanosterol, 241  
 Lanthanum, 164  
 Lanthanum oxide, 164  
 Lanum, 241  
 Lapix, 301  
 Lapping abrasives, 2  
 Larch, 394  
 Larch fir, 394  
 Lard, 395  
 Lard compound, 365  
 Lard oil, 395

- Largetooth aspen, 65  
 Larvicide, 369  
 Laterite, 78  
 Latex, 395  
 Latex cements, 12  
 Latex foam, 396  
 Latex pastes, 11  
 Latten ware, 544  
 Lauan, 396  
 Laudanum, 515  
 Laundry soda, 659  
 Lauralene, 284  
 Lauric acid, 284  
 Lautal, 30  
 Lava, 397  
 Lava talc, 708  
 Lavalloy, 398  
 Lavender oil, 537, 539  
 Lavender water, 539  
 Laver, 14  
 Lavolain, 398  
 Lawson cypress, 153  
 Lead, 398  
 Lead acetate, 254  
 Lead alkali metals, 399  
 Lead anodes, 51  
 Lead azide, 306  
 Lead-base babbitt, 69  
 Lead bronze, 357  
 Lead carbonate, 401  
 Lead chromate, 401, 559  
 Lead-coated copper, 399  
 Lead-coated steel, 720  
 Lead foil, 302  
 Lead-indium alloys, 366  
 Lead linoleate, 254  
 Lead-lube grease, 425  
 Lead molybdate, 471  
 Lead monoxide, 415  
 Lead oleate, 254  
 Lead ores, 400  
 Lead pencils, 332  
 Lead pigments, 401  
 Lead-silver solder, 651  
 Lead styphnate, 306  
 Lead sulfamate, 699  
 Lead sulphate, 559  
 Lead thiosulphate, 402  
 Lead titanate, 730  
 Lead wool, 399  
 Leaded bronze, 356  
 Leaded copper, 209  
 Leaded glass, 321  
 Leaded gunmetal, 341  
 Leaded high brass, 402  
 Leaded steel, 402  
 Leaded zinc oxide, 793  
 Leadoid, 521  
 Leadtex, 399  
 Leaf lard, 395  
 Leantin, 70  
 Leather, 403  
 Leather board, 404  
 Leather dust, 405  
 Leather fabrics, 188  
 Leather flour, 405  
 Leatherlubric, 699  
 Lebanon No. 34 alloy, 221  
 Lebanon cedar, 152  
 Lebanon steel 22XM, 472  
 Lebanon steel 48, 349  
 Lechuguilla, 652  
 Lecithin, 405  
 Lectorcast, 486  
 Ledaloyl, 333  
 Leddel alloy, 790  
 Ledger paper, 525  
 Ledloy, 402  
 Ledrite brass, 402  
 Lees, 57  
 Leipzig yellow, 401  
 Lektromesh, 780  
 Lemon, 411  
 Lemon juice, 411  
 Lemon oil, 411  
 Lemongrass oil, 405  
 Lemongrass pulp, 406  
 Lensex, 244  
 Leonite, 574  
 Lepidolite, 406  
 Lesco H steel, 683  
 Lesco L steel, 683  
 Lesco LM steel, 683  
 Lesco M steel, 683  
 Lethal gases, 570  
 Lethane, 584  
 Leukanol, 711  
 Leukorit, 549  
 Levant styrax, 694  
 Levigated abrasive, 1  
 Levo menthol, 340  
 Levulose, 326  
 Lewis iron, 786  
 Lewisite, 570  
 Lewisol resin, 608  
 Liberian coffee, 194  
 Libollite, 66  
 Licanic acid, 511  
 Lichenin, 128  
 Lichtenberg's alloy, 309  
 Licorice, 407  
 Licuri nuts, 137  
 Licuri oil, 137  
 Licuri wax, 137  
 Lignin, 407  
 Lignite, 408  
 Lignite wax, 519  
 Ligno-sulphonic acid, 681  
 Lignum vitae, 409  
 Lime, 410  
 Lime grease, 425  
 Lime-hardened rosin, 607  
 Lime juice, 411  
 Lime mortar, 411  
 Lime oil, 411  
 Lime wood, 76  
 Limeolith, 165  
 Limestone, 412  
 Limon balsa, 72  
 Limonene, 266  
 Limonin, 542  
 Limonite, 377  
 Linabestos, 62  
 Linaloe oil, 606  
 Linalol, 606  
 Linalyl acetate, 537  
 Linden, 76  
 Lindol, 125  
 Lindol HF-X, 427  
 Linen, 412  
 Linen duck, 262  
 Linen fabrics, 412  
 Lingue, 625  
 Lining metal, 53  
 Linnacite, 190  
 Linofelt, 669  
 Linoleum, 413  
 Linotile, 218  
 Linoxyn, 414  
 Linseed, 413  
 Linseed cake, 414  
 Linseed oil, 412  
 Linseed pitch, 689  
 Linters, 415  
 Lionite, 38  
 Lipids, 83  
 Lipowitz alloy, 308  
 Liqui-Moly, 427  
 Liquid air, 415  
 Liquid gas, 543  
 Liquid glues, 328  
 Liquid oxygen, 518  
 Liquid stainless steel, 521  
 Liquid sugar, 697  
 Liquidambar, 694  
 Lisle, 412  
 Litharge, 415  
 Lithiophilite, 407  
 Lithium, 415  
 Lithium alloys, 417  
 Lithium-calcium alloys, 417  
 Lithium chloride, 416  
 Lithium copper, 417  
 Lithium greases, 458  
 Lithium hydride, 416  
 Lithium-lead, 417  
 Lithium ores, 407  
 Lithium six, 416  
 Lithium stearate, 458  
 Lithium-treated steel, 417  
 Lithographic oil, 414  
 Lithographic stone, 412  
 Lithopone, 418  
 Lithospar, 675  
 Lithosphere, 798  
 Litmus, 418

Litmus paper, 418  
 Liver ore, 185  
 Livingstonite, 185  
 Lizard leather, 21  
 Llama hair, 24  
 LMW steel, 359  
 Lo-Ex alloy, 33  
 Laolin, 572  
 Loba copal, 205  
 Lobelia, 258  
 Lobinine, 258  
 Loblolly pine, 561  
 Locust, 413  
 Locust bean flour, 419  
 Locust bean gum, 419  
 Lode tin, 142  
 Lodgepole pine, 561  
 Logwood, 420  
 Lokao, 265  
 Lombardy poplar, 573  
 Lوندال, 34  
 Long pepper, 535  
 Long varnish, 753  
 Longleaf pine, 560  
 Longstraw pine, 560  
 Loofa sponge, 420  
 Lorandite, 722  
 Lotens, 641  
 Lotol, 396  
 Lotus metal, 70  
 Low-alloy steels, 420  
 Low brass, 595  
 Low-carbon ferrochrome, 289  
 Low-carbon ferromanganese, 289  
 Low-carbon ferrotitanium, 291  
 Low-carbon steel, 149, 690  
 Low-expansion alloys, 422  
 Lox, 280  
 Loxa bark, 183  
 Lubaloy, 138  
 Lubeco metal, 70  
 Lubrex 45, 426  
 Lubricating grease, 424  
 Lubricating oils, 426  
 Lubrico, 357  
 Luccu oil, 512  
 Lucero, 235  
 Luciferin, 430  
 Lucite, 8  
 Lucite HM-140, 8  
 Lucitone, 8  
 Ludensheid plate, 545  
 Ludlite board, 346  
 Ludlum steel No. 602, 635  
 Ludox, 636  
 Lufax 77A, 514  
 Lumarith, 156  
 Lumarith EC, 154  
 Lumbang oil, 738

Lumbayan, 397  
 Lumber, 781  
 Lumen alloy 11-C, 36  
 Lumen manganese bronze, 446  
 Lumiclad paint, 521  
 Luminous paint, 428  
 Luminous plastic, 430  
 Lumitol, 709  
 Lumnite cement, 159  
 Lumnitè screen cloth, 780  
 Lunar caustic, 649  
 Lupis fibers, 451  
 Lupolen, 276  
 Lupulin, 675  
 Lusterite steel, 685  
 Lustraglas, 321  
 Lustron, 572  
 Lustron PI, 572  
 Luteine, 484  
 Lutes, 430  
 Luvican, 759  
 Luxwood, 549  
 Luzonite, 59  
 Lycopodium, 700  
 Lyddite, 280  
 Lydian stone, 298  
 Lye, 661  
 Lyonore metal, 213  
 Lysol, 230

## M

M bronze, 201  
 M-M-M alloy, 486  
 M-ten, 151  
 Macanilla oil, 68  
 Mace, 503  
 McGill metal, 36  
 Machine steel, 134  
 Machinery steel, 134  
 Mach's metal, 32  
 Macht's metal, 477  
 Macite, 47  
 Mackenite metal, 349  
 Mackenzie's amalgam, 44  
 Mackintosh cloth, 187  
 Mack's cement, 344  
 Maco cotton, 224  
 Macoustic, 344  
 Macstone, 624  
 Madagascar copal, 205  
 Madar, 387  
 Madavitum, 592  
 Maddar, 431  
 Maddar lake, 431  
 Maddar red, 431  
 Madia seed oil, 703  
 Madras, 226  
 Madras hemp, 704  
 Mafura tallow, 755  
 Magnafux steel, 691

Magnalite, 33  
 Magnalium, 32  
 Magnefer, 599  
 Magnesia, 431  
 Magnesia alba levis, 437  
 Magnesia brick, 297  
 Magnesia cement, 160  
 Magnesia powder, 431  
 Magnesite, 431  
 Magnesium, 432  
 Magnesium alloy, 434  
 Magnesium alloy AM240, 435  
 Magnesium alloy AM403, 435  
 Magnesium alloy AM745, 435  
 Magnesium alloy AZ63, 436  
 Magnesium alloy EM51, 436  
 Magnesium carbonate, 436  
 Magnesium chloride, 159  
 Magnesium mica, 460  
 Magnesium-Monel, 437  
 Magnesium-nickel, 437  
 Magnesium oxide, 160  
 Magnesium peroxide, 519  
 Magnesium phosphate, 513  
 Magnesium powder, 437  
 Magnesium sulphate, 438  
 Magnesium-zinc alloys, 436  
 Magnet alloys, 438  
 Magnet steels, 438  
 Magnetic black, 288  
 Magnetic iron ore, 377  
 Magnetic iron powder, 376  
 Magnetic pyrites, 493  
 Magnetite, 377  
 Magnetostrictive alloys, 541  
 Magnium, 432  
 Magno, 602  
 Magno masse, 252  
 Magnolia isotropic bronze, 79  
 Magnolia metal, 778  
 Magnolia wood, 737  
 Maguey, 651  
 Mahoe, 766  
 Mahogany, 440  
 Mahogany birch, 92  
 Mahogany plywood, 568  
 Mahogany soap, 699  
 Mahuang, 258  
 Mahuba fat, 754  
 Mahubarana fat, 755  
 Maize, 219  
 Maize oil, 220  
 Maizolith, 764  
 Majagua, 766  
 Majolica, 270  
 Makalot, 549  
 Makore, 390  
 Malanang, 397

- Malabar tallow, 755  
 Malachite, 210  
 Malachite green, 168  
 Malcomized steel, 139  
 Maleic anhydride, 554  
 Malekized rice, 605  
 Malinite, 386  
 Malleable brass, 476  
 Malleable iron, 441  
 Malleable pig iron, 556  
 Mallory metal, 704  
 Mallory 100 metal, 704  
 Mallory 1000 metal, 351  
 Malmstone, 624  
 Malotte's metal, 309  
 Malt, 75  
 Malt sugar, 326  
 Maltophen, 12  
 Maltose, 326  
 Malva fiber, 385  
 Mamarron oil, 68  
 Man-Ten steel, 449  
 Manandonite, 407  
 Manbarklak, 334  
 Mandioca, 686  
 Mangaba, 611  
 Mangabeira rubber, 611  
 Manganal, 449  
 Manganblende, 447  
 Manganese, 443  
 Manganese acetate, 254  
 Manganese alloy, 444  
 Manganese-aluminum, 444  
 Manganese-aluminum brass, 446  
 Manganese-boron, 445  
 Manganese bronze, 445  
 Manganese casting brass, 446  
 Manganese copper, 445  
 Manganese green, 559  
 Manganese-molybdenum steel, 450  
 Manganese-nickel steel, 449  
 Manganese ores, 446  
 Manganese powder, 444  
 Manganese screw stock, 449  
 Manganese-silicon, 642  
 Manganese stearate, 458  
 Manganese steel, 448  
 Manganese sulphide, 447  
 Manganese tablets, 444  
 Manganese titanium, 291  
 Manganese-vanadium steel, 450  
 Manganese-zinc alloys, 790  
 Manganin, 602  
 Manganite, 364, 447  
 Mangano steel, 500  
 Manganotantalite, 713  
 Manganox, 301  
 Manggasinoro, 397  
 Mangona, 390  
 Mangrove, 450  
 Mangrove cutch, 451  
 Manguinite, 571  
 Manila copal, 205  
 Manila gold, 595  
 Manila hemp, 451  
 Manila paper, 525  
 Manioc, 686  
 Manjak, 318  
 Manketti oil, 261  
 Mannheim gold, 595  
 Mannitan drying oil, 148  
 Mannitol, 668  
 Mannoketoheptose, 512<sup>a</sup>  
 Mansil die steel, 500  
 Maple, 451  
 Maple flavor, 452  
 Maple sirup, 452  
 Maple sugar, 452  
 Marabout silk, 646  
 Maracaibo boxwood, 101  
 Maracaibo copiaba, 342  
 Maracaibo lignum vitae, 409  
 Marbelite, 453  
 Marble, 452  
 Marble chips, 453  
 Marble dust, 453  
 Marble ebony, 266  
 Marble flour, 453  
 Marblette, 548  
 Marblewood, 266  
 Marboloid, 750  
 Marcasite, 379  
 Marekanite, 583  
 Margaric acid, 689  
 Margarine, 117  
 Margarite, 460  
 Marijuana, 352  
 Marine glue, 327  
 Marine oakum, 507  
 Marine rope, 215  
 Marine varnish, 754  
 Maritime pine, 743  
 Market brass, 355  
 Marking inks, 368  
 Marlate, 371  
 Marls, 107  
 Marlstone, 631  
 Marmalade, 542  
 Marseilles soap, 657  
 Marsh cypress, 239  
 Marsh gas, 459  
 Martin elastic limit steel, 449  
 Martin steel, 770  
 Martinel steel, 449  
 Martin's cement, 160  
 Martonite, 571  
 Marvinol VR-10, 759  
 Masonex, 128  
 Masonite, 295  
 Masonite quarter board, 295  
 Masonoid, 128  
 Masonry cement, 159  
 Massicot, 415  
 Master alloy, 22  
 Mastic, 453  
 Masurium, 592  
 Masuron, 156  
 Matai, 562  
 Match wax, 530  
 Matesa, 594  
 Mathesius metal, 400  
 Matrix alloy, 279  
 Matura diamonds, 795  
 Mathitius hemp, 453  
 Max-El 1B steel, 135  
 Max-El No. 4 steel, 450  
 Maxilvry steel, 180  
 Maxite steel, 360  
 Maxtack steel, 742  
 Maxtensile, 487  
 Mayapis, 397  
 Mayari iron, 557  
 Mayari R steel, 421  
 Mazlo alloy AM265, 435  
 Mead, 85  
 Mealarub, 616  
 Mecca balsam, 538  
 Mechanical wood pulp, 525  
 Medellin coffee, 195  
 Medina quartzite, 588  
 Medium-carbon steels, 149, 690  
 Medium manganese steel, 448  
 Medlar gum, 475  
 Mechanite metal, 146  
 Meerschaut, 454  
 Megass, 70  
 Melamine, 454  
 Melamine resin, 545  
 Melanite, 280, 313  
 Melanterite, 292  
 Melegueta pepper, 535  
 Melitriose, 696  
 Melmac 404, 454  
 Melmac 483, 454  
 Melmac 592, 454  
 Melmac 1077, 454  
 Melurac 300, 454  
 Menachinite, 727  
 Menachite, 727  
 Mendozite, 25  
 Menhaden oil, 454  
 Menthol, 536  
 Meral, 33  
 Meranti, 397  
 Merawan, 397  
 Mercerized cotton, 455  
 Merchant bar iron, 785  
 Merclor D, 621

- Merco bronze, 110
- Mercoloy, 486
- Mercuric chloride, 456
- Mercuric naphthenate, 254
- Mercuric oxide, 456
- Mercuric selenide, 185
- Mercuric sulphide, 185
- Mercuric telluride, 185
- Mercurochrome, 456
- Mercury, 456
- Mercury fulminate, 306
- Mercury ores, 185
- Mercury-thallium amalgam, 44
- Mercus pine, 563
- Merino wool, 784
- Merrillite, 792
- Mertone WB-2, 637
- Mescal buttons, 257
- Mesothorium, 456
- Mesquite, 419
- Met-L-Wood, 569
- Meta cresol, 230
- Metal-Bord, 578
- Metal lath, 278
- Metal paints, 520
- Metal polishes, 113
- Metal polylactates, 464
- Metaline, 425
- Metalite, 38, 569
- Metalized wood, 458
- Metallic brown, 288
- Metallic pigments, 560
- Metallic red, 288
- Metallic soap, 457
- Metallized paper, 527
- Metalloid, 54
- Metallophos, 552
- Metamorphic rocks, 806
- Meteorite iron, 495
- Methacrylic acid, 8
- Methallyl alcohol, 24
- Methane, 459
- Methanoic acid, 303
- Methanol, 460
- Methenamine, 353
- Methocel, 155
- Methoxychlor, 371
- Methyl abietate, 608
- Methyl acetate, 229
- Methyl acetone, 7
- Methyl alcohol, 460
- Methyl benzene, 731
- Methyl bromide, 306
- Methyl carbitol, 277
- Methyl cellulose, 155
- Methyl chloride, 171
- Methyl chloro silane, 645
- Methyl cyclohexane, 731
- Methyl ether, 274
- Methyl furan, 307
- Methyl hexyl ketone, 666
- Methyl laurate, 284
- Methyl methacrylate, 8
- Methyl phenol, 229
- Methyl red, 168
- Methyl rubber, 616
- Methyl salicylate, 675
- Methylal, 274
- Methylamine, 46
- Methylated spirits, 275
- Methylcarbinol, 274
- Methylene oxide, 303
- Methylhydride, 459
- Methylol-melamine resin, 189
- Methylol pinene, 744
- Methylol-urea resin, 189
- Metronite, 559
- Mexacote, 332
- Mexican linaloe, 606
- Mexican onyx, 513
- Mexican soaproot, 626
- Mica, 460
- Mica clay, 386
- Mica flake, 463
- Mica-kote, 287
- Mica pellets, 757
- Mica powder, 462
- Micabond, 462
- Micalith G, 463
- Micanite, 461
- Micarta, 548
- Mico cocoa, 192
- Micro asbestos, 61
- Micro sheet, 730
- Microcrystalline wax, 530
- Microfine cocoa, 192
- Microline, 285
- Microlite, 714
- Micronized barite, 73
- Micronized clay, 386
- Micronized mica, 463
- Microporite, 203
- Midvaloy, 221
- Mikolite, 757
- Mild abrasives, 2
- Mild polish, 1
- Mild steel, 367
- Military explosives, 280
- Milk, 463
- Milk albumin, 16
- Milk bush, 232
- Milk powder, 464
- Milkstone, 140
- Milkweed, 231
- Milkweed floss, 388
- Milkwort, 259
- Millaloy, 491
- Milled soaps, 656
- Miller metal, 789
- Millerite, 494
- Millet, 465
- Millimar, 318
- Millstone, 465
- Milvan steel, 361
- Milwaloy, 175
- Mimico, 641
- Mimosa, 151
- Minargent, 233
- Mindanao lauan, 397
- Mindoro pine, 563
- Minelite, 678
- Mineral black, 559
- Mineral green, 559
- Mineral lard oil, 395
- Mineral lubricating grease, 424
- Mineral oils, 509
- Mineral rubber, 765
- Mineral salt, 620
- Mineral wax, 519, 769
- Mineral wool, 465
- Mineral wool board, 466
- Minette ore, 378
- Minium, 185
- Minofor, 545
- Mipolam, 761
- Mirac, 270
- Miraculoy, 491
- Miramesh, 156
- Miro, 562
- Misch metal, 163
- Misco 20, 489
- Misco alloys, 488
- Misco C, 488
- Misco metal, 488
- Miscoloy No. 60, 491
- Miscrome, 488
- Mispickel, 59
- Missouri tripoli, 736
- Mitchalloy A, 486
- Mix 812 steel, 183
- Mixed acid, 498
- Mixture, 803
- ML steel, 358
- Mo-Cut steel, 359
- Mo.S.H. steel, 358
- Mocasco 30, 487
- Mocasco iron, 487
- Mocaya butter, 756
- Mocha coffee, 195
- Mocha leather, 633
- Mock silver, 382
- Mockernut hickory, 354
- Modified aluminum alloys, 40
- Modified gunmetal, 341
- Noellon degreas, 241
- Mogul steel, 359
- Mohair, 467
- Mohair fabrics, 467
- Mohawk steel, 362
- Mohican steel, 359
- Molascuit, 71
- Molasses, 696

Mold steel, 467  
 Moldarta, 547  
 Molding graphite, 332  
 Molding plastics, 705  
 Molding sand, 468  
 Molecule, 803  
 Moleskin, 757  
 Moloie steel, 450  
 Molybdenite, 471  
 Molybdenum, 469  
 Molybdenum cast iron, 470  
 Molybdenum high-speed steel, 358  
 Molybdenum ores, 471  
 Molybdenum powder, 470  
 Molybdenum steel, 471  
 Molybdenum sulphide, 427  
 Molybdc oxide, 470  
 Molybdite, 471  
 Molykote, 427  
 Molyte, 123  
 Monarch metal, 357  
 Monax glass, 323  
 Monazite, 472  
 Mond metal, 473  
 Monel metal, 473  
 Mongolian wool, 784  
 Monkey grass, 554  
 Monkshood, 257  
 Mono-Block, 466  
 Monoamyl naphthalene, 481  
 Monochloro benzene, 171  
 Monochloroethane, 171  
 Monofil, 345, 505  
 Monohydroxy alcohol, 17  
 Monomer, 705  
 Monoplex DOA, 668  
 Monopole soaps, 243  
 Monopolin, 274  
 Monosaccharides, 128  
 Monosodium glutamate, 581  
 Monotype metal, 745  
 Monox, 637  
 Monoxychlor, 371  
 Montan wax, 519  
 Montana larch, 394  
 Montax, 437  
 Monterey cypress, 239  
 Montmorillonite, 161, 305  
 Montpelier yellow, 401  
 Moonstone, 285  
 Mordant, 474  
 Morenti, 397  
 Morganite, 88  
 Morillo bark, 625  
 Morin, 309  
 Morindone, 309  
 Morocco leather, 632  
 Morphine, 515  
 Mortar, 159  
 Mosaic gold, 559

Moss agate, 15  
 Moss opal, 15  
 Moss starch, 128  
 Mossbunker, 455  
 Mossy zinc, 788  
 Mother of pearl, 474  
 Motia grass, 406  
 Motor bronze, 778  
 Motor fuel, 313  
 Mottled graywear, 270  
 Motung steel, 359  
 Moulmein cedar, 734  
 Mount Airy granite, 330  
 Mountain ash, 64  
 Mountain hemlock, 353  
 Mountain larch, 394  
 Mountain leather, 61  
 Mouray's solder, 665  
 Mowilith, 760  
 Mowrah butter, 99  
 MSM steel, 635  
 Mu oil, 738  
 Mucilage, 475  
 Mullfrax, 476  
 Mullite, 475  
 Mulmul, 601  
 Multimold steel, 250  
 Mumetal, 540  
 Mungo fibers, 785  
 Muntz metal, 476  
 Murex, 301  
 Murga, 754  
 Muriatic acid, 363  
 Murlins, 14  
 Murumuru oil, 67  
 Muscovite, 460  
 Muscovy glass, 460  
 Mushet steel, 358  
 Music wire, 477  
 Musk, 537  
 Musk seed, 537  
 Muslin, 478  
 Mustard, 478  
 Mustard gas, 570  
 Mustard oil, 479  
 Mustard seed oil, 479  
 Mustone, 616  
 Mutton tallow, 710  
 MVC aluminum alloy, 40  
 Mwang, 577  
 Mycalex, 461  
 Mykroy No. 51, 461  
 Mykroy sheet, 461  
 Myrbane oil, 87  
 Myrcene, 744  
 Myrcia oil, 539  
 Myrcil palmitate, 84  
 Myristica oil, 504  
 Myristicin, 504  
 Myrobalan extract, 479  
 Myrobalans, 497

Myrrh, 600  
 Myrtan, 340  
 Myrtle wax, 755

## N

N-A-X high-tensile steel, 421  
 N-A-X 9100 steels, 421  
 N-A-X 9112 steel, 421  
 Nacre, 474  
 Nacrite, 385  
 Naouli oil, 120  
 Napalm, 315  
 Naphtha, 479  
 Naphthalene, 480  
 Naphthalene sulphonic acid, 547  
 Naphtenate driers, 254  
 Naphtholite, 480  
 Naphthyl thiourea, 682  
 Napped leather, 695  
 Narwhal, 773  
 Natalite, 38  
 Natalon, 641  
 National emergency steel, 420  
 Native copper, 211  
 Native gold, 329  
 Natrundum, 641  
 Natumite, 38  
 Natural cement, 159  
 Natural gas, 459  
 Natural iron, 377  
 Nauli gum, 267  
 Naval brass, 104, 476  
 Naval bronze, 476  
 Naval stores, 607, 743  
 Navalium, 32  
 Navy alloy No. 2, 41  
 Navy bronze, 46B22, 485  
 Navy pitch, 715  
 Navy tombasil, 639  
 Navy wool, 323  
 NBS resin, 572  
 NE steel 8630, 422  
 NE steel 8715, 422  
 Neat plaster, 344  
 Neat soap, 425  
 Neatsfoot oil, 481  
 Necktie cloth, 467  
 Needle tubing, 255  
 Needle wire, 255  
 Nekal, 773  
 Nekoe, 242  
 Neodymium, 164  
 Neolube, 428  
 Neolyn resins, 20  
 Neon, 481  
 Neonium, 33  
 Neophane glass, 322

- Neophrax, 765
- Neoprene, 614
- Neoprene cements, 12
- Neoprene latex, 396
- Neoprene type RT, 614
- Neosol, 275
- Nepheline, 550
- Nepheline syanite, 550
- Nephrite, 60
- Neptunium, 748
- Neradol D, 711
- Neroli oil, 542
- Neroli Portugal, 542
- Nesa glass, 322
- Netto bean, 419
- Neutral lard, 395
- Neutral oils, 426
- Neutron, 803
- Nevasota, 229
- Nevilloid C-55, 232
- Nevindene, 232
- New Caledonia pine, 562
- New Zealand beech, 83
- New Zealand flax, 215
- New Zealand gum, 388
- New Zealand hemp, 215
- Newaloy, 213
- Newloy, 495
- Newtonite, 386
- Newton's alloy, 308
- Newton's metal, 308
- N'gart oil, 261
- Ni-Chillite, 487
- Ni-Hard, 178
- Ni-Stainless steel, 685
- Ni-Tensyl iron, 486
- Niacin, 762
- Niagathal, 554
- Niangon, 390
- Niaproof, 768
- Nibcoloy, 21
- Nicolite, 494
- Nichroloy, 349
- Nichrome, 348
- Nichrome S, 602
- Nichrome V, 602
- Nickel, 482
- Nickel alloys, 483
- Nickel-aluminum, 484
- Nickel ammonium sulphate, 497
- Nickel anodes, 51
- Nickel babbitt, 70
- Nickel brass, 484
- Nickel bronze, 485
- Nickel carbonate, 497
- Nickel carbonyl, 497
- Nickel cast iron, 486
- Nickel chloride, 497
- Nickel-chromium alloys, 487
- Nickel-chromium cast iron, 487
- Nickel-chromium steel, 490
- Nickel-clad steel, 264
- Nickel-cobalt alloys, 491
- Nickel copper, 492
- Nickel-copper shot, 492
- Nickel-manganese steel, 450
- Nickel-molybdenum iron, 492
- Nickel-molybdenum steel, 493
- Nickel ores, 493
- Nickel shot, 483
- Nickel-silicon brass, 484
- Nickel silver, 494
- Nickel silver 828, 772
- Nickel stearate, 458
- Nickel steel, 495
- Nickel sulphate, 496
- Nickel sulphide, 494
- Nickel-tantalum alloy, 497
- Nickel titanium, 292
- Nickel-vanadium steel, 496
- Nickel welding rod, 772
- Nickel-zirconium, 795
- Nickeladium, 752
- Nickelene, 485
- Nickeline, 485
- Nickeloid, 263
- Nickeloy, 33
- Nielad, 264
- Nicloy, 496
- Nicol prisms, 121
- Nicotinic acid, 762
- Nicou, 242
- Nicouline, 242
- Nicroman steel, 183
- Nicrosilal, 486
- Nielite D, 553
- Nifarine, 404
- Nifos-T, 371
- Niger seed, 126
- Nigerian pearwood, 625
- Niggerhead ores, 378
- Nigrite, 66
- Nikkel oil, 186
- Nikro-Trimmer steel, 490
- Nikrofer, 557
- Nikrome, 491
- Nilvar, 423
- Nimonic 75, 348
- Nimonic 80, 348
- Niobium, 198
- Niresist, 487
- Nirex, 488
- Nisiloy, 22
- Niter, 576
- Niter cake, 701
- Nitrallloy, 41
- Nitrard, 42
- Nitrated kerosene, 389
- Nitrating acid, 498
- Nitrex, 614
- Nitric acid, 497
- Nitricastiron, 145
- Nitrided cast iron, 145
- Nitriding steel, 41
- Nitrile rubber, 615
- Nitrobarite, 74
- Nitrobenzene, 87
- Nitrocellulose, 498
- Nitrochloroform, 570
- Nitroethane, 668
- Nitrogen, 498
- Nitrogen pentoxide, 498
- Nitrogen tetroxide, 498
- Nitrogen trichloride, 47
- Nitrogenated oils, 271
- Nitroglycerin, 499
- Nitromethane, 668
- Nitron, 158, 660
- Nitroparaffins, 667
- Nitrophoska, 294
- Nitrostarch, 688
- Nitrotrichloromethane, 570
- Nivar, 422
- Nivarox, 423
- Nixonite, 156
- Nixonoid, 158
- No-D-K, 229
- Noble metals, 577
- Nodular cast iron, 144
- Nodulizing alloy, 144
- Nogroth metal, 487
- Noheat metal, 400
- Nolex, 373
- Noli palm, 524
- Nolu, 82
- Nomag, 145
- Noncorrodite, 222
- Nondeforming steel, 500
- Nonionic agents, 243
- Nonmagnetic steel, 502
- Nonpareil insulating brick, 391
- Nonshattering glass, 502
- Nonshrinking steel, 500
- Nonslip concrete, 203
- Nopol, 744
- Norbide, 101
- Norconidendrin, 56
- Nordihydroguaiaretic acid, 601
- Nordhauser acid, 701
- Norelite glue, 12
- Norepol rubber, 616
- Norit, 10
- Normal amyl alcohol, 48
- Normal butyl alcohol, 118
- Norskalloy, 557
- North Carolina pine, 560



- Northern pine, 562  
 Northern white cedar, 725  
 Northern white pine, 560  
 Norway iron, 786  
 Norway pine, 562  
 Norway saltpeter, 662  
 Norway spruce, 680  
 Norwegian herring, 353  
 Notol No. 1, 731  
 Noumeite, 493  
 Novac, 630  
 Novaculite, 510  
 Novite, 486  
 Novoid corkboard, 218  
 Novopan, 295  
 Nu-Film, 687  
 Nuban, 396  
 Nuchar, 10  
 Nucin, 767  
 Neuvite, 164  
 Nun-Lint cloth, 227  
 Nuremberg gold, 382  
 Nuroz resin, 609  
 Nurse shark, 632  
 Nutall oak, 505  
 Nutgalls, 310  
 Nutmeg, 503  
 Nutmeg butter, 503  
 Nutmeg hickory, 354  
 Nutmeg oil, 504  
 Nux vomica, 504  
 Nykrom, 491  
 Nylatron G, 505  
 Nylon, 504  
 Nylon bearings, 80  
 Nylon fibers, 504  
 Nylon flannel, 504  
 Nylon rope, 216  
 Nyprene, 706  
 Nytron, 243
- O**
- O-Hi-O steel, 183  
 Oak, 505  
 Oak extract, 507  
 Oak moss, 539  
 Oakum, 507  
 Out hulls, 507  
 Oatmeal, 507  
 Oatmeal paper, 525  
 Oats, 507  
 Obsecuring agents, 570  
 Obsidian, 583  
 Ochre, 508  
 Ocote, 561  
 Ocotea oil, 674  
 Octa-Klor, 371  
 Octane, 313  
 Octanium, 423  
 Octoic driers, 254  
 Octyl alcohol, 666  
 Ocuba red, 755  
 Ocuba wax, 755  
 Odontolite, 381  
 Oerstit 400, 439  
 Offal, 83, 775  
 Oganwo, 390  
 Ogeche tupelo, 338  
 Ogo gum, 601  
 Ohio buckeye, 169  
 Ohioloy, 491  
 Oil ammoniac, 48  
 Oil asphalt, 67  
 Oil gas, 459  
 Oil of amber, 609  
 Oil of bitter almonds, 24  
 Oil of coriander, 673  
 Oil of sage, 674  
 Oil of turpentine, 743  
 Oil of vitriol, 701  
 Oil of white birch, 93  
 Oil shale, 631  
 Oilcloth, 509  
 Oildag, 428  
 Oiled silk, 509  
 Oiliness agents, 427  
 Oilite, 333  
 Oils, 509  
 Oilskin, 509  
 Oilstone, 510  
 Oiticica oil, 511  
 O.K. steel, 742  
 Okon, 197  
 Okume wood, 390  
 Olcotrop leather, 632  
 Oldfield pine, 561  
 Olefiant gas, 275  
 Olefins, 314  
 Oleic acid, 511  
 Oleo oil, 689  
 Oleo vermelho, 441  
 Oleomargarine, 117  
 Oleoresin varnish, 653  
 Oleoresins, 600  
 Oleostearin, 689  
 Oleum, 655  
 Olevene, 512  
 Olho wax, 136  
 Olibanum, 538  
 Olive-infused oil, 512  
 Olive oil, 512  
 Olive oil foots, 512  
 Olive wood, 542  
 Olivine, 513  
 Olivine sand, 513  
 Olono fiber, 215  
 Olympic bronze, 639  
 Olympic bronze G, 640  
 Omega steel, 635  
 Omu, 625  
 Onachita stones, 511  
 Onegite, 587  
 Onionskin paper, 526  
 Ontario steel, 502  
 Onyx, 513  
 Onyx marble, 513  
 Oolong tea, 716  
 Opacifiers, 514  
 Opacite, 654  
 Opal glass, 322  
 Opalescent glass, 322  
 Opaline silica, 247  
 Opalite, 736  
 Opalized wood, 514  
 Opalon, 547  
 Opalwax, 769  
 Opaque varnish, 754  
 Opax, 514  
 Open-hearth steel, 515  
 Ophorite, 437  
 Opium, 515  
 Opoil, 709  
 Oppanox, 538  
 Oppanol, 615  
 Oppanol C, 759  
 Optical fluorspar, 300  
 Optical glass, 516  
 Orange mineral, 596  
 Orange oil, 542  
 Orange pekoe tea, 716  
 Orange pigments, 559  
 Orange shellac, 634  
 Oranette, 19  
 Orchil, 418  
 Orchilla, 265  
 Ordinance bronze, 356  
 Ore, 516  
 Oregano, 673  
 Oregon ash, 64  
 Oregon cedar, 153  
 Oregon maple, 451  
 Oregon pine, 252  
 Oregon white pine, 561  
 Oreide brouze, 202  
 Orelite, 38  
 Organdy, 226  
 Organic catalysts, 150  
 Organic glass, 319  
 Organic plastics, 644  
 Organizine silk, 646  
 Organosilicon polymers, 645  
 Oriental linaloe, 606  
 Oriental topaz, 223  
 Orlon, 9  
 Ormulu gold, 595  
 Oronite detergent, 244  
 Oropon, 76  
 Orpiment, 59  
 Orris, 539  
 Ortho cresol, 230  
 Orthoboric acid, 99  
 Orthoclase, 285  
 Ortholeum, 300, 425  
 Orthonel, 541

Orthophosphoric acid, 552  
 Osage orange, 309  
 Osmi-iridium, 374  
 Osmiridium, 517  
 Osmium, 517  
 Osmo, 386  
 Osmose kaolin, 386  
 Osnaburg cloth, 517  
 Ossine, 316  
 Ostrich eggs, 285  
 Ostrich feathers, 285  
 Ostrich leather, 403  
 Otiscology, 422  
 Ottar of rose, 538  
 Otto of boronia, 538  
 Ounce metal, 200  
 Ouricury wax, 137  
 Overcup oak, 506  
 Oxalic acid, 517  
 Oxamide, 518  
 Oxidation inhibitors, 56  
 Oxyacetylene, 7  
 Oxychloride cement, 159  
 Oxygen, 518  
 Oxygen-free copper, 207  
 Oxygenated oils, 271  
 Oxygenized iron, 146  
 Oyster shells, 121  
 Ozite, 287  
 Ozokerite, 519  
 Ozone, 518

## P

Pacific dogwood, 252  
 Pacific red cedar, 724  
 Packaged fuel, 304  
 Packer bones, 97  
 Packfong, 494  
 Packinghouse hides, 355  
 Paco-paco, 384  
 Padang cassia, 186  
 Paddy, 604  
 Padouk, 392  
 Paina kapok, 387  
 Paint, 520  
 Paint oils, 260  
 Paint removers, 522  
 Palau, 578  
 Palay rubber, 231  
 Palco wool, 597  
 Palestic, 343  
 Palha wax, 136  
 Paligorskite, 62  
 Palium Z, 80  
 Palladium, 522  
 Palladium leaf, 523  
 Palladium powder, 523  
 Palladium-silver alloys, 523  
 Palladium sponge, 523  
 Pollet stones, 367  
 Palm kernel oil, 523

Palm oil, 523  
 Palm pitch, 689  
 Palm sugar, 697  
 Palm wine, 619  
 Palma, 787  
 Palma istle, 787  
 Palma pita, 787  
 Palma samandoca, 787  
 Palmrosa oil, 406  
 Palmetex, 218  
 Palmetto fiber, 112  
 Palmilla fiber, 787  
 Palmitic acid, 523  
 Palmyra, 555  
 Palo santo, 409  
 Panama rubber, 611  
 Panchrome, 711  
 Pandermite, 98  
 Paneling board, 568  
 Pantal, 30  
 Panther steel, 359  
 Pao rosa, 605  
 Pao santo bark, 217  
 Papain, 524  
 Papaya, 524  
 Papelon, 697  
 Paper, 524  
 Paper birch, 93  
 Paper mulberry, 528  
 Paper plants, 528  
 Paper pulp, 528  
 Paperoid, 532  
 Papier mâché, 529  
 Papite, 719  
 Paprika, 535  
 Papyrus, 524  
 Par-Exc steel, 363  
 Para chestnut, 105  
 Para copiba, 342  
 Para cresol, 230  
 Para glass, 554  
 Para rubber, 610  
 Paracumerone, 232  
 Parade twill, 227  
 Paradise wood, 606  
 Paraffin, 529  
 Paraffin oil, 530  
 Paraffin wax, 530  
 Paraform, 303  
 Paraformaldehyde, 303  
 Paragon steel, 501  
 Paraguayan cedar, 152  
 Paraguayan lignum vitae, 409  
 Paraguayan palm, 756  
 Paraguayan tea, 717  
 Paralan, 426  
 Paraldehyde, 5  
 Paraldol, 18  
 Parana pine, 562  
 Paranol, 550  
 Paraplex P-43HV, 20

Paraplex resins, 20  
 Paratex, 172  
 Parchment, 531  
 Parian cement, 160  
 Paris metal, 484  
 Paris white, 165  
 Parkerized steel, 556  
 Parkesine, 157  
 Parkwood, 568  
 Parlon, 172  
 Parock, 82  
 Parr metal, 483  
 Parrot coal, 127  
 Parsons' alloy, 446  
 Parsons' white brass, 70  
 Parting sand, 469  
 Partinium, 30  
 Partridge wood, 266  
 Paste diamonds, 321  
 Pasteboard, 531  
 Pastes, 11  
 Pasteurized milk, 464  
 Patapar, 531  
 Patchouli oil, 537  
 Patent alum, 25  
 Patina, 209  
 Patna rice, 605  
 Patronite, 138  
 Pattern metal, 790  
 Pattern woods, 532  
 Paving brick, 107  
 Paving sand, 114  
 Pawpaw, 524  
 Payta, 592  
 PDCP copper, 207  
 Peacock ore, 210  
 Peanut butter, 533  
 Peanut fiber, 581  
 Peanut oil, 532  
 Pearl ash, 573  
 Pearl barley, 75  
 Pearl essence, 560  
 Pearl filler, 343  
 Pearl moss, 14  
 Pearl sago, 619  
 Pearl sharkskin, 632  
 Pearl spar, 252  
 Pearl stearic acid, 688  
 Pearl tapioca, 686  
 Pearl white, 94  
 Pearlite, 143  
 Pearlitic malleable iron, 442  
 Pearlitic manganese steel, 448  
 Peat, 533  
 Peat moss, 533  
 Peat wax, 533  
 Pebbles, 335  
 Pecan, 354  
 Pectin, 129  
 Peening shot, 379

- Peerless A steel, 362  
 Peerless high-speed steel, 359  
 Peerless steel, 363  
 Pegmatite, 331  
 Pele's hair, 466  
 Pellet powder, 341  
 Pelletex, 133  
 Pellets blasting shot, 379  
 Pencal, 371  
 Penchlor, 663  
 Pencil cedar, 383  
 Pencolite G-1215, 603  
 Pennsalt FA-42, 556  
 Pennyroyal oil, 536  
 Pentachlorophenol, 372  
 Pentaerythritol, 534  
 Pentaglucoase, 129  
 Pentalyne 802A, 534  
 Pentalyne M, 608  
 Pentalyne resin, 534, 608  
 Pentamull, 534  
 Pentane, 543  
 Pentanol, 48  
 Pentawax 177, 534  
 Pentawax 286, 769  
 Pentex, 534  
 Pentolite, 281  
 Pentosans, 128  
 Pentose, 129  
 Pepper, 534  
 Pepper oil, 535  
 Peppermint, 535  
 Pepperoyal, 535  
 Peracetic acid, 6  
 Perborin, 658  
 Perbunan, 616  
 Percal, 226  
 Perchloron, 170  
 Perduren, 616  
 Perdurum, 740  
 Perforated metals, 279  
 Perfume oils, 536  
 Periclase, 431  
 Peridot, 513  
 Perilla oil, 540  
 Perilalex, 583  
 Perlit, 146  
 Perlite, 583  
 Perm-A-Clor, 735  
 Permabrasiv, 380  
 Permaclad, 200  
 Permafay, 540  
 Permalloy, 540  
 Permanent white, 73  
 Permanol, 711  
 Permax, 541  
 Permeability alloys, 540  
 Permenorm, 541  
 Perminvar, 540  
 Permissible explosives, 280  
 Permite, 34  
 Permite paint, 521  
 Peroxides, 519  
 Persian Gulf oxide, 288  
 Persian lambskin, 388  
 Persian powder, 584  
 Persian red, 288  
 Persimmon wood, 542  
 Perspex, 9  
 Perstoff, 550  
 Peru balsam, 731  
 Peruvian bark, 183  
 Peruvian cotton, 224  
 Petalite, 407  
 Pettitgrain, 542  
 Petrex resin, 20  
 Petrofac, 395  
 Petrohol, 275  
 Petrol, 313  
 Petrolatum, 543  
 Petroleum, 543  
 Petroleum asphalt, 67  
 Petroleum coke, 197  
 Petroleum ether, 479  
 Petroleum pitch, 67  
 Petroleum spirits, 479  
 Petrolite wax, 530  
 Petronate, 699  
 Pewter, 544  
 Peyote, 257  
 Peyotina hydrochloride, 257  
 Phellandrene, 267, 340  
 Phenac 703, 603  
 Phenol, 545  
 Phenol-formaldehyde resin, 546  
 Phenol-furfural resin, 549  
 Phenol-hexamine resin, 549  
 Phenol resins, 549  
 Phenolaldehyde, 705  
 Phenolite, 548  
 Phenolphthalein, 168  
 Phenrock, 548  
 Phenyl aminopropane, 87  
 Phenyl carbinol, 87  
 Phenyl isocyanate, 571  
 Phenylamine, 49  
 Phenylformic acid, 695  
 Philippine lignum vitae, 409  
 Philippine mahogany, 396  
 Philprene, 614  
 Phlogopite, 460  
 Phono bronze, 638  
 Phono electric alloys, 638  
 Phonolite, 550  
 Phos-copper, 106  
 Phosflake, 662  
 Phosgene, 550  
 Phosols, 699  
 Phosphate cleaner, 736  
 Phosphate glass, 320  
 Phosphate of lime, 122  
 Phosphate rock, 553  
 Phosphatic bauxite, 78  
 Phosphor bronze, 551  
 Phosphor casting bronze, 551  
 Phosphor copper, 552  
 Phosphor lignum, 82  
 Phosphor tin, 552  
 Phosphor zinc, 552  
 Phosphorated oils, 699  
 Phosphorescent paints, 428  
 Phosphoric acid, 552  
 Phosphoric oxide, 554  
 Phosphorized copper, 207  
 Phosphorogens, 429  
 Phosphors, 429  
 Phosphorus, 553  
 Phosphorus sulphide, 554  
 Photographic gelatin, 316  
 Photon, 803  
 Photosensitive glass, 322  
 Phthalic anhydride, 554  
 Phulwa butter, 99  
 Phunki lac, 633  
 Phyllite rock, 776  
 Phytohormone, 762  
 Piano wire, 478  
 Piassava, 554  
 Piccolyte resin, 744  
 Piccoumaron resins, 233  
 Pickling acids, 555  
 Picric acid, 280  
 Piezoelectric crystals, 586  
 Pig iron, 556  
 Pig tin, 725  
 Pigment, 558  
 Pigment E, 579  
 Pignut hickory, 354  
 Pigskin, 354  
 Pilancillo, 697  
 Pilchard, 353  
 Pimento, 672  
 Pimento oil, 673  
 Pin bar, 256  
 Pin metal, 356  
 Pinay tallow, 755  
 Pinchbeck metal, 595  
 Pine, 560  
 Pine needle oil, 564  
 Pine oil, 563  
 Pine pitch, 715  
 Pine root oil, 563  
 Pine tar, 715  
 Pinenes, 271  
 Pinite, 598  
 Pink coral, 214  
 Pink pine, 563  
 Pink salmon, 619  
 Pinolin, 609

- Pinosylvine, 251
- Pintsch gas, 459
- Piperitone, 240
- Pita fiber, 385
- Pitch, 65
- Pitch coal, 408
- Pitch oil, 229
- Pitch-On metal, 714
- Pitch pine, 562
- Pitchblende, 746
- Piteira, 453
- Pittsides, 251
- Plane wood, 564
- Plant species, 811
- Plantation gambier, 312
- Plaskon, 750
- Plaskon Alkyd, 20
- Plaspreg, 344
- Plastacelle, 156
- Plastag, 706
- Plastalloy, 468
- Plastavon fabric, 188
- Plaster, 344
- Plaster board, 344
- Plaster of paris, 343
- Plasti-Cell, 678
- Plastic bearings, 80
- Plastic bronze, 78, 564
- Plastic-coated wire mesh, 780
- Plastic film, 707
- Plastic wood, 564
- Plasticizer, 668
- Plastics, 704
- Plastiron, 367
- Plate glass, 565
- Plate-Loy, 720
- Platers' brass, 51
- Platina, 776
- Platinite, 423
- Platino, 577
- Platinoid, 382
- Platinum, 565
- Platinum arsenide, 566
- Platinum-iridium alloys, 566
- Platinum-ruthenium alloy, 204
- Platinum wire, 781
- Plessy's green, 560
- Plexene M, 8
- Plexiglas, 8
- Plexiglas V, 8
- Plexiglas VM, 8
- Plio-Tuf, 550
- Pliofilm, 172
- Pliolite, 172
- Pliolite S-1, 172
- Pliolite S-3, 614
- Pliolite latex 190, 614
- Pliosheen, 187
- Pliovac, 760
- Pliwax, 172
- Plumbago, 331
- Plumbers' solder, 664
- Plumrite 85, 594
- Pluramelt, 200
- Plush, 566
- Plutonium, 748
- Plyform, 568
- Plymax, 568
- Plymetl, 569
- Plypanel, 568
- Plyscord, 568
- Plywall, 567
- Plywood, 566
- P.M.G. metal, 639
- Pochote fiber, 387
- Poi, 577
- Poison gases, 569
- Polar ice, 799
- Polarized glass, 323
- Polishing crocus, 610
- Polishing powder, 1
- Pollard oak, 506
- Pollucite, 164
- Polonium, 571
- Polonium-plated metal, 571
- Polvin, 759
- Poly-Pale resin, 609
- Polyco 296 resin, 9
- Polyethylene plastics, 276
- Polyhydric alcohol, 17
- Polyhydroxy alcohol, 17
- Polyisoprene, 613
- Polylactylic plastics, 464
- Polymer, 705
- Polymerization plastics, 705
- Polysaccharides, 128
- Polystyrene, 571
- Polythene, 276
- Polyurethane plastics, 749
- Polyvinyl acetal, 759
- Polyvinyl acetate resin, 760
- Polyvinyl alcohol, 758
- Polyvinyl butyral, 759
- Polyvinyl carbazole, 759
- Polyvinyl chloride, 759
- Polyvinyl chloride film, 707
- Polyvinyl formal, 759
- Pomoloy, 145
- Pompton tool steel, 733
- Pond cypress, 239
- Pond pine, 562
- Ponderosa pine, 561
- Pongee, 647
- Ponolith, 418
- Pontan, 188
- Pontianak, 573
- Pontianak copal, 573
- Pontianak illipe, 99
- Poonac, 194
- Popcorn, 219
- Pope's Island white metal, 495
- Poplar, 573
- Poplin, 226
- Poppy seed oil, 516
- Por-Os-Way, 3
- Porcelain, 385
- Porcelain enamel, 269
- Porcelain grinding balls, 335
- Porcelava, 398
- Porex, 692
- Porgy oil, 455
- Porcel, 78
- Porous carbon, 131
- Porous graphite, 131
- Porpoise oil, 95
- Port Lopez mahogany, 390
- Port Orford cedar, 153
- Portland cement, 158
- Portland stone, 412
- Positex, 404
- Post oak, 505
- Postonal, 193
- Potash, 573
- Potash alum, 25
- Potash feldspar, 285
- Potash mica, 460
- Potash silicate, 460
- Potash spar, 286
- Potassium, 574
- Potassium acetate, 558
- Potassium acid tartrate, 57
- Potassium amalgam, 44
- Potassium carbonate, 573
- Potassium chlorate, 574
- Potassium chlorate cheddite, 678
- Potassium chloride, 575
- Potassium columbate, 199
- Potassium cyanate, 575
- Potassium cyanide, 575
- Potassium disphosphate, 574
- Potassium ferricyanide, 575
- Potassium ferrocyanide, 575
- Potassium hydride, 574
- Potassium hydroxide, 662
- Potassium naphthenate, 354
- Potassium nitrate, 567
- Potassium nitrite, 576
- Potassium oxymuriate, 574
- Potassium perrenate, 603
- Potassium persulphate, 150
- Potassium silicate, 663
- Potassium silver cyanide, 575

- Potassium sodium tartrate, 58  
 Potassium sulphate, 25  
 Potato, 576  
 Potato starch, 686  
 Potomac M steel, 362  
 Potomac steel, 182  
 Potted meats, 83  
 Potters' flint, 298  
 Potters' sand, 325  
 Pottery enamel, 269  
 Pouchong tea, 716  
 Pounce, 582, 622  
 Pouncing paper, 582  
 Powder metallurgy, 692  
 Powdered coal, 187  
 Powdered glass, 323  
 Powdered soaps, 656  
 Powderiron, 82  
 Powellite, 627  
 Pozzuolana cement, 160  
 Prairie bones, 97  
 Praseodymium, 164  
 Prealloyed steel powder, 692  
 Precious metals, 577  
 Prefinished metals, 578  
 Pregwood, 567  
 Premier jus, 709  
 Prenite, 63  
 Presdwood, 295  
 Preservatives, 578  
 Preserved ginger, 318  
 Prespine, 296  
 Press cloth, 346  
 Press E-Z steel, 135  
 Pressal, 12  
 Pressed brick, 107  
 Prestite, 162  
 Prestolite, 7  
 Prestone, 53  
 Priceite, 98  
 Primer, 579  
 Primer brass, 138  
 Prince Albert fir, 352  
 Prince's metal, 356  
 Printing inks, 368  
 Printing paper, 525  
 Prodag, 333  
 Promal, 442  
 Promethee, 678  
 Promethium, 592  
 Propane, 543  
 Propenol, 23  
 Proplatinum, 382  
 Propylene aldehyde, 230  
 Propylene laurate, 269  
 Proso millet, 465  
 Protectatin, 726  
 Protectite, 765  
 Protectoid, 156  
 Protein plastics, 581  
 Proteins, 580  
 Protek-Coat, 66  
 Protekwood, 568  
 Proton, 803  
 Proustite, 584  
 Prussian blue, 292  
 Prussiate of potash, 575  
 Prussiate of soda, 661  
 Prussic acid, 363  
 Prystal, 548  
 Ptychotis oil, 16  
 Puddling iron, 557  
 Puerh tea, 717  
 Puget Sound pine, 252  
 Pulpboard, 532  
 Pulpstones, 582  
 Pulque, 652  
 Pulverized silica, 636  
 Pumice, 582  
 Pumicite, 582  
 Pumpkin ash, 64  
 Purahon 5, 82  
 Purite, 660  
 Purocell, 153  
 Puroon, 375  
 Purple of cassius, 322  
 Purpleheart, 583  
 Purpurin, 431  
 Putty, 583  
 Putty powder, 584  
 Putz cream, 113  
 Pyralin, 158  
 Pyrargyrite, 584  
 Pyrasteel, 349  
 Pyrax, 585  
 Pyrene, 136  
 Pyrenone Aerosol, 371  
 Pyrenones, 471  
 Pyrethrin, 584  
 Pyrethronic acid, 584  
 Pyrethrum, 584  
 Pyrex, 320  
 Pyriodoxine, 762  
 Pyro, 53  
 Pyrobar, 99  
 Pyrobitumens, 65  
 Pyrocast, 487  
 Pyrocellulose, 493  
 Pyrogallol, 710  
 Pyrogen, 544  
 Pyrogenous asphalts, 65  
 Pyrolusite, 446  
 Pyromucic aldehyde, 307  
 Pyronite, 281  
 Pyrope, 312  
 Pyrophoric alloys, 585  
 Pyrophyllite, 585  
 Pyrosulphuric acid, 655  
 Pyrotechnics, 75  
 Pyroxylin, 157  
 Pyroxylin cement, 11  
 Pyrrholite, 493  
 Pyrrole, 50  
 Pyruvic acid, 762  
 Python skins, 655  
 Python steel, 752
- ## Q
- Q-Alloy, 348  
 Quadrafos, 737  
 Quality steel, 491  
 Quartz, 585  
 Quartz bearings, 367  
 Quartz crystals, 586  
 Quartz glass, 321  
 Quartz pebbles, 335  
 Quartzite, 588  
 Quartzite pebbles, 335  
 Quassia, 588  
 Quebracho, 589  
 Quebracho extract, 589  
 Queen wood, 235  
 Queen's metal, 545  
 Quenching oils, 204  
 Quercitron extract, 507  
 Quick-drying enamels, 271  
 Quick malleable iron, 442  
 Quicklime, 410  
 Quicksilver, 456  
 Quillaja, 625  
 Quinacrine hydrochloride, 184  
 Quinidine, 184  
 Quinine, 184  
 Quinine hydrochloride, 184  
 Quinine sulphate, 184  
 Quinoline, 715  
 Quinterra, 63
- ## R
- R Monel, 474  
 R-R 50 alloy, 33  
 R-R 53 alloy, 33  
 Rabbit fur, 346  
 Rabbit hair, 346  
 Rack-a-rock, 678  
 Racalloy, 772  
 Radianite steel, 684  
 Radioactive metals, 589  
 Radioactive paints, 428  
 Radium, 590  
 Radium-beryllium powder, 591  
 Rafaelite, 66  
 Raffinose, 696  
 Rail steel, 135  
 Railroad thermit, 723  
 Rainbow granite, 330  
 Rainwear, 187  
 Ramet, 713

- Ramie, 591
- Ramix, 432
- Randalite, 568
- Randanite, 391
- Range gum, 388
- Range oil, 389
- Rantil, 127
- Rape oil, 591
- Raphia, 112
- Rare earth metals, 163
- Rare metals, 592
- Rasorite, 98
- Ratany, 592
- Rathane 1080, 682
- Rattan, 593
- Rauli, 82
- Raw sienna, 508
- Rawhide, 355
- Raybestos, 102
- Raynile, 504
- Rayon, 593
- Rayon alpaca, 25
- Rayon cordage, 216
- Rays, 803
- Razor steel, 733
- R.D.S. steel, 490
- RDX, 282
- Realgar, 59
- Reconstructed coal, 187
- Red acaroid, 4
- Red alder, 17
- Red antimony, 55
- Red arsenic glass, 59
- Red ash, 64
- Red balsa, 72
- Red beech, 82
- Red brags, 594
- Red brass ingot, 105
- Red cake, 751
- Red casting brass, 215
- Red cedar, 383
- Red charcoal, 166
- Red copper ore, 210
- Red copper oxide, 211
- Red coral, 214
- Red Cut Cobalt steel, 360
- Red cypress, 239
- Red elm, 268
- Red fir, 252
- Red gum, 4, 338
- Red iron oxide, 288
- Red juniper, 383
- Red khaya, 390
- Red lauan, 396
- Red lead, 596
- Red locust, 418
- Red mahogany, 390
- Red mangrove, 450
- Red maple, 451
- Red mercury sulphide, 758
- Red oak, 505
- Red oil, 511
- Red orpiment, 59
- Red pepper, 535
- Red phosphorus, 554
- Red pine, 563
- Red rubber, 612
- Red salmon, 619
- Red sandalwood, 392
- Red silk cotton, 387
- Red spruce, 680
- Red squill, 681
- Red stained glass, 322
- Red Star steel, 752
- Red thermit, 723
- Redalloy, 595
- Redmanol, 546
- Redsol crystals, 575
- Reduced iron, 376
- Redunca wood, 340
- Redurit, 38
- Redwood, 596
- Redwood bark fiber, 597
- Redwood tannin, 597
- Reevon, 276
- Refined sugar, 696
- Refined sulphur, 700
- Reflective insulators, 346
- Refractories, 597
- Refractory cement, 599
- Refractory clay, 297
- Refrasil, 467
- Refrax, 598
- Refrigerants, 600
- Refrigeration oils, 427
- Regal python skin, 655
- Regenerated cellulose, 153
- Regulus metal, 53
- Regulus of Venus, 79
- Reinforced concrete, 203
- Reilth alloy, 356
- Rel-Kol, 384
- Relay steel, 643
- Reletha, 404
- Rem-Cru alloys, 728
- Rendered pork fat, 395
- Renierite, 317
- Reunet, 140
- Rensselaerite, 708
- Renyx AZN, 248
- Renyx alloy, 248
- Rep, 226
- Repellants, 306
- Reprocessed wool, 785
- Resenit, 614
- Resigum, 261
- Resilla steel, 680
- Resimene, 455
- Resin D.Y.L.T., 276
- Resin V, 608
- Resin emulsion paint, 522
- Resinite, 546
- Resinoids, 704
- Resinol, 261
- Resinox 6952, 547
- Resins, 600
- Resista, 213
- Resistac, 36
- Resistall, 526
- Resistan, 549
- Resistance wire, 601
- Resisto-Loy, 772
- Resistoflex, 761
- Resloom M-75, 189
- Resorcinol, 603
- Resorcinol adhesives, 603
- Resorcinol-formaldehyde plastic, 603
- Retz alloy, 356
- Reused wool, 784
- Revalon, 34
- Revere alloy 120, 595
- Revere alloy 130, 594
- Revere alloy 160, 138
- Revere alloy 429, 35
- Revere alloy 430, 35
- Revere alloy 508, 234
- Revere alloy JS-1, 435
- Revere alloy M, 435
- Revere phosphor bronze, 551
- Reverse brass, 788
- Reverse bronze, 778
- Revertex, 396
- Rex AA steel, 360
- Rex AAA steel, 360
- Rex babbitt, 70
- Rex 95 steel, 360
- Rex steel, 359
- Rex T-Mo steel, 359
- Rex VM steel, 360
- Rexalloy, 236
- Rextox, 211
- Reynolds alloy 13, 248
- Reynolds alloy 380, 248
- Reynolds alloy R-301, 30
- Reynolite, 549
- Reynolon 4000, 758
- Reynolon film, 707
- Rezistal, 489
- Rezistal 2600, 489
- Rhatoon ginger, 318
- Rhea, 591
- Rhenium, 603
- Rheum, 259
- Rhinestones, 321
- Rhodium, 604
- Rhodium-gold alloy, 578
- Rhodium oil, 606
- Rhodochrosite, 447
- Rhoidid, 156
- Rhodolite, 312
- Rhoplex WN-75, 188
- Rhoplex WN-80, 188
- Rhotanium, 578
- Rhozyme LA, 151

- Rhubarb, 259  
 Rhyolite, 583  
 Ribbon slate, 653  
 Riboflavin, 762  
 Rice, 604  
 Rice hulls, 604  
 Rice oil, 605  
 Rice paper, 528  
 Rice root, 112  
 Rice starch, 686  
 Rice straw, 604  
 Rice wine, 605  
 Rich gold metal, 595  
 Rich low brass, 594  
 Richard's solder, 665  
 Rif, 656  
 Rigid-Tex steel, 278  
 Rigidized steel, 278  
 Rimu, 563  
 Ring jewels, 366  
 Ringas, 606  
 Rinmann's green, 191  
 Ritex, 432  
 Ritha, 625  
 River birch, 93  
 River cottonwood, 229  
 River maple, 451  
 Road marking paint, 521  
 Road oil, 544  
 Roble, 83  
 Rocan copper, 208  
 Roche alum, 25  
 Rochelle salts, 58  
 Rock asphalt, 65  
 Rock cork, 466  
 Rock crystal, 586  
 Rock elm, 267  
 Rock maple, 451  
 Rock rose, 260  
 Rock salt, 620  
 Rock wool, 466  
 Rock wool blankets, 467  
 Rock wool quilt, 467  
 Rockite, 549  
 Rockoustile, 757  
 Rocktex, 466  
 Rocky Mountain juniper, 383  
 Rocou, 49  
 Rol-man steel, 449  
 Roll felt, 287  
 Rolled oats, 507  
 Rolled zinc, 787  
 Roman alum, 25  
 Roman bronze, 476  
 Roman cement, 159  
 Romanzovite, 313  
 Roneusil steel, 449  
 Roof putty, 271  
 Roofing copper, 208  
 Roofing granules, 115  
 Roofing sand, 114  
 Roofing slate, 653  
 Roofinsul, 347  
 Roofloy, 399  
 Rope, 215  
 Roscoelite, 605  
 Rose maple, 452  
 Rose quartz, 587  
 Rose water, 538  
 Rosein, 382  
 Rosele fiber, 384  
 Rosemary oil, 538  
 Rosemary pine, 560  
 Rose's alloy, 309  
 Rosewood, 605  
 Rosewood oil, 606  
 Rosin, 606  
 Rosin ester, 607  
 Rosin oil, 609  
 Rosin size, 607  
 Rosite, 162  
 Rotenone, 242  
 Rothoffite, 313  
 Rottenstone, 609  
 Rouge, 609  
 Rough-leaf dogwood, 252  
 Rousette leather, 632  
 Roxaprene, 172  
 Royal blue, 190  
 Royal insulation board, 677  
 Royalite, 615  
 Rubatex, 677  
 Rubber, 610  
 Rubber bearings, 80  
 Rubber cements, 12  
 Rubber powder, 616  
 Rubberized fabrics, 187  
 Rubberized paper, 526  
 Rubbermastic, 318  
 Rubbing stones, 776  
 Rubens brown, 508  
 Rubidium, 617  
 Rubidium oxide, 406  
 Rubio iron ore, 377  
 Ruby, 617  
 Ruby arsenic, 59  
 Ruby glass, 322  
 Ruby mica, 461  
 Ruby silver, 584  
 Ruby sulphur, 59  
 Rue oil, 539  
 Rulahyde, 172  
 Ruolz silver, 494  
 Ruselite, 248  
 Russian duck, 262  
 Russian isinglass, 380  
 Russian maple, 92  
 Russian oil, 544  
 Rustless iron, 682  
 Rustless RR-11 iron, 683  
 Ruthenium, 618  
 Ruthenium oxide, 618  
 Rutile, 729  
 Rutin, 257  
 Rycase steel, 198  
 Rycro screw stock, 628  
 Rye, 618  
 Rye straw, 618  
 Ryerson VD steel, 733  
 Ryertex, 82  
 Rytense AA machinery steel, 135  
 S  
 S Monel, 473  
 Sabadilla, 370  
 Sabeco metal, 357  
 Sabicu, 440  
 Saccharides, 128  
 Saccharin, 698  
 Saddle soap, 657  
 SAE alloy 33, 32  
 SAE alloy 68, 36  
 SAE alloy 324, 32  
 SAE alloy 660, 79  
 SAE babbitt, 69  
 SAE bronze 65, 315  
 SAE bronze 791, 79  
 SAE bronze 795, 79  
 SAE screw stock, 628  
 SAE solder No. 1, 664  
 SAE solder No. 4, 665  
 SAE steel 1020, 134  
 SAE steel 1112, 135  
 SAE steel 1120, 135  
 SAE steel 2330, 496  
 SAE steel 2350, 618  
 SAF steel 3110, 135  
 SAE steel 3160, 493  
 SAE steel 3312, 135  
 SAE steel 3330, 491  
 SAE steel 4130, 472  
 SAE steel 4140, 174  
 SAE steel 4150, 472  
 SAE steel 4615, 472  
 SAE steel 4650, 472  
 SAE steel 6145, 752  
 SAE steel 6150, 249  
 SAE steel 6195, 249  
 SAE steel 7260, 742  
 SAE steel 9255, 644  
 SAE steel 71360, 742  
 SAE steel 71660, 742  
 SAE steel T1350, 619  
 SAE steel X1330, 449  
 SAE steel X1340, 449  
 SAE steel X4340, 422  
 SAE steels, 618  
 SAE tungsten steels, 742  
 SAE white brass, 776  
 SAF black, 132  
 Safalloy, 30C  
 Safety glass, 502  
 Safflower, 50

- Safflower oil, 50
- Saffron, 50
- Saflex, 760
- Safrol, 674
- Sagamore steel, 501
- Sage, 674
- Sagenite, 587
- Sago flour, 619
- Saigon cinnamon, 185
- Saké, 605
- Sal ammoniac, 47
- Sal soda, 659
- Salge's bronze, 788
- Salicin, 779
- Salicoside, 779
- Salicylic acid, 779
- Saligenin, 779
- Salmon gum, 339
- Salmon oil, 619
- Salmon trout, 619
- Salp, 370
- Salt, 620
- Salt cake, 702
- Salt tablets, 620
- Salt peter, 576, 662
- Salvador sisal, 652
- Samson Extra steel, 468
- Samson steel, 490
- Sand, 621
- Sand-lime brick, 107
- Sandalwood, 622
- Sandalwood oil, 622
- Sandarac, 622
- Sandblast sand, 622
- Sandpaper, 623
- Sandstone, 623
- Sanidine, 285
- Sanka, 120
- Sann hemp, 703
- Santa Marta balsa, 72
- Santalol, 126
- Santobanc, 271
- Santobrite, 546
- Santocel, 637
- Santomerse, 244
- Santophen 20, 372
- Santorin, 160
- Santosite, 702
- Santotan KR, 711
- Santowax, 769
- Sanwa millet, 465
- Sap brown dye, 408
- Sap gum, 338
- Sap pine, 561
- Sapele, 624
- Saponin, 625
- Sappanwood, 105
- Sapphire, 223, 626
- Sapucainha oil, 167
- Sapwood, 782
- Saran, 761
- Saran bristles, 761
- Saran latex, 761
- Saran rope, 216
- Saratoga steel, 501
- Sardine, 353
- Sardine oil, 353
- Sardoine, 15
- Sari gum, 735
- Sarrapia, 731
- Sarsaparilla, 674
- Sasanqua oil, 717
- Sassafras, 674
- Sassafras oil, 674
- Sassandra mahogany, 390
- Sassolite, 99
- Satco, 70
- Sateen, 627
- Satin, 626
- Satin rouge, 610
- Satin spar, 343
- Satin walnut, 338
- Satin white, 343
- Satinee, 606
- Satinwood, 339
- Saturated acids, 284
- Savin, 383
- Savin oil, 383
- Savory, 672, 673
- Sawdust, 783
- Sawfish, 632
- Saxon blue, 190
- Scale wax, 85
- Scandium, 627
- Scarlet oak, 506
- Scented mahogany, 624
- Scheele's green, 559
- Scheelite, 627
- Schimose, 280
- Schneck oak, 505
- Scotch fir, 562
- Scotch grass, 258
- Scotch pine, 562
- Scotch tape, 337
- Scots pine, 562
- Scott's cement, 344
- Scouring abrasive, 628
- Scouring powder, 658
- Screen cloth, 779
- Screening smokes, 654
- Screw stock, 134, 628
- Scrub palmetto, 112
- Scrub pine, 561
- Scythestones, 776
- Sea Island cotton, 224
- Sea onion, 681
- Sea water, 801
- Seacoal, 95
- Seacoast teak, 718
- Sea oil, 628
- Sealing tapes, 12
- Sealmet alloy, 424
- Seaming twine, 215
- Seaweed, 13
- Secondary amyl alcohol, 48
- Secondary copper, 207
- Sedimentary rocks, 806
- Seed lac, 633
- Seewasser alloy, 32
- Seidlitz, 438
- Seidlitz powder, 438
- Seine twine, 215
- Seismotite, 583
- Seito ware, 161
- Sel-Rex, 575
- Selectron CR-39, 24
- Selenite, 345
- Selenium, 629
- Selenium copper, 630
- Selenium steel, 629
- Self-hardening steel, 358
- Self-lubricating bearings, 81
- Semianthracite, 52
- Semibituminous coal, 95
- Semicoke, 196
- Seminole hard steel, 635
- Semiplastic bronze, 564
- Semisteel, 144
- Senarmorite, 55
- Sendust alloys, 540
- Senega, 259
- Sengierite, 747
- Senna, 630
- Sennaar gum, 339
- Sepia, 238
- Sequoia, 596
- Seraceta, 594
- Serap grass, 406
- Seraya, 397
- Serge, 783
- Sericite mica, 463
- Serpentine, 630
- Sesame oil, 630
- Setim, 339
- Sett grease, 425
- Seville orange, 542
- Seymour phosphor bronze, 551
- Seymourite, 485
- Shadke, 596
- Shagbark hickory, 354
- Shagreen leather, 632
- Shaku-do, 596
- Shale, 631
- Shale oil, 631
- Shamra, 476
- Shantung silk, 647
- Shark leather, 632
- Shark liver oil, 632
- Sharon steel 302, 179
- Shatterproof glass, 502
- She oak, 506
- Shea butter, 755
- Shea nut oil, 755
- Shear steel, 691
- Sheep intestines, 151



- Sheepskin, 632  
 Sheepskein shearlings, 633  
 Sheepswool sponge, 676  
 Sheetflextos, 62  
 Shell steel, 515  
 Shellac, 633  
 Shellac plastics, 634  
 Shellbark hickory, 354  
 Sherardized metals, 792  
 Sherolatium, 543  
 Shiah zira, 674  
 Shilo fiber, 387  
 Shim stock, 356  
 Shingle spruce, 680  
 Shinglewood, 724  
 Ship pitch, 715  
 Shirayuki, 581  
 Shock-Proof iron, 442  
 Shock-resistant steel, 634  
 Shoddy, 784  
 Shoe die steel, 635  
 Shoe fiber, 765  
 Short varnish, 753  
 Shortenings, 365  
 Shortleaf pine, 560  
 Shot ore, 378  
 Shrinkproof fabrics, 189  
 Shumard oak, 505  
 Siak tallow, 99  
 Siam benzoin, 695  
 Siberian fir, 564  
 Siberian hare, 124  
 Siberian pine oil, 564  
 Sicalite, 141  
 Sicilian sulphur, 700  
 Sicromo steel, 635  
 Sideraphite, 221  
 Siderite, 378  
 Sienna, 508  
 Sierra Fibrene, 708  
 Sierra Leone butter, 754  
 Sifbronze, 106  
 Sigmalium, 30  
 Signal smoke, 655  
 Sil-Fos, 650  
 Sil-O-Cel, 247  
 Sil-O-Cel C-22, 247  
 Sil-Var paint, 521  
 Silal, 642  
 Silanca, 648  
 Silanes, 646  
 Silastic, 645  
 Silberstein solder, 651  
 Silchrome RA, 350  
 Silcut steel, 628  
 Silene EF, 122  
 Silesia, 678  
 Sillex, 736  
 Silxon, 641  
 Silica, 635  
 Silica aerogel, 637  
 Silica brick, 588  
 Silica flour, 636  
 Silica gel, 637  
 Silica glass, 636  
 Silica powder, 636  
 Silica sand, 621  
 Silica sandstone, 623  
 Silical, 585  
 Silicic acid, 277  
 Silicon, 638  
 Silicon aluminum, 291  
 Silicon brass, 639  
 Silicon bronze, 638  
 Silicon carbide, 640  
 Silicon carbide cement, 599  
 Silicon-copper, 641  
 Silicon-copper alloy, 639  
 Silicon dioxide, 635  
 Silicon iron, 641  
 Silicon-manganese, 642  
 Silicon-manganese steel, 643  
 Silicon-manganese-zirconium, 796  
 Silicon monoxide, 637  
 Silicon oxycarbide, 347  
 Silicon-spiegel, 642  
 Silicon steel, 643  
 Silicon tetrachloride, 654  
 Silicon tetramethyl, 645  
 Silicon-zirconium, 796  
 Silicone enamels, 645  
 Silicone oils, 645  
 Silicone rubber, 645  
 Silicone tissue, 526  
 Silicones, 644  
 Silk, 646  
 Silk noils, 646  
 Silk velvet, 756  
 Silk waste, 646  
 Silky oak, 506  
 Sillimanite, 475  
 Silman steel, 643  
 Silt, 161  
 Silumin, 40  
 Silvacon 383, 253  
 Silvacon 490, 253  
 Silvacon 508, 253  
 Silvaz, 290  
 Silvel, 484  
 Silver, 648  
 Silver amalgam, 44  
 Silver azoimide, 306  
 Silver babbitt, 70  
 Silver-bearing copper, 207  
 Silver beech, 83  
 Silver bell metal, 85  
 Silver birch, 92  
 Silver bond silica, 636  
 Silver bromide, 649  
 Silver chloride, 162  
 Silver chloride crystals, 649  
 Silver-clad steel, 649  
 Silver-copper alloy, 204, 648  
 Silver difluoride, 299  
 Silver glance, 57  
 Silver-graphite alloys, 204  
 Silver-indium alloys, 366  
 Silver-magnesium solder, 651  
 Silver maple, 451  
 Silver-molybdenum alloy, 204  
 Silver nitrate, 649  
 Silver pine, 563  
 Silver-Ply, 200  
 Silver potassium cyanide, 650  
 Silver powder, 649  
 Silver solder, 650  
 Silver spruce, 680  
 Silv sulphantimonite, 55  
 Silver sulphide, 650  
 Silver-tin alloy, 649  
 Silver-tungsten alloys, 204  
 Silver wattle, 419  
 Silv aid, 495  
 Silverweed, 259  
 Silv iron, 557  
 Sin, 187  
 Simanal, 291  
 Sin, 30  
 Simplex steel, 490  
 Single nickel salt, 497  
 Single sugars, 128  
 Sintercorund, 223  
 Sin erit, 676  
 Sin erloy, 692  
 Sipo mahogany, 624  
 Sisal, 651  
 Sisalkraft, 527  
 Sisoo, 605  
 Sitka cypress, 239  
 Sitka spruce, 680  
 Ski, 354  
 Skleron, 43  
 Sku spruce, 680  
 Skydrol, 427  
 Slax wax, 530  
 Slax, 652  
 Slag cement, 160  
 Slag formers, 301  
 Slag pumice, 583  
 Slag wool, 466  
 Slash pine, 561  
 Slate, 653  
 Slate black, 559  
 Slate flour, 653  
 Slate granules, 115  
 Slate lime, 653  
 Slaskote, 288  
 Slaters' felt, 287  
 Slicker solder, 664  
 Slippery elm, 268

- Slush castings, 777
- Slushing oil, 426
- Smalt, 190
- Smaltite, 59
- Smelling salts, 46
- Smithco PE, 709
- Smithco RT, 709
- Smithsonite, 791
- Smoke agents, 654
- Smoke candles, 654
- Smoke pots, 654
- Smoke screens, 654
- Smoked elk, 267
- Smokeless fuel, 196
- Smokeless powder, 279
- SMZ alloy, 796
- Snagging wheels, 223
- Snakeroot, 259
- Snakeskins, 655
- Sneezing gas, 571
- Snowflake oil, 670
- Soap, 655
- Soap flakes, 656
- Soap nut, 625
- Soap plant, 626
- Soapbark, 625
- Soapberry, 625
- Soapless shampoos, 658
- Soapless soaps, 243
- Soaproot, 626
- Soapstone, 658
- Soapwort, 625
- Sockeye salmon, 619
- Sod oil, 774
- Soda alum, 25
- Soda ash, 659
- Soda briquettes, 659
- Soda crystals, 659
- Soda feldspar, 285
- Soda lime, 411
- Soda lime glass, 319
- Soda niter, 662
- Soda spar, 286
- Soda-treated rosin, 607
- Soda water, 237
- Sodatol, 281
- Sodium, 660
- Sodium acid sulphate, 701
- Sodium alginate, 14
- Sodium aluminate, 660
- Sodium aluminum silicate, 270, 297
- Sodium amalgam, 44
- Sodium antimony lactophenate, 370
- Sodium benzoate, 695
- Sodium bicarbonate, 659
- Sodium bisulphate, 701
- Sodium borate, 98
- Sodium borate decahydrate, 660
- Sodium carbonate, 659
- Sodium cellulose glycollate, 154
- Sodium cellulose sulphate, 154
- Sodium chloride, 620
- Sodium chlorite, 621
- Sodium-copper, 660
- Sodium cyanide, 660
- Sodium dichromate, 660
- Sodium ferrocyanide, 661
- Sodium fluoracetic acid, 682
- Sodium fluosilicate, 369
- Sodium glutamate, 581
- Sodium hydrate, 661
- Sodium hydrogen carbonate, 659
- Sodium hydroxide, 661
- Sodium hypochlorite, 621
- Sodium lauryl sulphate, 243
- Sodium metasilicate, 662
- Sodium naphthenate, 254
- Sodium nitrate, 662
- Sodium oleate, 511, 655
- Sodium orthosilicate, 662
- Sodium oxychlorite, 621
- Sodium pectate, 129
- Sodium pentachlorophenol, 546
- Sodium perborate, 658
- Sodium peroxide, 518
- Sodium phosphoaluminate, 26
- Sodium pyrophosphate, 737
- Sodium selenite, 629
- Sodium silicate, 662
- Sodium soaps, 656
- Sodium stannate, 474
- Sodium sulphate, 701
- Sodium sulphide, 702
- Sodium sulphite, 702
- Sodium sulphhydrate, 702
- Sodium tetraphosphate, 737
- Sodium-tin, 660
- Sodium tungstate, 781
- Sodium uranate, 748
- Sofa grass, 406
- Soft black, 132
- Soft coal, 94
- Soft corn, 219
- Soft maple, 451
- Soft silk, 646
- Soft soaps, 657
- Soft solder, 664
- Softwoods, 782
- Sohnhofen stone, 412
- Soils, 809
- Solar salt, 620
- Solar steel, 642
- Solcod, 699
- Solder, 664
- Solder No. 1580, 664
- Solder No. 4663, 664
- Solder wire, 665
- Solidified alcohol, 17
- Solidified oil, 425
- Sulinox, 414
- Solox, 275
- Solozone, 518
- Soluble cotton, 157
- Soluble oils, 236
- Soluble starch, 687
- Soluminium, 665
- Solution, 803
- Solvers, 759
- Solvent naphtha, 480
- Solvents, 666
- Solvesso, 480
- Sorbital, 668
- Sorbo, 668
- Sorel cement, 159
- Sorel's alloy, 788
- Sorghum grass, 697
- Sorghum sirup, 697
- Sorgo sirup, 697
- Sound insulators, 669
- Souple silk, 646
- Sour dock, 126
- Sour gum, 338
- Sour tupelo, 338
- Southern cypress, 239
- Southern gum, 338
- Southern pine, 561
- Southern red oak, 505
- Southern white cedar, 152
- Sorprene, 614
- Soy milk, 464
- Soya bean oil, 669
- Soya butter, 118
- Soyalene, 670
- Soybean albumin, 16
- Soybean flour, 670
- Soybean glue, 327
- Soybean meal, 670
- Soybean oil, 669
- Soybean oil cake, 670
- Soybean protein, 581
- Spanish black, 559
- Spanish cedar, 152
- Spanish chestnut, 169
- Spanish garnet, 312
- Spanish goatskin, 632
- Spanish leather, 746
- Spanish moss, 671
- Spanish oak, 506
- Spanish peanut, 532
- Spar varnish, 753
- Spark plug wire, 602
- Sparkaloy, 602
- Sparklers, 75
- Spathic iron ore, 378
- Spauldite, 548

- Spearmint, 536  
 Special alloy machine steel, 449  
 Specular hematite, 377  
 Speculum metal, 671  
 Speculum plate, 671  
 Speed Alloy steel, 135  
 Speed-Cut steel, 468  
 Speed Star steel, 360  
 Speedaloy, 236  
 Spekwite, 51  
 Spelter, 788  
 Spelter solder, 106  
 Spence's metal, 430  
 Sperm oil, 671  
 Spermaceti, 672  
 Sperrylite, 565  
 Spessartite, 313  
 Sphalerite, 791  
 Spice, 672  
 Spiegeleisen, 289  
 Spike lavender, 539  
 Spinel, 176, 617  
 Spinning brass, 138  
 Spirit varnish, 753  
 Spirits of salt, 363  
 Spirits of turpentine, 743  
 Spodumene, 675  
 Sponge, 676  
 Sponge cloth, 227  
 Sponge iron, 676  
 Sponge rubber, 677  
 Sprat, 353  
 Sprengle explosives, 678  
 Spring brass, 356  
 Spring bronze, 356  
 Spring steel, 678  
 Spring wheat, 775  
 Spruce, 680  
 Spruce extract, 681  
 Spruce fir, 680  
 Spruce gum, 681  
 Spruce pine, 351, 561  
 Sprucolite, 569  
 Squill, 681  
 Sta-Gloss steel, 180  
 Sta-Tite paper, 527  
 Stabelite resin, 608  
 Stabilized fabrics, 189  
 Stabilizer alloys, 437  
 Stain, 520  
 Stainless C welding rod, 771  
 Stainless CF-8M steel, 181  
 Stainless-clad steel, 200  
 Stainless iron, 682  
 Stainless iron No. 12, 682  
 Stainless nickel, 495  
 Stainless oils, 427  
 Stainless steel, 683  
 Stainless steel filters, 693  
 Stainless steel flake, 560  
 Stainless steel wool, 693  
 Stainless U steel, 180  
 Stainless W steel, 180  
 Stainstripe, 198  
 Stand oil, 414  
 Standard alloy, 488  
 Standard gold, 329  
 Standard sand, 622  
 Standard tin, 725  
 Stannic oxide, 726  
 Stannic sulphide, 559  
 Stannous sulphide, 559  
 Stannum metal, 70  
 Stanolith grease, 458  
 Staple fiber, 594  
 Star antimony, 54  
 Star J-metal, 235  
 Star-leaved gum, 338  
 Star ruby, 617  
 Star-Zenith steel, 359  
 Staralox, 38  
 Starch, 686  
 Starch acetates, 687  
 Starch nitrate, 688  
 Starch sponge, 688  
 Stargrass, 259  
 Statex, 133  
 Statuary bronze, 688  
 Staybolt iron, 786  
 Staybrite steel, 684  
 Staypak, 410  
 Steam bronze, 201  
 Steam cylinder oil, 426  
 Steamed bone, 98  
 Stearic acid, 688  
 Stearin, 710  
 Stearin pitch, 689  
 Stearite, 689  
 Steatite, 658  
 Steatite talc, 708  
 Steel, 689  
 Steel bronze, 531  
 Steel castings, 148  
 Steel forgings, 691  
 Steel grit, 379  
 Steel powder, 692  
 Steel shot, 379  
 Steel wire, 478  
 Steel wool, 693  
 Steelblast, 379  
 Steelhead trout, 619  
 Steelite, 678  
 Stellarite, 66  
 Stellite, 235  
 Stellite No. 21, 222  
 Stellite hard-facing rod, 772  
 Stentor steel, 500  
 Stephanite, 55  
 Sterbon, 641  
 Stereotype metal, 745  
 Sterling silver, 648  
 Sterling spelter, 788  
 Sterling stainless FC, 685  
 Sterling stainless steel, 684  
 Sterling white, 418  
 Sterlite, 485  
 Sterlith, 38  
 Sterri, 699  
 Sterro metal, 477  
 Stibiconite, 55  
 Stibnite, 54  
 Stick lac, 633  
 Stick rouge, 610  
 Stickwater, 510  
 Stillingia oil, 693  
 Stillingia tallow, 693  
 Stitching wire, 478  
 STM steel, 360  
 Stockfish, 632  
 Stockholm tar, 715  
 Stockinett, 167  
 Stoddard solvent, 480  
 Stoneware, 162  
 Stoodite, 772  
 Stora, 167  
 Storalon, 641  
 Storax, 694  
 Stramonium, 257  
 Strauss metal, 740  
 Straw, 618  
 Strawboard, 531  
 Strenes metal, 487  
 Streptomycin, 833  
 Stressproof steel, 450  
 Strex, 227  
 Stripecoat, 154  
 Stroba wax, 769  
 Strontianite, 693  
 Strontium, 693  
 Strontium carbonate, 694  
 Strontium nitrate, 694  
 Strontium stearate, 458  
 Strontium sulphate, 694  
 Strontium sulphide, 694  
 Structural nickel steel, 496  
 Structural silicon steel, 643  
 Structural steels, 449  
 Strychnine, 504  
 Strychnine sulphate, 504  
 Stud steel, 256  
 Sturgeon, 380  
 Stymer, 572  
 Styphnic acid, 306  
 Styraloy, 572  
 Styrax, 694  
 Styrene, 571  
 Styrene-acrylic resin, 8  
 Styrene bromide, 585  
 Styrene-butylene resin, 572  
 Styroflex, 572

- Styrofoam, 677
- Styron, 372
- Suari fat, 734
- Sublimed white lead, 401
- Succinite, 45
- Sucrose, 695
- Suede, 695
- Sueded fabrics, 405
- Sugar, 695
- Sugar beet, 695
- Sugar beet pulp, 129
- Sugar cane, 695
- Sugar cane wax, 137
- Sugar maple, 451
- Sugar of lead, 254
- Sugar palm, 619
- Sugar pine, 698
- Sulfamic acid, 698
- Sulfan, 701
- Sulfolanes, 667
- Sulphite turpentine, 743
- Sulphocarbamide, 748
- Sulphonated castor oil, 147
- Sulphonated oil, 699
- Sulphonated sperm oil, 672
- Sulphonated stearin, 699
- Sulphonated tall oil, 709
- Sulphonated tallow, 699
- Sulphourea, 748
- Sulphur, 699
- Sulphur cements, 430
- Sulphur dioxide, 700
- Sulphur dyes, 266
- Sulphur hexafluoride, 299
- Sulphur trioxide, 701
- Sulphurated oils, 271
- Sulphuric acid, 701
- Sulphuric anhydride, 701
- Sulphuric trioxide, 654
- Sulphurized oil, 236
- Sulphurous acid, 701
- Sulphurous acid anhydride, 700
- Sulphuryl chloride, 654
- Sulpomag, 438
- Sultex oil, 237
- Sulvanite, 570
- Sumac, 702
- Sumac wax, 381
- Sumatra benzoin, 695
- Sumauma, 72
- Sumet bronze, 357
- Sun hemp, 703
- Sunec, 384
- Sunflower meal, 703
- Sunflower oil, 703
- Sunflower rubber, 703
- Sunn fiber, 703
- Sunolith, 74
- Sunshine carbon, 131
- Sunstone, 285
- Sunwax, 530
- Super-calendered paper, 525
- Super-cut steel, 628
- Super high-speed steel, 358
- Super-Invar, 423
- Super-Kore steel, 22
- Super manganese bronze, 446
- Super stainless steel, 179
- Superalloy steel, 493
- Superbronze, 704
- Superduralumin, 30
- Superex, 247
- Superfine red lead, 596
- Superloy, 771
- Supermal, 442
- Supermalloy, 540
- Supernickel, 233
- Superock, 203
- Superoxides, 519
- Superpalite, 550
- Superpax, 514
- Superphosphate, 294, 553
- Supertemp block, 466
- Supertensile steel wire, 478
- Supremus steel, 359
- Surf, 244
- Surface-active agents, 243
- Surfax, 243
- Surinam greenheart, 334
- Surinam quassia, 588
- Surinam teak, 718
- Suspenso, 165
- SuVeneer steel, 200
- Suzorite rock, 115
- Swamp ash, 64
- Swamp birch, 92
- Swamp black gum, 338
- Swamp cedar, 725
- Swamp chestnut oak, 507
- Swamp cottonwood, 229
- Swamp gum, 338
- Swamp maple, 451
- Swamp oak, 506
- Swamp pine, 561
- Swamp tupelo, 338
- Swatow grass cloth, 591
- Swedelec, 786
- Swedish charcoal iron, 167
- Swedish wrought iron, 786
- Sweet birch, 93
- Sweet birch oil, 93
- Sweet chocolate, 192
- Sweet corn, 219
- Sweet gum, 338, 694
- Sweet myrrh, 601
- Sweet potato, 576
- Sweet potato starch, 686
- Sweetaloy, 488
- Swiss, 226
- Switch copper, 208
- Sycamore, 704
- Sycamore gum, 338
- Sylvan, 307
- Sylvanite, 330
- Sylvite, 574
- Sympathetic inks, 368
- Synasol, 275
- Synergist, 56
- Synhexyl, 353
- Syntans, 711
- Synthane, 549
- Synthane L-RF, 548
- Synthanol, 147
- Synthesis gas, 187
- Synthetic alcohol, 17
- Synthetic almond oil, 24
- Synthetic amber, 45
- Synthetic beryl, 88
- Synthetic butter, 118
- Synthetic caffeine, 120
- Synthetic camphor, 125
- Synthetic cannabis, 353
- Synthetic cast iron, 143
- Synthetic cryolite, 231
- Synthetic egg white, 16
- Synthetic emeralds, 88
- Synthetic fibers, 593
- Synthetic gasoline, 314
- Synthetic gems, 617
- Synthetic hard rubber, 612
- Synthetic kieserite, 438
- Synthetic kyanite, 392
- Synthetic leather, 404
- Synthetic lubricants, 299
- Synthetic methyl acetone, 7
- Synthetic mica, 462
- Synthetic mullite, 475
- Synthetic musk, 537
- Synthetic olive oil, 512
- Synthetic pearl essence, 560
- Synthetic pine oil, 563
- Synthetic quartz crystal, 586
- Synthetic quinine, 184
- Synthetic resin glue, 327
- Synthetic resins, 704
- Synthetic rubber, 613
- Synthetic ruby, 617
- Synthetic salt cake, 702
- Synthetic sapphire, 626
- Synthetic silica, 637
- Synthetic spinel, 617
- Synthetic stearic acid, 689
- Synthetic steel scrap, 92
- Synthetic tannins, 711
- Synthetic varnish, 754
- Synthetic wax, 534, 769

Synthrez D, 189  
Systemic gas, 569  
Syton, 637  
Szomolnokite, 292

## T

T and V alloy, 236  
T oil, 731  
Tablet tea, 717  
Tabular alumina, 27  
Tacamahac, 229  
Tacari, 105  
Tachylite, 583  
Tackle twill, 227  
Tackol, 612  
Taconite, 377  
Taenite, 495  
Taggers tin, 726  
Tagua nut, 381  
Talc, 707  
Talc crayons, 658  
Talcu gum, 339  
Talh gum, 339  
Tali bamboo, 73  
Talide, 741  
Tall oil, 709  
Tall oil soaps, 657  
Talloel, 709  
Tallow, 709  
Tallow oil, 689  
Talmi gold, 263  
Tam alloy 35, 291  
Tam alloy 78, 291  
Tamanu, 167  
Tamarack, 394  
Tamarind, 58  
Tamco zirconium  
refractories, 794  
Tamo, 64  
Tampico, 652  
Tanacetene, 259  
Tanacetum, 259  
Tanacetum oil, 259  
Tanbark oak, 507  
Tane koji, 605  
Tangle, 396  
Tangle, 14  
Tanguis cotton, 224  
Tanigan, 711  
Tankage, 83  
Tanners' alkali, 659  
Tanners' grease, 282  
Tanning agents, 710  
Tannins, 710  
Tansy oil, 259  
Tansyn, 711  
Tantalal oxide, 713  
Tantalite, 713  
Tantaloy, 713  
Tantalum, 711  
Tantalum carbide, 712  
Tantalum ores, 713  
Tanteuxenite, 714  
Tantiron, 642  
Tantung G, 713  
Tap cinder, 599  
Tapa cloth, 529  
Tapazolite, 313  
Tapioca paste, 11  
Tapioca starch, 686  
Tapiolite, 714  
Tar, 714  
Tar camphor, 480  
Tara, 251  
Tara japonica, 311  
Tara powder, 251  
Tari, 251  
Tarlatan, 227  
Tarmac, 714  
Taro, 577  
Tartaric acid, 57  
Tarvia, 714  
Tasajo, 84  
Tasmanian blackwood, 419  
Tatmo steel, 359  
Tau sagyz, 240  
Tawhai, 83  
Taylor process wire, 716  
Taylor-White steel, 358  
Tea, 716  
Tea lead, 399  
Tea waste, 717  
Teak, 717  
Tear gas, 718  
Teaseed oil, 717  
Tec-Char, 10  
Technetium, 592  
Technic alloy, 22  
Teflon, 299  
Teglac resins, 20  
Tego resin film, 11  
Tej, 85  
Telactal, 40  
Telloy, 720  
Tellurium, 719  
Tellurium bronze, 719  
Tellurium copper, 719  
Tellurium lead, 719  
Tellurium oxide, 719  
Telnic bronze, 551  
Temboard, 296  
Temlok, 296  
Tempaloy, 234  
Tempered lead, 399  
Tempering oils, 205  
Temperite, 123  
Temperite alloys, 309  
Tempil pellets, 309  
Temwood, 296  
Tenazit, 549  
Tengusa seaweed, 13  
Tenite, 156  
Tenite II, 157

Tenite III, 157  
Tennal, 34  
Tennantite, 59, 210  
Tenorite, 211  
Tenox BHA, 56  
Tenox HQ, 56  
Tensilite, 704  
Tensilite 300, 295  
Tensloy, 486  
Tensolite, 172  
Tenzaloy, 43  
Teosinte, 219  
Terbium, 164  
Terephthalic acid, 593  
Terne plate, 720  
Terpene alcohol, 744  
Terpenes, 271  
Terpinol, 120  
Terra alba, 343  
Terra cotta, 721  
Terratex, 63  
Terre verte, 558  
Terry cloth, 227  
Terson voile, 188  
Tertiary, 664  
Tertiary amyl alcohol, 48  
Tervan, 616  
Terylene, 593  
Test papers, 168  
Tetmejer, 639  
Teton steel, 182  
Tetra ethyl orthosilicate,  
277  
Tetrabutyl hydro-  
peroxide, 519  
Tetrachlorethane, 721  
Tetrachloro methane, 136  
Tetraethyl lead, 721  
Tetraethyl pyrophosphate,  
371  
Tetrafluoro ethylene, 299  
Tetrahedrite, 210  
Tetrahydrofuran, 307  
Tetralin, 481  
Tetraphosphoric acid, 737  
Tetrol, 307  
Tetryl, 281  
Texas oak, 505  
Textile soda, 659  
Textolite, 548  
Textone, 621  
Thallium, 722  
Thallium bromide  
iodide, 722  
Thallium oxysulphide, 722  
Thallium sulphate, 722  
Thanite, 370  
Thenaud's blue, 191  
Theobromine, 120  
Therlo, 601  
Therm-O-Flake brick,  
757

- Thermalloy, 492
- Thermalloy 40, 488
- Thermalloy 72, 488
- Thermax, 296
- Thermisilid, 642
- Thermit, 722
- Thermo seal, 759
- Thermocouple metals, 723
- Thermoelectric metals, 323
- Thermoil-Granodine, 579
- Thermometals, 723
- Thermopane, 321
- Thermoplastic resins, 705
- Thermoplax, 197
- Thermosetting resins, 705
- Thermostatic metals, 723
- Thermotex, 66
- Thermotomic black, 132
- Thiamin chloride, 762
- Thickening agents, 668
- Thinsteel, 198
- Thinstrip magnesium, 433
- Thioacetamide, 372
- Thiocarbamide, 748
- Thiokol, 614
- Thiokol A, 614
- Thionyl chloride, 700
- Thiourea, 748
- Thomas slag, 653
- Thomas steel, 92
- Thoreaulite, 713
- Thoria, 724
- Thorite, 724
- Thorium, 724
- Thorium nitrate, 724
- Thorium oxide, 724
- Thorium silicate, 473
- Thorium-tungsten alloys, 724
- Thorn apple, 257
- Thortveitite, 627
- Thurston's bearing metal, 68
- Thuya, 724
- Thuya leaf oil, 725
- Thyme, 16
- Thymidol, 251
- Thymoform, 250
- Thymol, 16
- Thymol blue, 168
- Thyrite, 373
- Ti-Namel, 370
- Ti-Pure, 730
- Tiama mahogany, 624
- Tiaong, 397
- Tidolith, 418
- Tiemanite, 185
- Tiff, 73
- Tiger bronze, 79
- Til, 127
- Til oil, 631
- Til seed, 631
- Tiling plaster, 160
- Timang, 449
- Timber, 781
- Timbo, 242
- Tin, 725
- Tin-base babbitt, 69
- Tin dioxide, 142
- Tin foil, 302
- Tin naphthenate, 254
- Tin ore, 142
- Tin oxide, 726
- Tin plate, 726
- Tin powder, 725
- Tin stone, 142
- Tin tetrachloride, 654
- Tinadure, 222
- Tincal, 98
- Tincture of iodine, 374
- Tingii, 242
- Tinite, 70
- Tinman's solder, 664
- Tinnevelly senna, 630
- Tint-Metal, 578
- Tinyu pine, 563
- Tire cord wire, 478
- Tisco steel, 449
- Tissier's metal, 81
- Tissue paper, 526
- Titanated lithopone, 418
- Titania, 730
- Titania crystals, 730
- Titania-magnesia ceramics, 730
- Titanic acid, 655
- Titanic oxide, 729
- Titanite, 34
- Titanium, 727
- Titanium carbide, 728
- Titanium-chromium alloy, 728
- Titanium copper, 727
- Titanium dioxide, 730
- Titanium ores, 729
- Titanium oxide, 730
- Titanium tetrachloride, 654
- Titanor metal, 728
- Titanox, 730
- Titanox L, 730
- T-K steel, 362
- TL silver solder, 651
- TNA, 281
- TNT, 281
- Tobin bronze, 476
- Toewak, 619
- Toilet soaps, 656
- Toledo steel, 472
- Tollac, 731
- Tolu balsam, 730
- Toluene, 731
- Toluol, 731
- Tolyl phosphate, 125
- Tomatl, 731
- Tomato, 731
- Tomato seed oil, 731
- Tombac metal, 596
- Tombasil, 639
- Tomlinite, 408
- Toncan iron, 213
- Tonite, 570
- Tonka bean, 731
- Tonkin bamboo, 73
- Tontine, 188
- Tool steel, 732
- Toolface, 771
- Toon, 734
- Topaz, 587
- Tophet A, 602
- Tophet C, 602
- Torhauc mineral, 631
- Torbernite, 747
- Tornesit, 172
- Torofoleum, 669
- Touchstone, 298
- Toura, 105
- Tourmaline, 617
- Tournay metal, 596
- Trabuk, 778
- Tracing cloth, 734
- Tracing paper, 253
- Traction sand, 622
- Traders' gold, 595
- Traffic paint, 521
- Tragacanth gum, 734
- Tragasol gum, 419
- Tran-Cor steel, 643
- Transformer steel, 643
- Transite, 62
- Translucent marble, 452
- Transparent mirror glass, 322
- Transultex oil, 237
- Transuranic metals, 592
- Transvaal blue asbestos, 61
- Trap rock, 115
- Trapuca resin, 205
- Trass, 160
- Travertine, 345
- Treacle, 697
- Treated tar, 714
- Tremolite, 60
- Tri-Alloy, 357
- Tri-Clene, 735
- Tri-Ten steel, 213
- Triacetin, 6
- Triad, 735
- Tricalcium phosphate, 554
- Trichlor cumene, 171
- Trichlorethylene, 735
- Trichloromethane, 171
- Trieresyl phosphate, 125
- Trifluoroacetic acid, 6
- Trimene, 612

Trimethyl butane, 315  
 Trinidad asphalt, 65  
 Trinitro anisol, 281  
 Trinitro resorcinol, 306  
 Trinitroaniline, 281  
 Trinitrocellulose, 498  
 Trinitrophenol, 280  
 Trinitrotoluene, 281  
 Trinitrotoluol, 281  
 Trioxane, 303  
 Tripoli, 736  
 Tripolite, 736  
 Triptane, 315  
 Trisodium phosphate, 736  
 Triticum, 258  
 Tritium, 365  
 Triton oil, 530  
 Trodaloy 1, 90  
 Trodaloy 7, 90  
 Trojan explosive, 688  
 Trona, 660  
 Troostite, 792  
 Troilitul, 572  
 Tru-Steel shot, 379  
 Truform steel, 501  
 Truline, 217  
 Trypsin, 76  
 Tsao, 383  
 Tuart, 340  
 Tuc Tur, 485  
 Tucum fiber, 385  
 Tucum oil, 67  
 Tuf-Lite, 550  
 Tuf-Lite plastic, 706  
 Tufa, 807  
 Tufaloy, 22  
 Tuff, 807  
 Tuffalloy 55, 90  
 Tufnol, 549  
 Tulipwood, 737  
 Tuncro, 440  
 Tung-Alloy, 772  
 Tung oil, 737  
 Tungo steel, 363  
 Tungsten, 739  
 Tungsten carbide, 740  
 Tungsten cast iron, 145  
 Tungsten electrodes, 739  
 Tungsten magnet steel, 438  
 Tungsten-nickel alloy, 350  
 Tungsten paste, 739  
 Tungsten powder, 739  
 Tungsten salts, 739  
 Tungsten steel, 741  
 Tungsten-titanium carbide, 741  
 Tungsten wire, 739  
 Tungstic acid, 627  
 Tungweld rods, 771  
 Tupelo, 338  
 Tupelo gum, 338

Turbadium bronze, 445  
 Turbine blade steel, 683  
 Turbiston's bronze, 445  
 Turgite, 378  
 Turkey cup sponge, 676  
 Turkey red, 431  
 Turkey red oil, 699  
 Turkish boxwood, 101  
 Turkish dogwood, 252  
 Turkish geranium oil, 406  
 Turkish oats, 508  
 Turmeric, 318  
 Turpentine, 743  
 Turwar bark, 151  
 Tuscan red, 288  
 Tuscarawa sand, 469  
 Tussah silk, 647  
 Tutanic metal, 545  
 Tuyamunite, 747  
 Tweed, 783  
 Twill, 227  
 Twin Mo steel, 360  
 Twine, 214  
 Txixtle, 170  
 Tygon resins, 308  
 Tylerite, 487  
 Type metal, 744  
 Typewriter paper, 526  
 Typha, 387  
 Tyrian purple, 264  
 Tyrite, 164  
 Tyuyamunite, 750

## U

Uapal, 12  
 Ucuhuba tallow, 754  
 Uda skins, 633  
 Udylite, 119  
 Uformite 412A, 749  
 Uformite 449, 749  
 Uformite 507, 11  
 Uformite 580, 217  
 Uformite MU56, 454  
 Ulexite, 98  
 Ulmal, 32  
 Ulmic acid, 268  
 Ultrabasilite, 317  
 Ultralumin, 34  
 Ultramarine, 745  
 Ultrasan, 430  
 Ultrawets, 244  
 Ultrax opacifier, 514  
 Uma steel No. 1, 182  
 Uma steel No. 5, 182  
 Umber, 508  
 Unakite, 331  
 Undercoat, 579  
 Uni-Syn packing, 63  
 Uni-Temp grease, 458  
 Unicel ND, 677  
 Unicut steel, 360

Uniloy 1409, 682  
 Uniloy 1409M, 682  
 Uniloy steel, 182  
 Unionaloy steel, 496  
 Uniperiox, 519  
 Unisorb, 287  
 Unite, 750  
 Univan steel, 496  
 Universal indicator, 168  
 Upholstery leather, 746  
 Upholstery plush, 566  
 Upland cotton, 224  
 Urac 110 resin, 12  
 Urac 185, 750  
 Uralian emerald, 313  
 Uramon, 293  
 Uranic oxide, 748  
 Uranine, 429  
 Uraninite, 746  
 Uranite, 747  
 Uranium, 747  
 Uranium 235, 747  
 Uranium 238, 747  
 Uranium glass, 748  
 Uranium hexafluoride, 747  
 Uranium ores, 747  
 Uranium oxide, 748  
 Uranium tetrafluoride, 747  
 Uranium trioxide, 748  
 Uranium yellow, 748  
 Uranious oxide, 748  
 Urea, 748  
 Urea-formaldehyde resins, 749  
 Urea peroxide, 519  
 Ureaform, 294  
 Urethane, 749  
 Urethane oils, 749  
 Urucu, 242  
 Urucury wax, 137  
 Urunday extract, 589  
 U.S.S. steel 12A1, 684  
 U.S.S. steel 27, 684  
 U.S.S. steel 321, 180  
 U.S.S. steel 347, 180  
 U.S.S. steel MX, 628  
 U.S.S. steels, 684  
 Utaloy, 348  
 Utilloy 20, 489  
 Uvarovite, 313

## V

V-Foundry alloy, 289  
 V-Lite, 23  
 Valentinite, 55  
 Valeric acid, 96  
 Valonia, 507  
 Valve bronze, 201  
 Valve copper, 210  
 Van Lom steel, 359  
 Vanadinite, 401

- Vanadium, 750
- Vanadium metal, 751
- Vanadium mica, 460
- Vanadium ores, 750
- Vanadium oxide, 605, 751
- Vanadium pentoxide, 751
- Vanadium salts, 751
- Vanadium steel, 751
- Vanadium-tin yellow, 751
- Vandex, 630
- Vandiset, 67
- Vandiset resin, 706
- Vandyke brown, 408, 508
- Vanick, 487
- Vanilla beans, 752
- Vanillin, 752
- Vapor-cured rubber, 611
- Variiegated ore, 210
- Varnish, 753
- Varnished cambric, 123
- Varnished cloth, 123
- Varnished paper, 527
- Varnished rayon, 124
- Varnished silk, 124
- Varnodag, 754
- Varnolene, 480
- Vasco Extrude die steel, 362
- Vasco Marvel steel, 362
- Vasco Supreme steel, 359
- Vasco vanadium steel, 751
- Vascoloy-Ramet, 713
- Vaseline, 543
- Vat dyes, 265
- Vatochnik, 703
- Vatool steel, 734
- Veal, 83
- Vectolite, 439
- Vee jewels, 366
- Vega steel, 501
- Vegetable black, 758
- Vegetable crin, 112
- Vegetable dyes, 265
- Vegetable fats, 754
- Vegetable fibers, 112
- Vegetable gelatin, 316
- Vegetable glue, 11
- Vegetable ivory, 381
- Vegetable oils, 756
- Vegetable parchment, 531
- Vegetable protein, 580
- Vegetable silk, 387
- Vegetable soap, 626
- Vegetable sponge, 420
- Vegetable sulphur, 700
- Vegetable tallow, 755
- Vegetable waxes, 769
- Vellum, 531
- Velon, 761
- Velsicol 1068, 371
- Velvet, 756
- Velveteen, 757
- Veneer, 566
- Veneer fiberboard, 296
- Venetian, 226
- Venetian red, 288
- Venetian soap, 657
- Venetian white, 402
- Venice turpentine, 744
- Vera, 409
- Veratraldehyde, 370
- Veratric acid, 370
- Verde antique marble, 630
- Verdigris, 209
- Veriloy, 348
- Vermiculite, 757
- Vermilion, 559
- Vermilion red, 758
- Vermont marble, 452
- Vernice, 45
- Vernonite, 8
- Verona green, 558
- Versalite, 615
- Vetivazulene, 336
- Vetraldehyde, 370
- Vibration insulators, 669
- Vibro-Insulators, 669
- Vibro-Insulator, 669
- Vibron 103, 23
- Vicalloy, 541
- Vicara, 581
- Vici kid, 391
- Vicor glass, 320
- Victor metal, 495
- Victorite, 765
- Victron, 572
- Viculoy, 91
- Vicuña, 25
- Vimlite, 156
- Vinagreira, 384
- Vinal, 761
- Vincennite, 364
- Vine black, 758
- Vine maple, 451
- Vinegar, 6
- Vinnol, 759
- Vinsol resin, 608
- Vinyl acetate, 760
- Vinyl cyanide, 9
- Vinyl ether, 759
- Vinyl ethylhexyl ether, 759
- Vinyl film 7051, 707
- Vinyl methylether, 759
- Vinyl resins, 758
- Vinylidene chloride plastic, 761
- Vinylite, 760
- Vinyloid, 760
- Vinylum, 560
- Vinyon, 760
- Vinyon N, 760
- Violet oil, 539
- Virginia greenstone, 658
- Virginia peanut, 532
- Virginia poplar, 573
- Virginium, 592
- Viscoloid, 158
- Viacose rayon, 593
- Vistanex, 615
- Vitalium, 222
- Vitamin A, 761
- Vitamin B, 762
- Vitamin C, 763
- Vitamin D, 763
- Vitamin E, 763
- Vitamin G, 762
- Vitamin H, 762
- Vitamin P, 763
- Vitamin oil, 632
- Vitamins, 761
- Vitrain, 315
- Vitreosil, 587
- Vitreous enamels, 269
- Vitreous selenium, 629
- Vitreous silica, 636
- Vitric steel, 270
- Vitrified wheels, 2
- Vitriol, 701
- Vitrite, 571
- Vitrobond, 599
- Vitrolain, 373
- Vitron yarn, 324
- Voile, 226
- Volatile alkali, 46
- Volatile oils, 271
- Volcanic glass, 583
- Volclay, 86
- Vrbaita, 722
- Vuelite, 156
- Vul-Mo steel, 359
- Vulcabeston, 373
- Vulcan bronze, 639
- Vulcanite, 612
- Vulcanized fiber, 763
- Vulcanized oils, 765
- Vulcanized rubber, 611
- Vulcaplas, 615
- Vulcoid, 373
- Vulcollan, 616
- Vultex, 616

W

- Wad ore, 447
- Wagner's alloy, 545
- Wahoo, 267
- Wallaby, 385
- Walnut, 766
- Walnut oil, 738, 767
- Walnut shell flour, 767
- Walrus hide, 767
- Walrus leather, 767
- Wando steel, 500
- Wandoo, 340
- War bronze, 789
- Warnes metal, 382
- Washable wallpaper, 527



- Washing soda, 659  
 Washita oilstone, 511  
 Waste, 225  
 Watch spring alloy, 423  
 Watch spring steel, 679  
 Water, 798  
 Water ash, 64  
 Water buffalo, 355  
 Water-ground mica, 463  
 Water gum, 338  
 Water hickory, 354  
 Water-of-Ayre stone, 511  
 Water paints, 522  
 Water repellants, 767  
 Water softeners, 768  
 Water-soluble cellulose, 154  
 Water tupelo, 338  
 Waterleaf, 531  
 Watermelon seed oil, 703  
 Waterproof paper, 526  
 Watertown Arsenal steel, 358  
 Watsonite, 462  
 Wattle, 151  
 Wattle bark, 151  
 Waukesha metal, 483  
 Wax, 769  
 Wax calf leather, 403  
 Wax palm, 137  
 Wax tailings, 530  
 Waxate, 209  
 Waxy corn, 220  
 Waylite, 203  
 Wear-resistant steel, 770  
 Wearloy, 146  
 Weatherite, 527  
 Webert alloy, 212  
 Weiralead, 720  
 Weircoloy, 213  
 Weirite, 727  
 Weirzin, 311  
 Weisalloy, 34  
 Welchboard, 568  
 Weld, 265  
 Welding fluxes, 301  
 Welding rods, 771  
 Welmet steel, 472  
 Wessell's silver, 494  
 West African cedar, 624  
 West Coast hemlock, 352  
 West Indian ebony, 193  
 West Indian elemi, 267  
 West Indian lemongrass, 406  
 West Indian locust, 718  
 West Virginia spruce, 680  
 Western black willow, 779  
 Western hemlock, 352  
 Western hemlock fir, 352  
 Western larch, 394  
 Western red cedar, 724  
 Western spruce, 680  
 Western tamarack, 394  
 Western white oak, 506  
 Western white pine, 561  
 Western yellow pine, 561  
 Westrosol, 735  
 Wet-strong paper, 526  
 Wetting agents, 772  
 Whale guano, 294  
 Whale liver oil, 774  
 Whale oil, 773  
 Whalebone, 774  
 Wheat, 775  
 Wheat flour, 775  
 Whetstone, 776  
 Whipcord, 757  
 White acid, 273  
 White agate, 16  
 White amber, 45  
 White arsenic, 58  
 White ash, 64  
 White basswood, 76  
 White beech, 82  
 White birch, 93  
 White brass, 776  
 White carbon black, 638  
 White cast iron, 142  
 White cedar, 153, 725  
 White cement, 159  
 White copper, 494  
 White cutch, 311  
 White dammar, 205  
 White deal, 680  
 White dogwood, 252  
 White elm, 267  
 White factice, 765  
 White fir, 680  
 White flux, 301  
 White ginger, 318  
 White glass enamel, 269  
 White gold, 777  
 White gold solder, 777  
 White grease, 395  
 White gum, 622  
 White gunpowder, 341  
 White hickory, 354  
 White lauan, 397  
 White lead, 401  
 White lead putty, 583  
 White mahogany, 390  
 White malva, 384  
 White maple, 451  
 White metals, 777  
 White millet, 465  
 White mineral oil, 544  
 White mustard, 478  
 White nickel alloy, 777  
 White nickel brass, 495  
 White oak, 505  
 White ochre, 508  
 White pepper, 534  
 White phosphor bronze, 552  
 White phosphorus, 553  
 White pine, 560  
 White poplar, 573  
 White quebracho, 589  
 White shellac, 634  
 White silk cotton, 387  
 White siris wood, 766  
 White spirit, 480  
 White spruce, 680  
 White squill, 682  
 White tan, 251  
 White vitriol, 702  
 White whale, 773  
 Whitefish, 455  
 Whiteheart iron, 441  
 Whitening agents, 430  
 Whitewash, 522  
 Whitewood, 228, 737  
 Whiting, 165  
 Whiting putty, 583  
 Widia metal, 740  
 Widura, 215  
 Wigan, 230  
 Wilco alloy No. 6, 204  
 Wilcoloy, 741  
 Wild date, 626  
 Wild limetree, 338  
 Wild silk, 647  
 Wilkinite, 86  
 Willemite, 792  
 Willow, 779  
 Wilmil, 40  
 Wiluite, 313  
 Window glass, 321  
 Wine lees, 57  
 Wine stone, 57  
 Winged elm, 267  
 Winter wheat, 775  
 Wintergreen oil, 675  
 Wiping cloth, 227  
 Wiping solder, 664  
 Wire cloth, 779  
 Wire glass, 780  
 Wire screen cloth, 780  
 Wirebars, 206  
 Wisteria, 537  
 Witch hazel, 258  
 Witherite, 74  
 Wizard steel, 742  
 Wizard Wick, 50  
 Wood, 265  
 Wofatit KS, 769  
 Wofatit P, 769  
 Wolframite, 780  
 Wollaston wire, 781  
 Wollastonite, 467  
 Wonderstone, 585  
 Wonderwood, 295  
 Wood, 781  
 Wood alcohol, 460  
 Wood charcoal, 166  
 Wood ether, 274  
 Wood fiber, 278  
 Wood flour, 783

Wood molasses, 697  
 Wood molding powder, 295  
 Wood oil, 342, 737  
 Wood preservatives, 371  
 Wood pulp, 528  
 Wood resin, 606  
 Wood sugars, 128  
 Wood tar, 715  
 Wood turpentine, 743  
 Wood wool, 278  
 Woodex, 82  
 Wood's alloy, 308  
 Wood's fusible metal, 308  
 Wool, 783  
 Wool grease, 241  
 Wool noils, 785  
 Woolens, 783  
 Woorali, 504  
 Wootz steel, 472  
 Wormseed oil, 785  
 Wormwood oil, 785  
 Worsteds, 783  
 Woven veneer, 568  
 Wrapping paper, 525  
 Writing ink, 368  
 Writing paper, 525  
 Wrought iron, 785  
 Wulfenite, 471  
 Wurtzilite, 317  
 Wurtzite, 791  
 Wyndaloy 720, 444  
 Wyomingite, 574

## X

X-ite, 348  
 X shot, 483  
 Xenon, 481  
 Xylenol, 229  
 Xylol, 715  
 Xylonite, 157  
 Xylol bromide, 719

## Y

Y-alloy, 33  
 Yacca gum, 4  
 Yam, 577  
 Yarmor, 563  
 Yatay palm, 112  
 Yautia, 577  
 Yaya, 394  
 Yellow acaroid, 4  
 Yellow birch, 92  
 Yellow brass, 355  
 Yellow buckeye, 169  
 Yellow casting brass, 105  
 Yellow cedar, 239  
 Yellow copper ore, 209  
 Yellow cross, 570  
 Yellow cutch, 311  
 Yellow cypress, 239  
 Yellow fir, 252  
 Yellow grease, 395

Yellow guayacan, 409  
 Yellow ingot, 105  
 Yellow ingot metal, 105  
 Yellow iron oxide, 508  
 Yellow lake, 558  
 Yellow lauan, 397  
 Yellow metal, 476  
 Yellow ochre, 508  
 Yellow oxide, 748  
 Yellow phosphorus, 554  
 Yellow pine, 560  
 Yellow poplar, 737  
 Yellow sapphire, 626  
 Yellow silver pine, 563  
 Yellow spruce, 680  
 Yerba maté, 717  
 Ylang ylang, 786  
 Yoloy, 213  
 York gum, 340  
 Yorkshire grease, 241  
 Young fustic, 309  
 Yperite, 570  
 Ytterbite, 271  
 Ytterbium, 164  
 Yttrium, 164  
 Yuca, 686  
 Yucatan sisal, 651  
 Yucca, 626  
 Yucca fiber, 786  
 Yucca powder, 626

## Z

Z-metal, 442  
 Z nickel, 482  
 Zakatalsk nuts, 767  
 Zam metal, 790  
 Zamak, 248  
 Zamak 2, 789  
 Zamak 3, 789  
 Zamak 5, 789  
 Zamak alloys, 789  
 Zanzibar copal, 205  
 Zapatero, 101  
 Zapon, 393  
 Zapupe fiber, 651  
 Zdravetz oil, 538  
 Zedoary, 319  
 Zedoary oil, 319  
 Zein, 220  
 Zelactite, 393  
 Zoo-Karb, 768  
 Zeolite, 297  
 Zerex, 53  
 Zerofil, 466  
 Zerone, 53  
 Zilloy, 787  
 Zimocca sponge, 676  
 Zinar, 254  
 Zinc, 787  
 Zinc alloy steel, 311  
 Zinc anodes, 51  
 Zinc-base alloys, 788  
 Zinc bichromate, 791  
 Zinc blende, 791  
 Zinc carbonate, 791  
 Zinc chloride, 790  
 Zinc chromate, 791  
 Zinc-coated steel, 311  
 Zinc dust, 792  
 Zinc ores, 791  
 Zinc orthosilicate, 792  
 Zinc oxide, 793  
 Zinc peroxide, 519, 793  
 Zinc powder, 792  
 Zinc resinate, 254  
 Zinc sheet, 787  
 Zinc silicate, 791  
 Zinc smoke, 655  
 Zinc stearate, 793  
 Zinc sulphate, 702  
 Zinc sulphide, 793  
 Zinc tetroxy chromate, 560  
 Zinc white, 793  
 Zinc wire, 787  
 Zinc yellow, 791  
 Zincgrip, 311  
 Zincite, 792  
 Zincolith, 418  
 Zinnal, 263  
 Zinnwaldite, 675  
 Zircon, 794  
 Zircon crystals, 795  
 Zircon flour, 469  
 Zircon-magnesite cement, 599  
 Zircon porcelain, 373  
 Zircon sand, 469  
 Zirconia, 793  
 Zirconiferous quartz, 729  
 Zirconite, 794  
 Zirconite sand, 469  
 Zirconium, 795  
 Zirconium acetate, 768  
 Zirconium carbide, 795  
 Zirconium-cobalt, 796  
 Zirconium-copper, 795  
 Zirconium-ferrosilicon, 796  
 Zirconium hydride, 796  
 Zirconium-lead alloy, 585  
 Zirconium-nickel, 796  
 Zirconium oxide, 793  
 Zirconium oxychloride, 795  
 Zirconium powder, 796  
 Zirconium sand, 794  
 Zirconium silicate, 794  
 Zirconium steels, 796  
 Zirconium sulphate, 796  
 Zircopax, 514  
 Zircral, 43  
 Zn-Cu-Be alloy, 789  
 Zonolite, 757  
 Zopaque, 730  
 Zorite, 349  
 Zymose, 151







